

Basis	PU castin resin
Resin	GM 987 Comp. A (ISO)
Hardener	GM 987 Comp. B (AMIN)
Colour	orange-opaque

Applications

- Foundry patterns
- Pattern plates
- fixtures
- Core boxes

Properties

- excellent abrasion resistance
- hard flexible
- no brittleness phase
- well castable
- Shore D hardness approx. 65

Processing data

Product		Mixture GM 987 / Comp. A+B	Resin GM 987 Comp. A (ISO)	Hardener GM 987 Comp. B (AMIN)
Colour		orange-opaque	orange-transparent	white-opaque
Mixing ratio	p. b. w.		100	21
Viscosity at 25°C	mPas	7700 ± 300	6400 ± 400	500 ± 50
Density at 20°C	g / cm ³	1,14 ± 0,02	1,09 ± 0,02	1,22 ± 0,02
Pot life 200 g / 20°C	min.	14 - 17	-	-
Curing time at RT	hrs.	16 - 18	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	18 ± 0,3
Flexural elongation at flexural strength	EN ISO 178	%	8,6 ± 0,2
Flexural modulus	EN ISO 178	MPa	470 ± 25
Tensile strength	EN ISO 527-1	MPa	29 ± 3
Elongation of tensile strength	EN ISO 527-1	%	260 ± 40
Shore hardness	DIN ISO 7619-1	Shore D	65 ± 2
Wear jet test	internal tests	W(V/t) [mm ³ /min]	ca. 15

Sales units (packages)

Units	Comp. A	GM 987 Comp. A (ISO)	4,000 kg
	Comp. B	GM 987 Comp. B (AMIN)	0,840 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.

Important processing instructions:

B comp. (amine) must be stirred in and carefully mixed into A comp. (isocyanate). The material must be free of streaks.

Before use you have to stir up / shake the thinline comp. B.

In General

GM 987 Comp. B (Amine) can be subject to colour variations due to raw materials, but these colour variations have no influence on the quality and the properties of the product.

The postcured material is not UV stable and darkens by and by. However according to our experience the change in colour does not affect its utilizability.

The mechanical properties will be reached after 7 d at room temperature or post curing of 8 h at 80°C.

For priming the ancillary product **GM 987 thix Comp. B is applied.**

Mixing Ratio

100 Gwtl. GM 987 Comp. A

10,5 Gwtl. GM 987 Comp. B

10,5 Gwtl. GM 987 thix Comp. B

As bonding agent on aluminium support we recommend our PU coupling paste KP 8.

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.