

Basis	<b>Vaccum Casting Resin MG 410</b>
Resin	<b>MG 410 Comp. A</b>
Hardener	<b>MG 410 Comp. B</b>
Colour	ivory

## Applications

- Prototypes in the automotive field
- Prototypes in the industrial field
- Prototypes in the design field

## Properties

- highly heat resistant
- very well castable
- high strength
- fast curing

## Processing data

Product		Mixture MG 410 / Comp. A+B	Resin MG 410 Comp. A	Hardener MG 410 Comp. B
Colour		ivory	ivory	transparent
<b>Mixing ratio</b>	<b>p. b. w.</b>		<b>100</b>	<b>200</b>
Viscosity at 25°C	mPas	250 ± 50	450 ± 50	60 ± 10
Density at 20°C	g / cm <sup>3</sup>	1,13 ± 0,01	1,0 ± 0,01	1,2 ± 0,01
Pot life 200 g / 20°C	min.	3 - 5	-	-
Curing time at 60° C	min.	30 - 60	-	-
Post curing	Time in h/ Temperature in °C	1 h / 70 1 h / 120 2 h / 150	-	-

## Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	76 ± 7
Flexural modulus	EN ISO 178	MPa	2450 ± 200
Flexural strength at breakage	EN ISO 178	%	4,0 ± 0,6
Tensile strength	EN ISO 527	MPa	40 ± 3
Breaking elongation (tensile)	EN ISO 527	%	3 ± 0,4
Impact resistance (Charpy)	EN ISO 179	kJ/m <sup>2</sup>	11 ± 3
Heat resistance (HDT)	DIN EN ISO 75 B	°C	200 ± 5
TG in TMA T <sub>g</sub>	Methode TMA	°C	n. a.
Shore hardness	DIN 53505	Shore D	84 ± 3
Linear shrinkage	internal	%	ca. 0,6

## Sales units (packages)

Units	Resin	MG 410 Comp. A	1,000 kg
	Hardener	MG 410 Comp. B	2 x 1,000 kg

## Processing instructions

To get bubble-free parts, we recommend vacuum processing

In order to simplify stirring, the material should be heated up at 60°C (no processing at 60°C, potlife too short!) over night. The material should have a temperature of about 25°C, mould temperature 60°C.

As moulding material we recommend silicone moulds, for example made of **Silastic®** T-4.

## In General

This product is a polyurethane system which is not resistant to hydrolysis.

Postcuring has to be made in one step.

Since the material has a single softening point at 60°C, we recommend backing up the part during postcuring.

## Storing

Storage at room temperature 18-25 °C.

Already opened containers should be closed immediately after use and should be used as soon as possible.

Information about the expiration date you find on the sales packages.

## 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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