

Basis	Hard casting resin
Resin	GH 706
Hardener	GLE
Colour	blue
Further colours	grey
Further hardeners	GL

Applications

- Foundry patterns
- Core boxes
- Pattern plates
- Coping models

Properties

- abrasion resistant
- fine structure
- good compressive strength
- very hard
- wear resistant
- well castable
- castable up to 15 mm

Processing data

Product		Mixture GH 706 / GLE	Resin GH 706	Hardener GLE
Colour		blue	blue	amber
Mixing ratio	p. b. w.		100	18
Viscosity at 25°C	mPas	10000 ± 2000	20500 ± 3500	1500 ± 250
Density at 20°C	g / cm ³	2,05 ± 0,05	2,23 ± 0,07	0,98 ± 0,02
Pot life 200 g / 20°C	min.	30 - 40	-	-
Curing time at RT	hrs.	12 - 16	-	-
Post curing	Time in h/ Temperature in °C	-	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	85 ± 8
Flexural modulus	EN ISO 178	MPa	6750 ± 600
Flexural strength at breakage	EN ISO 178	%	2,1 ± 0,3
Compressive strength	EN ISO 604	MPa	86 ± 8
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	9 ± 2
Heat resistance (HDT)	DIN EN ISO 75 B	°C	50 ± 2
Shore hardness	DIN 53505	Shore D	90 ± 3
Coefficient of linear expansion	DIN 53752	10 ⁻⁶ K ⁻¹	-
Linear shrinkage	internal	%	ca. 0,11
Abrasion Taber Abraser CS 10 Application weight 1000g / 250 Rotations	internal	mg	23

Sales units (packages)

Packing size	B-Pack	GH 706 / GLE	Resin 6 x 1,250 kg / Hardener 6 x 0,225 kg = 8,850 kg
Units	Resin	GH 706	8,000 kg / 25,000 kg
	Hardener	GLE	5,000 kg

Processing instructions

The temperature of material and processing should be between 18 and 25° C.

Filled systems should be stirred thoroughly before use.

After each use the containers have to be closed again.

Porous mould surfaces should be sealed before (**ebalta** sealant).

For an optimum mould release we recommend a suitable release agent (e.g. T 1-1) which can be easily applied with a brush.

The mould should be treated 2 or 3 times with release agent and allowed to evaporate for approx. 20 min after every application.

Mixing ratio resin/hardener according to instructions!

To get a clean component part, we recommend upward flow casting and to take care of sufficient venting.

Resin residues at stirring rods and so on can be easily cleaned with our cleaning agent.

In General

ebalta GH 706/GLE is a well castable two-components epoxy resin, which cures at room temperature and can be casted till 20 mm thickness.

The resin GH 706 contains very fine hard fillers and with hardener GLE it has got a very hard, wear resistant surface with high compression strength and impact resistance.

With the slower GL hardener thicknesses of 40-50 mm can be casted.

Mixing ratio: GH 706/GL: 100:10

ebalta GH 706 is the castable version of the very hard gelcoat OH 6-1.

Storing

Storage at room temperature (18-25 °C) in closed original container 9 months.

Already opened containers should be closed immediately after use and should be used as soon as possible.

Safety measure

Please follow the precaution instructions of the Government Safety Organisation of the chemical industry when working with this material. Please follow safety advices !

Waste Disposal

According to arrangement with local authorities cured material can be disposed as domestic or commercial waste.

Non-cured products are waste which is subject to inspection and has to be disposed accordingly.

In case of further questions please do not hesitate to contact our Department for Product Safety.

The instructions and recommendations are given in good faith and are based on long experience and careful tests. Since the conditions of use are beyond our control, and due to versatility of applications and working methods, we can't give any guarantee. All information are non-binding and are no guarantee for special characteristics or properties of the product. Despite information given from **ebalta** the customer has to make his own tests regarding applications and processing. If any special warranty is requested, written agreement on this subject is essential.

ebalta Kunststoff GmbH . Erlbacher Straße 100 . 91541 Rothenburg ob der Tauber / Germany
Tel.: +49 9861 7007-0 . Fax: +49 9861 7007-77 . info@ebalta.de . www.ebalta.de