

Basis	<b>vaccum casting resin</b>
Resin	<b>MG 811 Comp. A</b>
Hardener	<b>MG 811 Comp. B (polyol)</b>
Colour	beige

### Applications

- High quality prototypes like PE

### Properties

- low agressivenes against silicones
- good impact strength
- long processing time
- very well castable

### Processing data

Product		Mixture MG 811 / Comp. A+B	Resin MG 811 Comp. A	Hardener MG 811 Comp. B (polyol)
Colour		beige	transparent	brown transparent
<b>Mixing ratio</b>	<b>p. b. w.</b>		<b>100</b>	<b>50</b>
Viscosity at 25°C	mPas	1000 ± 200	2450 ± 250	100 ± 10
Density at 20°C	g / cm <sup>3</sup>	1,14 ± 0,03	1,12 ± 0,03	1,19 ± 0,03
Pot life 200 g / 20°C	min.	11 - 12	-	-
Curing time at 70° C	Std.	2 - 2,5	-	-
Post curing	Time in h/ Temperature in °C	4 / 70	-	-

### Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	90 ± 5
Flexural modulus	EN ISO 178	MPa	1150 ± 10
Flexural strength at breakage	EN ISO 178	%	11,8 ± 0,3
Tensile strength	EN ISO 527	MPa	40 ± 5
Compressive strength	EN ISO 604	MPa	33 ± 3
Impact resistance (Charpy)	EN ISO 179	kJ/m <sup>2</sup>	no break
Shore hardness	DIN 53505	Shore D	75 ± 2

### Sales units (packages)

Units	Comp. A	MG 811 Comp. A	1 kg
	Comp. B	MG 811 Comp. B (polyol)	0,5 kg

## Processing instructions

MG 811 has to be cast in 60 - 70°C heated moulds. The components can be demoulded after approx. 2 - 2,5 hrs. This can differ accordingly to wall thickness and temperature.

To obtain optimum properties, afterwards postcuring of 4 hrs. at 70°C is required. If necessary, support parts during postcuring.

To get bubble-free parts, we recommend vacuum processing. Before casting a single air impact from 10 to 60-70 mbar is advisable.

For the mould material we suggest silicone moulds, e.g. **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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