

Basis	Wear resistant, well moldable casting resin
Resin	GM 727 Comp. A
Hardener	GM 727 Comp. B
Colour	beige

Applications

- fixtures
- Pattern plates
- Foundry patterns
- Control castings
- Negatives

Properties

- workable
- thick castable
- dimensionally accurate
- heat resistant

Processing data

Product		Mixture GM 727 / Comp. A+B	Resin GM 727 Comp. A	Hardener GM 727 Comp. B
Colour		beige	white	brown
Mixing ratio	p. b. w.		100	22
Viscosity at 25°C	mPas	6000 ± 800	30000 ± 4500	100 ± 30
Density at 20°C	g / cm ³	1,70 ± 0,05	1,81 ± 0,05	1,23 ± 0,02
Pot life 200 g / 20°C	min.	25 - 35	-	-
Curing time at RT	hrs.	12 - 16	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	75 ± 5
Flexural elongation at break	EN ISO 178	%	1,05 ± 0,05
Flexural modulus	EN ISO 178	MPa	8250 ± 500
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	5,5 ± 0,5
Compressive strength	EN ISO 604	MPa	100 ± 10
Heat resistance (HDT)	DIN EN ISO 75 B	°C	76 ± 3 (after post curing 8 h / 80°C)
Shore hardness	DIN ISO 7619-1	Shore D	90 ± 3
coefficient of linear expansion 20 - 60 °C	intern test methode	10 ⁻⁶ K ⁻¹	ca. 43
Linear shrinkage	internal	%	ca. 0,1
Wear jet test	internal tests	W(V/t) [mm ³ /min]	ca. 210

Sales units (packages)

Units	Comp. A	GM 727 Comp. A	5,000 kg / 15,000 kg / 30,000 kg
	Comp. B	GM 727 Comp. B	1,100 kg / 3,300 kg / 6,600 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.

Follow mixing ratio of resin and hardener according to instructions. For bubble-free mixing we recommend a star-shaped mixing rod.

Stirring rods etc. with residual resin can be easily cleaned with ebaclean.

In General

ebalta GM 727 is a well castable two components polyurethane casting resin, curing slowly at room temperature.

This casting resin is particularly suitable for solid casting of dimensionally accurate large-volume models with high temperature resistance.

Due to low mixing viscosity of GM 727 you can add 70% filler F-B and about 50% plastic granules to reduce shrinkage to approx. 0.05%.

For reduction of shrinkage to approx. 0.05% and due to low mixing viscosity for large volume parts we recommend to add up to approx. 70% filler F-B or approx. 50% plastic granules to GM 727.

For application of additional filler we recommend our spiral mixing rod.

As air bubbles cannot be avoided when adding filler, we recommend to prepare the model surface with a gel coat like OH 49 or OH 4.

Temperature resistance HDT according to DIN EN ISO 75 B after 7 days at room temperature: about 46°C

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.