

Basis	Crystal clear PU-casting resin
Resin	MG 850 Comp. A
Hardener	MG 850 Comp. B
Colour	transparent

### Applications

- Clear prototypes
- Samples

### Properties

- crystal clear
- well castable
- fast demolding
- high hardness

### Processing data

Product		Mixture MG 850 / Comp. A+B	Resin MG 850 Comp. A	Hardener MG 850 Comp. B
Colour		transparent	transparent	transparent
<b>Mixing ratio</b>	<b>p. b. w.</b>		<b>100</b>	<b>70</b>
Viscosity at 25°C	mPas	350 ± 100	80 ± 30	600 ± 100
Density at 20°C	g / cm <sup>3</sup>	1,07 ± 0,02	1,07 ± 0,02	1,07 ± 0,02
Pot life 200 g / 20°C	min.	8 - 10	-	-
Curing time at 60° C	min.	90 - 120	-	-
Post curing	Time in h/ Temperature in °C	-	-	-

### Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	87 ± 5
Flexural modulus	EN ISO 178	MPa	2220 ± 200
Flexural strength at breakage	EN ISO 178	%	7,0 ± 0,2
Tensile strength	EN ISO 527	MPa	-
Breaking elongation (tensile)	EN ISO 527	%	-
Compressive strength	EN ISO 604	MPa	77 ± 5
Impact resistance (Charpy)	EN ISO 179	kJ/m <sup>2</sup>	90 ± 15
Impact strength	ASTM D - 256	J/m	-
Heat resistance (Martens)	DIN 53458	°C	46 ± 2
TG in TMA T <sub>G</sub>	Methode TMA	°C	80
Shore hardness	DIN 53505	Shore D	82 ± 3
Linear shrinkage	internal	%	-

### Sales units (packages)

Units	Resin	MG 850 Comp. A	1,000 kg
	Hardener	MG 850 Comp. B	0,700 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 from 10 to 60-70 mbar.

As moulding compound we recommend silicone moulds for example **Silastic® S**.

Processing of MG 850 only in warm moulds at 60°C - 70 °C.

## In General

MG 850 is not completely UV-stable.  
However tests showed that after 12 months' storage there are nearly no changes in colour.

Parts with wall thickness til 6 cm can be made without any problems.

## 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