

Basis	Casting resin with surface slip characteristics
Resin	GH 760
Hardener	GL
Colour	grey

Applications

- Foundry patterns
- Core boxes
- Boards
- Control castings
- jig
- Hammer form tools
- Stretch forming tool
- Stretch tools

Properties

- dimensionally accurate
- abrasion resistant
- high strength
- castable until 40 mm
- very good sliding properties

Processing data

Product		Mixture GH 760 / GL	Resin GH 760	Hardener GL
Colour		grey	grey	yellow
Mixing ratio	p. b. w.		100	10
Viscosity at 25°C	mPas	9500 ± 1000	20000 ± 3500	750 ± 150
Density at 20°C	g / cm ³	2,20 ± 0,05	2,70 ± 0,05	1,00 ± 0,02
Pot life 200 g / 20°C	min.	45 - 55	-	-
Curing time at RT	hrs.	18 - 24	-	-
Post curing	Time in h/ Temperature in °C	-	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	100 ± 10
Flexural elongation at break	EN ISO 178	%	1,50 ± 0,2
Flexural modulus	EN ISO 178	MPa	7250 ± 500
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	9 ± 1,5
Compressive strength	EN ISO 604	MPa	120 ± 10
Heat resistance (HDT)	DIN EN ISO 75 B	°C	63 ± 2
Glass transition temperature TG	TMA	°C	-
Shore hardness	DIN ISO 7619-1	Shore D	89 ± 3
coefficient of linear expansion 20 - 50 °C	internatl test / Dilatometer	10 ⁻⁶ K ⁻¹	ca. 59
Dielectric strength E _D	DIN 53481	KV/mm	-
Linear shrinkage	internal	%	0,1
Wear jet test	internal tests	W(V/t) [mm ³ /min]	ca. 257
Abrasion Taber Abraser CS 17 Application weight 500g / 500 Rotations	internal	mg	ca. 20

Sales units (packages)

Packing size	B-Pack	GH 760 / GL	Resin 6 x 1,500 kg / Hardener 6 x 0,150 kg = 9,900 kg
Units	Resin	GH 760	8,000 kg / 25,000 kg
	Hardener	GL	1,5000 kg / 5,000 kg

Processing instructions

The temperature of material and processing should be between 18 and 25° C.

Filled systems should be stirred thoroughly before use.

After each use the containers have to be closed again.

Porous mould surfaces should be sealed before (**ebalta** sealant).

For an optimum mould release we recommend a suitable release agent (e.g. T 1-1) which can be easily applied with a brush.

The mould should be treated 2 or 3 times with release agent and allowed to evaporate for approx. 20 min after every application.

Mixing ratio resin/hardener according to instructions!

To get a clean component part, we recommend upward flow casting and to take care of sufficient venting.

Resin residues at stirring rods and so on can be easily cleaned with our ebaclean.

In General

ebalta GH 760/GL is a two-components epoxy resin, curing at room temperature, castable to 40 mm in open casting.

The fine non-grinding fillers lead to good surface slip properties and mechanical workability.

For this reason **ebalta** GH 760/GL is especially suitable for metal sheet tools as well as for foundry equipment.

Due to its high strength and excellent dimensional accuracy this system is quite versatile.

Storing

Storage at room temperature (18-25 °C) in closed original container 9 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.