

Basis **Very flexible casting resin**  
 Resin **GM 900 Comp. A**  
 Hardener **GM 900 Comp. B**

Colour black  
 Further colours beige

### Applications

- Casting mould for gypsum
- Casting mould for plastic
- Casting mould for wax
- Casting mould for ceramic materials

### Properties

- shore A hardness 10
- highly flexible
- good tear propagation resistance

### Processing data

Product		Mixture GM 900 / Comp. A+B	Resin GM 900 Comp. A	Hardener GM 900 Comp. B
Colour		black	black	transparent
<b>Mixing ratio</b>	<b>p. b. w.</b>		<b>100</b>	<b>10</b>
Viscosity at 25°C	mPas	1200 ± 200	1500 ± 500	40 ± 10
Density at 20°C	g / cm <sup>3</sup>	1,2 ± 0,03	1,19 ± 0,03	0,962 ± 0,03
Pot life 200 g / 20°C	min.	50 - 60	-	-
Curing time at RT	hrs.	16 - 24	-	-

### Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	-
Flexural modulus	EN ISO 178	MPa	-
Flexural strength at breakage	EN ISO 178	%	-
Tensile strength	EN ISO 527	MPa	2,8 ± 0,5
Elongation	EN ISO 527	%	300 ± 30
Compressive strength	EN ISO 604	MPa	-
Impact resistance (Charpy)	EN ISO 179	kJ/m <sup>2</sup>	-
Heat resistance (Martens)	DIN 53458	°C	-
TG in TMA T <sub>g</sub>	Methode TMA	°C	n. a.
Shore hardness	DIN 53505	Shore A	10 ± 2
Coefficient of linear expansion	DIN 53752	10 <sup>-6</sup> K <sup>-1</sup>	-
Linear shrinkage	internal	%	-
Tear resistance / angle test piece	EN ISO 34-1	kN/m	4,8 ± 0,5

### Sales units (packages)

Packing size	B- Pack	GM 900 / Comp. A+B	Resin 6 x 0,800 kg / Hardener 6 x 0,080 kg = 5,280 kg
Units	Resin	GM 900 Comp. A	15,000 kg
	Hardener	GM 900 Comp. B	1,500 kg

## Processing instructions

Material- and working- 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

Both components can be easily mixed free from air bubbles in small quantities by hand with a round stirring rod or in larger quantities with a spiral stirrer.

## In General

The product is a very soft-elastic polyurethane casting compound.

**ebalta** GM 900 is suitable as a flexible casting system in the field of mould- and tooling for parts which require low shore hardness and high tear propagation resistance due to deep under cuts. Mould temperatures of about 60 °C lead to faster curing and therefore short demoulding time.

Reactive casting resins must not be cast into elastic casting compound moulds, before complete curing of GM 951 (2-3 days).

For individual formulation of the shore hardness, GM 951 can be mixed with GM 900 (see mixing table).

Parts/moulds must not be cast with addition curing silicone, since this might lead to faulty reactions when curing the silicone.

## Storing

Storage at room temperature (18 – 25°C) in closed original container 6 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.

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