

Basis	Crystal clear PU-casting resin
Resin	MG 709 Comp. A
Hardener	MG 709-20 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 75 mm

Processing data

Product		Mixture MG 709-20 / Comp. A+B	Resin MG 709 Comp. A	Hardener MG 709-20 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.	15 - 20	-	-
Curing time at RT	hrs.	12 - 16	-	-
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 709-20 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.

Processing preferentially in customary vacuum pouring plants.

For parts with thicker wall thicknesses and longer potlife we recommend MG 709-120.

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

Further data sheets MG 709-9 / MG 709-120.

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.

ebalta UK Limited . B2 Langham Park, Trent Lane . Castle Donington . Derbyshire DE74 2UT
t: +44 1332 814700 . f: +44 1332 814775 . e: info@**ebalta**.co.uk . w: www.**ebalta**.co.uk