

Basis	Dimensionally accurate, very wear resistant casting resin
Resin	GM 714 Komp. A
Hardener	PUR 4 Comp. B
Colour	grey

Applications

- Foundry patterns
- Pattern plates
- Moulding tools

Properties

- very thick castable
- wear resistant
- dimensionally accurate
- abrasion resistant
- multi purpose useable

Processing data

Product		Mixture GM 714 / PUR 4	Resin GM 714 Komp. A	Hardener PUR 4 Comp. B
Colour		grey	light grey	brown
Mixing ratio	p. b. w.		100	15
Viscosity at 25°C	mPas	5500 - 500	-	90 ± 20
Density at 20°C	g / cm ³	2,1 ± 0,05	2,30 ± 0,05	1,22 ± 0,02
Pot life 200 g / 20°C	min.	40 - 45	-	-
Curing time at RT	hrs.	12 - 18	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	60 ± 5
Flexural elongation at break	EN ISO 178	%	2,00 ± 0,30
Flexural modulus	EN ISO 178	MPa	6250 ± 170
Tensile strength	EN ISO 527-1	MPa	-
Tensile strength / test piece type 2	ISO 37	MPa	-
Tensile modulus	EN ISO 527-1	MPa	-
Elongation	EN ISO 527-1	%	-
Elongation at break / test piece type 2	ISO 37	%	-
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	5,3 ± 0,6
Compressive strength	EN ISO 604	MPa	63 ± 5
TG in TMA T _G	Methode TMA	°C	-
Shore hardness	DIN ISO 7619-1	Shore D	88 ± 3
coefficient of thermal expansion	internal test / Dilatometer	10 ⁻⁶ K ⁻¹	-
Linear shrinkage	internal	%	-
Tear resistance arch shaped test piece with incision 1 mm	DIN ISO 34-1	kN/m	-
Tear resistance arch shaped test piece without incision	DIN ISO 34-1	kN/m	-
Abrasion Taber Abraser CS 17 Application weight 1000g / 500 Rotations	internal	mg	41

Sales units (packages)

Units	Resin	GM 714 Komp. A	20,000 kg
	Hardener	PUR 4 Comp. B	1,000 kg / 6,000 kg

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

ebalta GM 714 is a slow-curing versatile 2-components polyurethane casting compound.

It's wear resistant, shows low shrinkage and for this reason it's very suitable for sheet metal forming moulds and big volume moulds for solid casting.

Storing

Storage at room temperature 18-25 °C.

Opened containers should be closed immediately after use and should be used up as soon as possible.

Shelf life is indicated on the labels.

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.