

Basis	<b>HIGH QUALITY UNFILLED CASTING RESIN</b>
Resin	<b>SG 145 Comp. A</b>
Hardener	<b>SG 145 Comp. B</b>

## Applications

- Foundry models and core boxes
- Negatives of all types and auxillary forms
- Jigs for holding and trimming
- Prototype parts
- Copying forms and style models
- Checking cast of core box, casting forms and contours
- Forms for plastic processing

## Properties

- Very liquid
- High filling grade
- Only slight odour
- Good strength
- Low shrinkage
- Very good price/performance proportion

## Processing Data

Product		Mixture SG 145 Comp. A + B	Resin SG 145 Comp. A	Hardener SG 145 Comp. B
Colour			beige	brown
<b>Mixing ratio</b>	<b>p.b.w.</b>		100	100
Mixing viscosity	mPas	70 - 90		
Specific gravity without filler	kg/dm <sup>3</sup>	1.08 +/- 0.02		
Pot life 200g at 20°C	min.	5 - 7		
Curing time (demouldable)	hrs	1 - 2		
Application and curing temperature	°C	18 - 25		

## Physical Properties

Properties	Unit	Value
Colour		brown
Hardness at 20°C, without filler	Shore D	72 - 75
Compressive Strength, without filler	N/mm <sup>2</sup>	40 - 50
Tensile strength	N/mm <sup>2</sup>	50 - 55
Flexural Strength	N/mm <sup>2</sup>	55 - 60
E-modulus, flexural	n/mm <sup>2</sup>	1400 - 1500
Elongation at break, without filler	%	6.0 - 6.5
Linear shrinkage with 1.5 p.b.w. Filler F-B	%	0.13
Impact strength	KJ/m2	12 - 15
Temperature resistance	°C	55+/- 2

## Sales units (packages)

Units	Resin	SG 145 Comp. A	5,000 kg / 25,000 kg
	Hardener	SG 145 Comp. B	5,000 kg / 25,000 kg

tooling resins

blocks

ancillaries

silicones



## In General

The product ebalta SG 145 is a high quality, especially well suited two-component polyurethane casting resin with a very good price / performance proportion. SG 145 is without mixed in filler. The filler is stirred when the two components are mixed.

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	Name
Filler workable	Filler DN 20
Filler abrahasion resistant	Filler DN 80
Filler FG	Filler FG
Filler F Alu	Filler DN 30
Filler F Iron	Filler DN 60
Filler MF Paste	Filler MF Paste

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

## Storing

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

Filled substances should be thoroughly mixed before removal.

Close containers at once after use.

**Fillers of SG 145**

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

<b>Filler workable</b>		<b>Name: Filler DN 20</b>
Properties	<ul style="list-style-type: none"> <li>• good workable</li> <li>• high filling possibilities</li> <li>• low shrinkage</li> <li>• easy mixable</li> </ul>	<b>Colour: white</b>
Fill-grade	max. 2.0 time of the resin/hardener mix (comp. A + comp. B)	
Packing-size	25 kg - packs, 40 kg - packs	
<b>Filler abrasion resistant</b>		<b>Name: Filler DN 80</b>
Properties	<ul style="list-style-type: none"> <li>• abrasion resistant</li> <li>• fine structure</li> </ul>	<b>Colour: light grey</b>
Fill-grade	max. 2.5 time of the resin/hardener mix (comp. A + comp. B)	
Packing-size	25 kg - packs	
<b>Filler FG</b>		<b>Name: Filler FG</b>
Properties	<ul style="list-style-type: none"> <li>• dense smooth surface</li> <li>• wear resistant</li> <li>• easy workable mixes</li> <li>• mixes well without dust</li> </ul>	<b>Colour: beige</b>
Fill-grade	up to max. two times the fluid components A + B	
Packing-size	20 kg and 40 kg containers	
<b>Filler F Alu</b>		<b>Name: Filler DN 30</b>
Properties	<ul style="list-style-type: none"> <li>• fine structure</li> <li>• very good workable</li> <li>• good grindable</li> <li>• easy mixable</li> <li>• high filling possible</li> </ul>	<b>Colour: aluminium</b>
Fill-grade	max.1.75 time of the resin/hardener mix (comp. A + comp. B)	
Packing-size	25 kg - packs	
<b>Filler F Iron</b>		<b>Name: Filler DN 60</b>
Properties	<ul style="list-style-type: none"> <li>• low shrinkage</li> <li>• very high filling possible</li> <li>• very thick castable</li> <li>• high mechanical properties</li> <li>• easy mixable</li> </ul>	<b>Colour: black</b>
Fill-grade	max.4 times of the resin / hardener mix (comp. A + comp. B)	
Packing-size	40 kg - packs	
<b>Filler MF Paste</b>		<b>Name: Filler MF Paste</b>
Properties	<ul style="list-style-type: none"> <li>• very easy to work</li> <li>• very low weight</li> <li>• mixes well without dust</li> </ul>	<b>Colour: white</b>
Fill-grade	up to max.0.2 times the fluid components A + B	
Packing-size	1.2 kg containers	

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 the 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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