GM 708 / PUR 4

ebalta

Basis	**slow curing PU-casting system**
Resin	**GM 708 Comp. A**
Hardener	**PUR 4 Comp. B**
Colour	brown

Applications

- Sheet metal forming
- Foundry pattern
- Negatives
- Jigs

Properties

- unfilled
- slow curing

Processing data

Product		Mixture GM 708 / PUR 4	Resin GM 708 Comp. A	Hardener PUR 4 Comp. B
Colour		brown	beige	brown
Mixing ratio	p. b. w.		**100**	**75**
Viscosity at 25°C	mPas	500 ± 100	1300 ± 200	90 ± 20
Density at 20°C	g / cm^3	1,2 ± 0,03	1,18 ± 0,02	1,22 ± 0,02
Pot life 200 g / 20°C	min.	45 - 60	-	-
Curing time at RT	hrs.	16 - 24	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	110 ± 10
Flexural modulus	EN ISO 178	MPa	2250 ± 250
Flexural strength at breakage	EN ISO 178	%	7,4 ± 0,4
Tensile strength	EN ISO 527	MPa	50 ± 5
Elongation	EN ISO 527	%	10 ± 3
Compressive strength	EN ISO 604	MPa	80 ± 8
Impact resistance (Charpy)	EN ISO 179	kJ/m^2	58 ± 8
Heat resistance (HDT)	DIN EN ISO 75 B	°C	76 ± 3
TG in TMA T_G	Methode TMA	°C	-
Shore hardness	DIN 53505	Shore D	82 ± 3
Coefficient of linear expansion	DIN 53752	$10^{-6}K^{-1}$	-
Linear shrinkage	internal	%	-

Sales units (packages)

Units	Comp. A	GM 708 Comp. A	8,000 kg / 16,000 kg / 50,000 kg
	Hardener	PUR 4 Comp. B	1,000 kg / 1,500 kg / 3,000 kg / 6,000 kg

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Processing instructions

Material- and processing temperature: between 18 - 25 °C.
Close containers after use.
Seal porous mould surfaces first (**ebalta** mould sealer).
For optimum mould releasing we recommend a special release agent (like T1-1), which can
be applied easily with a brush or be sprayed. Releasing of the mould 2-3 times, evaporate
for about 20 min. after each releasing.

Mixing ratio resin/hardener according to instructions.

Stirring rods etc. with residual resin can be easily cleaned with **ebalta** cleaning agent.

In General

GM 708 is a high-quality, almost odourless 2-components-polyurethane casting compound
without any filler. The filler will only be added when mixing both components. The long potlife
of more than 45 min makes it possible to cast big-volume parts. Depending on the application,
different dry fillers can be used. To get optimum properties, especially low shrinkage, we
recommend a high filler content.
Properties and filler content of each filler: see our separate mixing table.

Storing

At appropriate storage (18 - 25 °C) in closed original container 6 months.
Already opened containers should be closed immediately after use and be protected against moisture. This material should be
used up 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.

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