

Ebalta GM 725-7 / PUR 13

Polyurethane
Ebalta Kunststoff GmbH

Message:

ebalta GM 725-7 is a well castable 2-components, polyurethane casting compound, which cures slowly at room temperature. It's especially suitable for solid casting of very dimensional accurate big volume moulds. The thin liquid hardener PUR 13 leads to slow mixing viscosity. Therefore a supplementary addition of 50 % filler F-B /3 or 75 % filler F-iron is possible. Shrinkage is reduced to 0,05 %. Alternatively plastic granules can be added (more than 50 %). In this case we recommend primer application of gelcoat OH 11 new or OH 48.

- Applications
- Foundry patterns
 - Negatives
 - Pattern plates
 - Control castings
 - fixtures
 - Sheet metal forming
- Properties
- thick castable
 - dimensionally accurate
 - excellent flow properties
 - well workable
 - long potlife
 - high strength

General Information			
Features	High strength		
	Good liquidity		
Appearance	Beige		
Processing Method	Casting		
Physical	Nominal Value	Unit	Test Method
Molding Shrinkage	0.10	%	Internal method
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	84 - 90		ISO 7619
Mechanical	Nominal Value	Unit	Test Method
Flexural Modulus	7230 - 8830	MPa	ISO 178
Flexural Stress	51.0 - 61.0	MPa	ISO 178
Compressive Stress	68.0 - 84.0	MPa	ISO 604
Impact	Nominal Value	Unit	Test Method
Charpy Unnotched Impact Strength	3.1 - 4.1	kJ/m²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (0.45 MPa, Unannealed)	49.0 - 53.0	°C	ISO 75-2/B
CLTE - Flow (20 to 50°C)	6.5E-5	cm/cm/°C	DIN 53752
Thermoset	Nominal Value	Unit	
Thermoset Components			
Resin	Mixing ratio by weight: 100		

Hardening method	Mixing ratio by weight: 15	
Additional Information		
Wear jet test : 182 W(V/t) [mm³/min] (internal tests)		
Uncured Properties	Nominal Value	Unit
Density (20°C)	1.70 - 1.80	g/cm³
Viscosity (25°C)	5.5 - 6.5	Pa·s
Curing Time (20°C)	12 - 16	hr
Pot Life ¹ (20°C)	40 - 50	min
NOTE		
1.	200 g	

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