

Basis **Abrasion resistant and compressive casting resin**
 Resin **Casting resin for M 04 Comp. A**
 Hardener **Casting resin for M 04 Comp. B**

Colour yellow
 Further colours black

Applications

- Changes of eblock M 04
- Repairing for eblock M 04

Properties

- abrasion resistant
- good compressive strength
- well castable

Processing data

Product		Mixture Casting resin M 04	Resin Casting resin for M 04 Comp. A	Hardener Casting resin for M 04 Comp. B
Colour		yellow	yellow	brown
Mixing ratio	p. b. w.		100	30
Viscosity at 25°C	mPas	4000 ± 500	13500 ± 2500	100 ± 30
Density at 20°C	g / cm ³	1,60 ± 0,05	1,70 ± 0,05	1,24 ± 0,02
Pot life 200 g / 20°C	min.	18 - 22	-	-
Curing time at RT	hrs.	4 - 10	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	68 ± 5
Flexural modulus	EN ISO 178	MPa	5275 ± 250
Flexural strength at breakage	EN ISO 178	%	1,6 ± 0,2
Tensile strength	EN ISO 527	MPa	-
Elongation	EN ISO 527	%	-
Compressive strength	EN ISO 604	MPa	81 ± 5
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	7,6 ± 1
Heat resistance (Martens)	DIN 53458	°C	51 ± 2
TG in TMA T _G	Methode TMA	°C	-
Shore hardness	DIN 53505	Shore D	88 ± 3
Coefficient of linear expansion	DIN 53752	10 ⁻⁶ K ⁻¹	-
Linear shrinkage	internal	%	-

Sales units (packages)

Units	Comp. A	Casting resin for M 04 Comp. A	0,800 kg
	Comp. B	Casting resin for M 04 Comp. B	0,240 kg

Processing instructions

Material- and working- 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 **ebalta** cleaning agent.

In General

The product is a Polyurethane system.

The casting resin can be accelerated on request.

Storing

At room temperature (18 – 25°C) and closed original containers storage life is 6 months.

Partly used containers have always to be closed and the material has to be used up 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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