

Basis	<b>glass fiber reinforced polyurethane resin</b>
Resin	<b>MG 425 GF Comp. A</b>
Hardener	<b>PUR 19 Comp. B</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

- good impact strength
- high rigidity
- mechanical processable

### Processing data

Product		Mixture MG 425 GF / PUR 19	Resin MG 425 GF Comp. A	Hardener PUR 19 Comp. B
Colour		black	black	brown
Mixing ratio	p. b. w.		<b>100</b>	<b>70</b>
	volume		100	69
Viscosity at 25°C	mPas	1800 ± 300	2800 ± 500	475 ± 100
Density at 20°C	g / cm <sup>3</sup>	1,2 ± 0,02	1,20 ± 0,02	1,22 ± 0,02
Pot life at 20°C	seconds	50 - 60	-	-
Curing time at RT	min.	20 - 30	-	-
Post curing	Time in h/ Temperature in °C	4 - 5 / 60	-	-

### Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	75 ± 5
Flexural modulus	EN ISO 178	MPa	2650 ± 250
Flexural strength at breakage	EN ISO 178	%	5,9 ± 0,2
Tensile strength	EN ISO 527	MPa	-
Compressive strength	EN ISO 604	MPa	56 ± 4
Impact resistance (Charpy)	EN ISO 179	kJ/m <sup>2</sup>	35 ± 5
Heat resistance (Martens)	DIN 53458	°C	50 ± 2
Glass transition temperature TG	methode DSC	°C	ca. 80
Shore hardness	DIN 53505	Shore D	81 ± 2

### Sales units (packages)

Units	Comp. A	MG 425 GF 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. 4 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. 20 - 30 min. 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 425 GF is processed on a two-component low pressure device.

The systems MG 400 / MG 423 / MG 425 / MG 425 GF / MG 475 / MG 480 are cured with the hardener PUR 19.

For this product range potlife can be set until 4 min.

By mixing MG 425 GF with MG 400 the E-modulus can vary between 630 – 2800 MPa.

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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