

Basis **Prototype casting resin MG 804 804 GF / 804**  
 Resin **MG 804 Comp. A**  
 Paste **MG 804 GF paste**  
 Hardener **MG 804-1 Comp. B**

Colour white  
 Further colours black

### Applications

- High quality prototypes, like ABS
- High quality prototypes, like PA

### Properties

- long potlife
- very well castable
- good impact strength
- high rigidity adjustable
- easily dyeable
- low aggressiveness against silicones

### Processing data

Product		Mixture MG 804, 804 GF / MG 804-1	Resin MG 804 Comp. A	Paste MG 804 GF paste	Hardener MG 804-1 Comp. B
Colour		white	whitish transparent	whitish	light amber
<b>Mixing ratio</b>	<b>p. b. w.</b>		<b>100</b>	<b>100</b>	<b>150</b>
Viscosity at 25°C	mPas	-	500 ± 70	thixotrop	50 ± 5
Density at 20°C	g / cm <sup>3</sup>	1,10 ± 0,02	1,038 ± 0,02	1,45 ± 0,03	1,16 ± 0,02
Pot life 200 g / 20°C	min.	7 - 9	-	-	-
Curing time at 60° C	min.	45 - 60	-	-	-
Post curing	Time in h/ Temperature in °C	4 / 60	-	-	-

### Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	78 ± 5
Flexural modulus	EN ISO 178	MPa	2600 ± 150
Flexural strength at breakage	EN ISO 178	%	4,9 ± 0,3
Tensile strength	EN ISO 527	MPa	-
Breaking elongation (tensile)	EN ISO 527	%	-
Impact resistance (Charpy)	EN ISO 179	kJ/m <sup>2</sup>	17 ± 2
TG in TMA T <sub>g</sub>	Methode TMA	°C	90
Shore hardness	DIN 53505	Shore D	78 ± 2
Linear shrinkage	internal	%	ca. 0,1

### Sales units (packages)

Units	Resin	MG 804 Comp. A	1,000 kg / 5,000 kg / 20,000 kg
	paste	MG 804 GF paste	1,000 kg / 5,000 kg / 20,000 kg
	Hardener	MG 804-1 Comp. B	1,000 kg / 5,000 kg / 20,000 kg

## Processing instructions

Stir up comp. A before use, since additives tend to sedimentation.

Individual formulation of E-modulus by adding glass fibre paste. Following instructions for mixing ratio!

To get more stiffness of the parts glass fibre paste MG 804 GF could be used.

Due to higher viscosity the casting has to be made in a vacuum chamber.

Further data sheets: MG 804 / Comp. A +B  
MG 804 / MG 804-1  
MG 804 GF/ MG 804-1

Processing parameters: Temperature of resin: 20-30°C / Temperature of mould: 60 - 70°C.

In order to get bubble-free parts, we recommend working under vacuum.

Straight before casting, we recommend a one-time air impact from 10 of 60-70 mbar.

Mouldmaterial: we recommend silicone moulds, for example **Silastic®** T4.

## In General

This product is a polyurethane system.

Preferential processing in usually used vacuum pouring plants.

Maximum wall thicknesses of the parts: from 5 – 10 mm.

## 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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