

Basis	<b>slow curing PU-casting system</b>
Resin	<b>GM 708 Comp. A</b>
Hardener	<b>PUR 4 Comp. B</b>
Colour	brown

### Applications

- Sheet metal forming
- Foundry pattern
- Negatives
- fixtures

### Properties

- unfilled
- slow curing

### Processing data

Product		Mixture GM 708 / PUR 4	Resin GM 708 Comp. A	Hardener PUR 4 Comp. B
Colour		brown	beige	brown
<b>Mixing ratio</b>	<b>p. b. w.</b>		<b>100</b>	<b>75</b>
Viscosity at 25°C	mPas	500 ± 100	1300 ± 200	90 ± 2
Density at 20°C	g / cm <sup>3</sup>	1,2 ± 0,03	1,18 ± 0,02	1,22 ± 0,02
Pot life 200 g / 20°C	min.	45 - 60	-	-
Curing time at RT	hrs.	16 - 24	-	-

### Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	110 ± 10
Flexural elongation at break	EN ISO 178	%	7,4 ± 0,4
Flexural modulus	EN ISO 178	MPa	2250 ± 250
Tensile strength	EN ISO 527-1	MPa	50 ± 5
Tensile strength / test piece type 2	ISO 37	MPa	-
Tensile modulus	EN ISO 527-1	MPa	-
Elongation	EN ISO 527-1	%	10 ± 3
Elongation at break / test piece type 2	ISO 37	%	-
Impact resistance (Charpy)	EN ISO 179	kJ/m <sup>2</sup>	58 ± 8
Compressive strength	EN ISO 604	MPa	80 ± 8
Heat resistance (HDT)	DIN EN ISO 75 B	°C	76 ± 3
TG in TMA T <sub>g</sub>	Methode TMA	°C	-
Shore hardness	DIN ISO 7619-1	Shore D	82 ± 3
coefficient of linear expansion 20 - 50 °C	internatl test / Dilatometer	10 <sup>-6</sup> K <sup>-1</sup>	ca. 108
Linear shrinkage	internal	%	-
Wear jet test	internal tests	W(V/t) [mm <sup>3</sup> /min]	ca. 138

### Sales units (packages)

Units	Comp. A	GM 708 Comp. A	8,000 kg / 16,000 kg / 50,000 kg
	Comp. B	PUR 4 Comp. B	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 ebaclean.

## In General

GM 708 is a high-quality, almost odourless 2-components-polyurethane casting compound without any filler. The filler will only be added when mixing both components. The long potlife of more than 45 min makes it possible to cast big-volume parts. Depending on the application, different dry fillers can be used. To get optimum properties, especially low shrinkage, we recommend a high filler content.

Properties and filler content of each filler: see our separate mixing table.

## 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.