

Basis	Heat resistant fast curing resin system
Resin	SG 152 Comp. A
Hardener	Hardener powder SG 152
Filler	F-Alu/3
Colour	grey

Applications

- Vacuum forming tools
- Polyester press forms
- Tools for plastic pressing
- Tools for plastic stamping

Properties

- heat resistant
- fast curing

Processing data

Product		Mixture SG 152	Resin SG 152 Comp. A	Hardener Hardener powder SG 152	Filler F-Alu/3
Colour		grey	yellow transparent	white	alu grey
Mixing ratio	p. b. w.		100	3	200
Viscosity at 25°C	mPas	-	7000 ± 1000	-	-
Density at 20°C	g / cm ³	-	1,8 ± 0,05	-	-
Pot life 200 g / 20°C	min.	18 - 22	-	-	-
Curing time at RT	hrs.	0,5 - 1	-	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	-
Flexural modulus	EN ISO 178	MPa	-
Flexural strength at breakage	EN ISO 178	%	-
Compressive strength	EN ISO 604	MPa	110 ± 10
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	-
Heat resistance (Martens)	DIN 53458	°C	98 ± 3
Shore hardness	DIN 53505	Shore D	85 ± 3
Coefficient of linear expansion	DIN 53752	10 ⁻⁶ K ⁻¹	ca. 38
Linear shrinkage	internal	%	ca. 0,1

Sales units (packages)

Units	Comp. A	SG 152 Comp. A	9,000 kg / 25,000 kg
	Comp. B	Hardener powder SG 152	0,270 kg / 0,750 kg
	Filler	F-Alu/3	18,000 kg / 25,000 kg

Processing instructions

Release treatment:

All models and moulds have to be treated with **ebalta**-primer and **ebalta** release wax T2. The negative, which is treated with the release wax has to be treated with the release film PVA finally. The release film residues can be washed off easily with water after demoulding.

Preparation:

The wall thicknesses should not be less than 40 mm, as otherwise the necessary curing is not achieved.

Further information for application see separate sheet.

In General

It consists of a liquid component and a hardener powder. The liquid component is filled with the double amount in ppw of special aluminium filler F-Alu/3. The resin cures within 20-30 minutes to well heat-conducting, heat-resistant moulds.

The cured moulds are very easily machinable. The structure is extremely dense and the machined areas have an aluminium-like appearance.

It is possible to cast any quantity, which can be mixed in one or more containers. After-casting or casting in layers is not possible. Therefore it is very important to determine the casting volume exactly in order to avoid that the mixed quantity is too small.

Material should be carefully stirred up/ shaken before use.

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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