

Basis	Prototype casting resin MG 805
Resin	MG 805 Komp. A
Hardener	MG 805 FR Comp. B
Colour	black

Applications

- High quality parts, flame retardant

Properties

- flame retardant variation
- high heat resistance
- long potlife

Processing data

Product		Mixture MG 805 / MG 805 FR	Resin MG 805 Komp. A	Hardener MG 805 FR Comp. B
Colour		black	colourless	black
Mixing ratio	p. b. w.		100	120
Viscosity at 25°C	mPas	-	290 ± 25	3500 ± 500
Density at 20°C	g / cm ³	1,33 ± 0,03	1,14 ± 0,02	1,4 ± 0,03
Pot life 200 g / 20°C	min.	5 - 7	-	-
Curing time at 75° C	min.	90 - 120	-	-
Post curing	Time in h/ Temperature in °C	2 / 100	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	70 ± 5
Flexural modulus	EN ISO 178	MPa	2770 ± 250
Flexural strength at breakage	EN ISO 178	%	4,5 ± 0,3
Tensile strength	EN ISO 527	MPa	46 ± 4
Breaking elongation (tensile)	EN ISO 527	%	9,7 ± 0,5
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	18 ± 3
TG in TMA T _G	Methode TMA	°C	122
Shore hardness	DIN 53505	Shore D	83 ± 3
Linear shrinkage	internal	%	ca. 0,3
Fire behavior / Coating thickness 4 mm	-	-	VO

Sales units (packages)

Units	Resin	MG 805 Komp. A	1,000 kg
	Hardener	MG 805 FR Comp. B	1,200 kg

Processing instructions

Stir up comp. A before use, since additives tend to sedimentation. Higher heat resistance is reached with MG 805-1.

Further data sheets: MG 805-1

Processing parameter: Temperature of resin: 20-30°C / Temperature of mould: 75°C.

MG 805 FR, comp.B contains fillers, which now and then and depending on temperatures tend to sedimentation. For this reason before mixing careful stirring up is requested.

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

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

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

In General

This product is a filled prototype casting resin on polyurethane basis, which is flame resistant according to EN 60950 Class V-O.

Processing preferably in vacuum casting machine.

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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