

Basis	Wear resistant, well moldable casting resin
Resin	GM 979 Comp. A
Hardener	PUR 1 Comp. B
Colour	green

Applications

- Pattern plates
- Foundry patterns
- Core boxes
- Negatives

Properties

- wear resistant
- good compressive strength
- impact resistant
- heat resistant
- excellent demoulding from mould and core sand properties

Processing data

Product		Mixture GM 979 / PUR 1	Resin GM 979 Comp. A	Hardener PUR 1 Comp. B
Colour		green	green	brown
Mixing ratio	p. b. w.		100	25
Viscosity at 25°C	mPas	4500 ± 800	15000 ± 3000	100 ± 30
Density at 20°C	g / cm ³	1,65 ± 0,05	1,73 ± 0,05	1,24 ± 0,02
Pot life 200 g / 20°C	min.	25 - 35	-	-
Curing time at RT	hrs.	8 - 12	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	68 ± 5
Flexural elongation at break	EN ISO 178	%	1,20 ± 0,1
Flexural modulus	EN ISO 178	MPa	6700 ± 500
Tensile strength	EN ISO 527-1	MPa	-
Elongation	EN ISO 527-1	%	-
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	5,5 ± 0,5
Compressive strength	EN ISO 604	MPa	85 ± 5
Heat resistance (HDT)	DIN EN ISO 75 B	°C	80 ± 3
Shore hardness	DIN ISO 7619-1	Shore D	90 ± 3
Linear shrinkage	internal	%	-
Abrasion Taber Abraser H 18 Application weight 500g / 250 Rotations	internal	mg	ca. 125

Sales units (packages)

Packing size	B-Pack	GM 979 / PUR 1	resin 6 x 0,960 kg / hardener 6 x 0,240 kg = 7,200 kg
Units	Comp. A	GM 979 Comp. A	25 kg
	Comp. B	PUR 1 Comp. B	6 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 ebaclean.

In General

ebalta GM 979 is an easy-to-handle-2components-polyurethane casting compound which shows very low adhesive properties compared to moulding sand. Due to its high abrasion resistance, GM 979 is especially suitable for foundry patterns, which have to resist to abrasive wear by moulded sand. GM 979 even keeps its high mechanical strength when using moulding sands with higher temperatures.

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.