

Special-Resins

for foundry models, tools patterns, gauges and master models.

Accessories:

release agents, fillers, core and reinforcing materials and miscellaneous tooling aids

ebalta

UK LIMITED

B2 Langham Park, Trent Lane

Castle Donington, DE74 2UT

Technical Data Sheet

High quality unfilled casting resin

General remarks

ebalta SG SG 140L is a high-quality, nearly odourless two-component unfilled polyurethane casting resin. Alternative fillers can be added to the mixed components.

The binding agent is very temperature-resistant immediately after curing, without tempering, and has high strength values. The remaining properties are determined by the filling materials used.

We recommend the following fillers:

Filler -workable	F-B
Filler -abrasion-resistant	F-A
Filler -G	F-G
Filler -alu	F-alu
Filler -iron	F-Iron
Filler - MF	MF-Paste

Properties, fill-grade and packing-sizes of the fillers are on the back-page of this data-sheet.

Properties

Only slight odour
Temperature-resistant
High strength

Fields of application

Foundry models and core boxes
Negatives of all types and auxiliary forms
Jigs for holding and trimming
Prototype parts
Vacuum forming tools
Copying forms and style models

Checking cast of core boxes, casting forms and contours, forms for plastics processing.

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SG 140L

Physical Properties

Colour	Resin SG 140L	white
	Hardener PUR 12	brown
Mixing-viscosity	mPas	: 70-90
Specific gravity	kg/dm ³	: 1,05
Hardness-Shore D	at 20 °C	: 70-75
Compressive strength	N/mm ²	: 35
Tensile strength	N/mm ²	: 30-35
Flexural strength	N/mm ²	: 35-40
Impact strength	KJ/m ²	: 15-20
Temperature resistance	°C	: approx. 80

Information for use

Mixing ratio:	100	p.b.w. Resin	SG 140L
	100	p.b.w. Hardener	PUR 12

Pot life 200 g at 20°C: 7 - 9 min.

Curing time (de-mouldable) 2 - 2 ½ hrs.

Application and

curing temperature: 18 - 25 °C

Storage life at RT in closed containers: 1/2 year

in closed containers:

Filled substances should be thoroughly mixed before removal

Close containers at once after use

Packing sizes

SG 140L	1,000 kg, 5,000 kg, 50,000 kg
PUR 12	1,000 kg, 5,000 kg, 50,000 kg

F-B, -F-A, F-Alu	25 kg
F-B, F-Eisen	40 kg
F-G	20 kg, 40 kg
MF-Paste	1,200 kg

Note:

The instructions and recommendations are given in good faith, and are based on long experience and careful tests. But these recommendations are without guarantee, since the conditions of use are beyond our control.

Fillers of SG 140L

The fillers should be stirred in the two-component A + B separate, so that both components have the same viscosity. Than the both components are very easy and good mixable. By small amounts and enough routine it is also possible to mix the unfilled component at first and put then the fillers in, without losing too much pot life for pouring.

Filler workable

Name: F-B

Properties good workable
high filling possible
low shrinkage
easy mixable

Colour : white

Fill-grade max. the 2,0 time of the resin/hardener mix (comp. A + comp. B)

Packing-size 25 kg - packs, 40 kg - packs

Filler abrasion resistant

Name: F-A

Properties abrasion resistant
fine structure

Colour : light-grey

Fill-grade max. the 2,5 time of the resin/hardener mix (comp. A + comp. B)

Packing-size 25 kg - packs

Filler - G

Name: F-G

Properties Dense smooth surface
wear resistant
easy workable mixes
mixes well without dust

Colour: beige

Fill-grade up to max. two times the fluid components A + B

Packing-size 20 kg and 40 kg containers

Filler-Alu

Name: F-Alu

Properties fine structure
very good workable
good grindable
easy mixable
high filling possible

Colour: alu

Fill-grade max. the 1,75 time of the resin/hardener mix (comp. A + comp. B)

Packing-size 25 kg-packs

Filler-Iron

Name: F-Iron

Properties low shrinkage
very high filling possible
very thick castable
high mechanical properties
easy mixable

Colour: black

Fill-grade max. the 4 times of the resin/hardener mix (comp. A + comp. B)

Packing size 40 kg-packs

Filler - MF

Name: M-F Paste

Properties Very easy to work
very low weight
mixes well without dust

Colour: white

Fill-grade up to max. 0,2 times the fluid components A + B

Packing-size 1,2 kg containers