

Basis	<b>flexible casting resin</b>
Resin	<b>GM 956 Comp. A (Isocyanate)</b>
Hardener	<b>GM 956-30 Comp. B (Polyole)</b>
Colour	transparent

### Applications

- Prototypes with rubber-like properties
- Flexible parts

### Properties

- shore A hardness about 30
- shore hardness (flexibility) variable till A 83
- excellent flow properties
- transparent
- easily dyeable
- odourless
- free of mercury
- high tear strength
- RoHS conform

### Processing data

Product		Mixture GM 956 / GM 956-30	Resin GM 956 Comp. A (Isocyanate)	Hardener GM 956-30 Comp. B (Polyole)
Colour		transparent	transparent	amber-transparent
<b>Mixing ratio</b>	<b>p. b. w.</b>		<b>100</b>	<b>205</b>
Viscosity at 25°C	mPas	1500 ± 200	5000 ± 1000	580 ± 80
Density at 20°C	g / cm <sup>3</sup>	1,04 ± 0,02	1,06 ± 0,02	1,00 ± 0,02
Pot life 200 g / 20°C	min.	20 - 30	-	-
Curing time at 70° C	h	3	-	-

### Physical data

Properties	Inspect. requirem.	Unit	Value
Tensile strength / test piece type 2	ISO 37	MPa	2,2 ± 0,2
Elongation at break / test piece type 2	ISO 37	%	2000 ± 500
Shore hardness	DIN ISO 7619-1	Shore A	30 ± 2
Tear resistance arch shaped test piece with incision 1 mm	DIN ISO 34-1	kN/m	6,7 ± 0,5

### Sales units (packages)

Units	Comp. A	GM 956 Comp. A (Isocyanate)	1,000 kg / 5,000 kg
	Comp. B	GM 956-30 Comp. B (Polyole)	2,050 kg / 10,250 kg

## Processing instructions

Material- and processing temperature between 18°C and 25°C.  
Mixing ratio resin and hardener according instructions.

When using pigment paste, it needs to stir it in Comp.B.

To reach shore hardness A 65 mix GM 956 Comp. A, GM 956-30 Comp. B and GM 956-80 Comp. B as follows:

GM 956 Comp. A (100 weight contents) + GM 956 -30 Comp. B (100 weight contents) + GM 956-80 Comp. B (40 weight contents)

First step is the mixture of the B-components, second step: stir B components in Comp. A.

For vacuum casting parts the mould temperature should be 70°C.

Both components can be easily mixed free from air bubbles in small quantities by hand with a stirring rod or in larger quantities with a spiral stirrer. The processing in a vacuum is also possible.  
Stirring rods etc. with residual resin can be easily cleaned with ebaclean.

To accelerate use our Accelerator 08.

## In General

This product is a polyurethane system.

After use please close the containers carefully.

The product 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.

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.

## 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: see 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.