

Basis	Prototype casting material
Resin	MG 423 Comp. A
Hardener	PUR 19 Comp. B
Colour	black

Applications

- Funktional parts automotive field
- Funktional parts EPD field
- Prototyping parts EPD field
- Prototypes automotive field
- Cladding parts automotive field
- Cladding parts EPD field

Properties

- high impact strength
- high heat resistance
- excellent flow properties

Processing data

Product		Mixture MG 423 / PUR 19	Resin MG 423 Comp. A	Hardener PUR 19 Comp. B
Colour		black	black	brown
Mixing ratio	p. b. w.		100	100
	volume		100	84
Viscosity at 25°C	mPas	1200 ± 200	3000 ± 100	475 ± 100
Density at 20°C	g / cm ³	1,15 ± 0,02	1,03 ± 0,02	1,22 ± 0,02
Pot life at 20°C	seconds	55 - 70	-	-
Curing time at RT	min.	30 - 40	-	-
Post curing	Time in h/ Temperature in °C	6 / 80	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	83 ± 8
Flexural modulus	EN ISO 178	MPa	1980 ± 200
Flexural strength at breakage	EN ISO 178	%	7,1 ± 0,3
Tensile strength	EN ISO 527	MPa	-
Compressive strength	EN ISO 604	MPa	-
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	53 ± 8
Glass transition temperature TG	methode DSC	°C	ca. 87
Shore hardness	DIN 53505	Shore D	82 ± 2

Sales units (packages)

Units	Comp. A	MG 423 Comp. A	5,000 kg / 20,000 kg
	Comp. B	PUR 19 Comp. B	5,000 kg / 20,000 kg

Processing instructions

It is essential to stir component A before use, as the additives tend to sedimentation. Component B has not to be stirred.

The moulding tools should be made of a polyurethane- resp. epoxy resin system, with a high-quality surface.

In order to improve the surface appearance of the component, it is possible:

- to preheat the material to 30 °C
- to preheat the moulds to 40 - 50 °C

A combination of preheated material and moulds is the optimum.

The wall thicknesses of the components are approx. 3 - 10 mm. Ribs or bigger material accumulations can also be produced.

The shrinkage is 0,45%. But the shrinkage can be slightly influenced by the geometry of the respective component.

The components can be demoulded after approx. 30-40 minutes. This can differ accordingly to wall thickness and temperature.

The postcuring has to be made by means of a supporting structure.

In General

ebalta MG 423 is processed on a two-component low pressure device.

After grinding with a sand paper , grit 280, the surface can be varnished with a commercial lacquer. For better adhesion we recommend the use of a primer coat. Nitrocellulose lacquers have a better adhesion on polyurethane surfaces than on acrylic-lacquer-systems.

Release agent – please see category release agent

Storing

In temperierten Räumen (18 – 25°C) und ungeöffneten Originalgebinden beträgt die Lagerfähigkeit 6 Monate.

Angebrochene Gebinde sind stets zu verschließen und baldmöglichst zu verarbeiten.

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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