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|----------|---------------------------------------|
| Basis | Crystal clear PU-casting resin |
| Resin | MG 709 Comp. A |
| Hardener | MG 709-120 Comp. B |
| Colour | colourless |

Applications

- In the automotive field
- Domestic articles
- Consumer goods
- Lenses
- Decoration stuff
- Jewellery imitation

Properties

- UV-stable
- crystal clear
- castable up to 150 mm

Processing data

| Product | | Mixture MG 709-120 / Comp. A+B | Resin MG 709 Comp. A | Hardener MG 709-120 Comp. B |
|-----------------------|------------------------------------|-----------------------------------|-------------------------|--------------------------------|
| Colour | | colourless | colourless | colourless |
| Mixing ratio | p. b. w. | | 100 | 90 |
| Viscosity at 25°C | mPas | 450 ± 100 | 300 ± 75 | 550 ± 100 |
| Density at 20°C | g / cm ³ | 1,04 ± 0,02 | - | - |
| Pot life 200 g / 20°C | min. | 110 - 120 | - | - |
| Curing time at RT | hrs. | 20 - 30 | - | - |
| Post curing | Time in h/ Temperature in °C | - | - | - |

Physical data

| Properties | Inspect. requirem. | Unit | Value |
|-------------------------------|--------------------|-------------------|------------|
| Flexural strength | EN ISO 178 | MPa | 68 ± 5 |
| Flexural modulus | EN ISO 178 | MPa | 2150 ± 150 |
| Flexural strength at breakage | EN ISO 178 | % | 5 ± 0,1 |
| Tensile strength | EN ISO 527 | MPa | - |
| Breaking elongation (tensile) | EN ISO 527 | % | - |
| Compressive strength | EN ISO 604 | MPa | 60 ± 6 |
| Impact resistance (Charpy) | EN ISO 179 | kJ/m ² | 67 ± 10 |
| Impact strength | ASTM D - 256 | J/m | - |
| Heat resistance (Martens) | DIN 53458 | °C | 35 ± 2 |
| TG in TMA T _G | Methode TMA | °C | - |
| Shore hardness | DIN 53505 | Shore D | 80 ± 3 |
| Linear shrinkage | internal | % | - |

Sales units (packages)

| | | | |
|-------|----------|--------------------|---------------------|
| Units | Resin | MG 709 Comp. A | 1,000 kg / 5,000 kg |
| | Hardener | MG 709-120 Comp. B | 0,900 kg / 4,500 kg |

Processing instructions

As moulding compounds we recommend **Silastic® S**. When using other types of silicones, mat surfaces might occur.

Both components should be mixed for about 2 minutes in their correct mixing ratios.

To achieve a bubble free article we recommend a de-airing of the mixture.

Colour pigments should be mixed into the B-component.

The castings cure at room temperature. In the case of early demoulding the surface may be sticky.

This can be rectified by a post cure of about 5 hrs at 60 °C.

In General

Our product MG 709 is a crystal clear UV stabilized 2-components polyurethane casting compound with different potlives curing at room temperature.

For parts with thinner wall thicknesses and shorter potlife we recommend MG 709-9 or MG 709-20.

Further data sheets MG 709-9 / MG 709-20.

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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