

Basis	<b>Prototype casting resin MG 805-1</b>
Resin	<b>MG 805-1 Comp. A</b>
Hardener	<b>MG 805 Comp. B</b>
Colour	black

### Applications

- High quality prototypes, like ABS

### Properties

- very high temperature resistance
- excellent dissolving
- very well castable
- long potlife

### Processing data

Product		Mixture MG 805-1 / MG 805	Resin MG 805-1 Comp. A	Hardener MG 805 Comp. B
Colour		black	colourless	black
<b>Mixing ratio</b>	<b>p. b. w.</b>		<b>100</b>	<b>70</b>
Viscosity at 25°C	mPas	-	700 ± 100	700 ± 100
Density at 20°C	g / cm <sup>3</sup>	1,16 ± 0,02	1,14 ± 0,02	1,16 ± 0,02
Pot life 200 g / 20°C	min.	5 - 7	-	-
Curing time at 75° C	min.	90 - 120	-	-
Post curing	Time in h/ Temperature in °C	1 / 100 2 / 120	-	-

### Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	100 ± 5
Flexural modulus	EN ISO 178	MPa	1930 ± 100
Flexural strength at breakage	EN ISO 178	%	9 ± 0,2
Tensile strength	EN ISO 527	MPa	67 ± 5
Breaking elongation (tensile)	EN ISO 527	%	10,5 ± 2
Compressive strength	EN ISO 604	MPa	-
Impact resistance (Charpy)	EN ISO 179	kJ/m <sup>2</sup>	63 ± 10
Impact strength	ASTM D - 256	J/m	-
Heat resistance (Martens)	DIN 53458	°C	120 ± 3
TG in TMA T <sub>G</sub>	Methode TMA	°C	135
Shore hardness	DIN 53505	Shore D	80 ± 3
Linear shrinkage	internal	%	ca. 0,3

### Sales units (packages)

Units	Resin	MG 805-1 Comp. A	1,000 kg / 5,000 kg
	Hardener	MG 805 Comp. B	0,700 kg / 3,500 kg

## Processing instructions

Stir up comp. A before use, since additives tend to sedimentation. Higher heat resistance is reached with MG 805-1.

Processing parameters: Temperature of resin: 20-30°C / Temperature of mould: 75°C.

Further data sheets: MG 805

In order to get bubble-free parts, we recommend working under vacuum.  
Straight before casting, we recommend a one-time air impact from 10 of 60-70 mbar.

The material has to be cured of min. 50 °C. Curing at room temperature leads to brittle of the material.

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

## In General

This product is a polyurethane system.

Processing preferably in vacuum casting machine.  
Manufacturing of the parts can be made manually.

## 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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