

(Also known in Europe as SG 130 / PUR 11)

Basis	High quality fast casting resin system
Resin	SG 140 Comp. A
Hardener	PUR 11 Comp. B
Colour	ivory

## Applications

- Foundry patterns
- Core boxes
- Negatives
- Prototypes
- Vacuum forming tools
- Coping models
- Mould probes for trimming of prototypes

## Properties

- unfilled
- impact resistant
- high strength

## Processing data

Product		Mixture SG 140 / PUR 11	Resin SG 140 Comp. A	Hardener PUR 11 Comp. B
Colour		ivory	white	yellow
<b>Mixing ratio</b>	<b>p. b. w.</b>		<b>100</b>	<b>100</b>
Viscosity at 25°C	mPas	75 ± 20	150 ± 20	25 ± 10
Density at 20°C	g / cm <sup>3</sup>	1,10 ± 0,02	1,12 ± 0,02	1,10 ± 0,02
Pot life 200 g / 20°C	min.	2,5 - 3,5	-	-
Curing time at RT	hrs.	0,5 - 1,5	-	-

## Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	60 ± 5
Flexural modulus	EN ISO 178	MPa	1000 ± 100
Flexural strength at breakage	EN ISO 178	%	12 ± 0,3
Compressive strength	EN ISO 604	MPa	47 ± 5
Impact resistance (Charpy)	EN ISO 179	kJ/m <sup>2</sup>	26 ± 2,5
Heat resistance (HDT)	DIN EN ISO 75 B	°C	84 ± 3
Shore hardness	DIN 53505	Shore D	72 ± 2
Coefficient of linear expansion	DIN 53752	10 <sup>-6</sup> K <sup>-1</sup>	-
Linear shrinkage	internal	%	-

## Sales units (packages)

Packing size	A-Pack	SG 140 / PUR 11	Resin 5 x 0,250 kg / Hardener 5 x 0,250 kg / Filler F-B 5 x 0,750 kg = 6,250 kg
Units	Resin	SG 140 Comp. A	1,000 kg / 5,000 kg / 50,000 kg
	Hardener	PUR 11 Comp. B	1,000 kg / 5,000 kg / 50,000 kg

## Processing instructions

The fillers should be stirred into the single components A and B, so they have nearly the same viscosity. After the both components can be mixed very well.

In case of small quantities and sufficient experience it is also possible to mix the unfilled components first and then to stir into the filler, without making the potlife too short for casting.

## In General

This is a Polyurethane system.

Material should be carefully stirred up/ shaken before use.

Filler content and sales units are on the separate mixing table noted.

## Storing

At room temperature (18 – 25°C) and closed original containers storage life is 6 months.

Partly used containers have always to be closed and the material has to be used up 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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