

Basis **very hard elastic, high abrasion resistant PU resin**  
 Resin **VP GM 995 Comp. A**  
 Hardener **VP GM 995 Comp. B**

Colour beige  
 Further colours transparent

### Applications

- Core boxes
- Foundry patterns
- Pattern plates
- Jigs

### Properties

- very abrasion resistant
- hard elastomeric
- very well castable
- nontoxic

### Processing data

Product		Mixture VP GM 995 / Comp. A+B	Resin VP GM 995 Comp. A	Hardener VP GM 995 Comp. B
Colour		beige	transparent	beige
<b>Mixing ratio</b>	<b>p. b. w.</b>		<b>100</b>	<b>52</b>
Viscosity at 25°C	mPas	2200 ± 400	4250 ± 600	400 ± 80
Density at 20°C	g / cm <sup>3</sup>	1,10 ± 0,02	1,10 ± 0,03	1,10 ± 0,03
Pot life 200 g / 20°C	min.	12 - 16	-	-
Curing time at RT	hrs.	8 - 10	-	-

### Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	-
Flexural modulus	EN ISO 178	MPa	-
Flexural strength at breakage	EN ISO 178	%	
Tensile strength	EN ISO 527	MPa	30 ± 3
Tensile modulus	EN ISO 527	MPa	170 ± 15
Elongation	EN ISO 527	%	365 ± 90
Compressive strength	EN ISO 604	MPa	-
Impact resistance (Charpy)	EN ISO 179	kJ/m <sup>2</sup>	-
Heat resistance (HDT)	DIN EN ISO 75 B	°C	-
TG in TMA T <sub>G</sub>	Methode TMA	°C	-
Shore hardness	DIN 53505	Shore D	65 ± 3
Coefficient of linear expansion	DIN 53752	10 <sup>-6</sup> K <sup>-1</sup>	-
Linear shrinkage	internal	%	-
Tear resistance / angle test piece	EN ISO 34-1	kN/m	-
Abrasion Taber Abraser H 18 Application weight 500g / 500 Rotations	internal	mg	ca. 18

### Sales units (packages)

Units                      Comp. A              VP GM 995 Comp. A              5 kg  
                                   Comp. B              VP GM 995 Comp. B              2,6 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.

Both components can be easily mixed free from air bubbles in small quantities by hand with a round 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 **ebalta** cleaning agent

## In General

This product is a Polyurethane system

"VP"-products are experimental products.

Regarding technical data slight modifications are possible.

VP GM 995 can be cast on a metal carrier or epoxy resin core plate by surface layer processing.

We recommend a layer of 6 - 8 mm.

Depending on cast thickness demoulding after 6-8 hrs. Moulds have to be completely dry and waxed. Porous materials require sealing.

Final shore hardness after 2 - 3 days at room temperature.

Comp. A is affected by moisture.

Due to raw materials comp. B might be subject to colour variations which however don't affect the quality and characteristics of the product.

We recommend to use up open containers a.s.a.p.

## Storing

Storage at room temperature (18 – 25°C) in closed original container 6 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.

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