

Basis	Vaccum Casting Resin MG 410
Resin	MG 410 Comp. A
Hardener	MG 410 Comp. B
Colour	ivory

Applications

- Prototypes automotive field
- Prototypes in the industrial field
- Prototypes in the design field

Properties

- highly heat resistant
- very well castable
- high strength
- fast curing

Processing data

Product		Mixture MG 410 / Comp. A+B	Resin MG 410 Comp. A	Hardener MG 410 Comp. B
Colour		ivory	ivory	transparent
Mixing ratio	p. b. w.		100	200
Viscosity at 25°C	mPas	250 ± 50	450 ± 50	60 ± 10
Density at 20°C	g / cm ³	1,13 ± 0,01	1,0 ± 0,01	1,2 ± 0,01
Pot life 200 g / 20°C	min.	3 - 5	-	-
Curing time at 60° C	min.	30 - 60	-	-
Post curing	Time in h/ Temperature in °C	1 h / 70 1 h / 120 2 h / 150	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	76 ± 7
Flexural modulus	EN ISO 178	MPa	2450 ± 200
Flexural strength at breakage	EN ISO 178	%	4,0 ± 0,6
Tensile strength	EN ISO 527	MPa	40 ± 3
Breaking elongation (tensile)	EN ISO 527	%	3 ± 0,4
Compressive strength	EN ISO 604	MPa	86 ± 8
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	11 ± 3
Impact strength	ASTM D - 256	J/m	-
Heat resistance (HDT)	DIN EN ISO 75 B	°C	200 ± 5
TG in TMA T _G	Methode TMA	°C	n. a.
Shore hardness	DIN 53505	Shore D	84 ± 3
Linear shrinkage	internal	%	ca. 0,6

Sales units (packages)

Units	Resin	MG 410 Comp. A	1,000 kg
	Hardener	MG 410 Comp. B	1,000 kg

Processing instructions

In order to get bubble-free parts, we recommend working under vacuum.
Straight before casting, we recommend a one-time air impact of 60-70 mbar.

Mouldmaterial: we recommend silicone moulds, for example **Silastic®** T4.

In General

This product is a polyurethane casting resin.

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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