

Basis **Prototype casting resin MG 933**
 Resin **MG 933 Comp. A**
 Hardener **MG 933 Comp. B**

Colour black
 Further colours beige

Applications

- Funktional parts automotive field
- Funktional parts EDP field
- Prototyping parts EDP field
- Prototypes in the automotive field
- Cladding parts automotive field
- Cladding parts EDP field

Properties

- high impact resistance
- good flexural strength
- longer processing time

Processing data

Product		Mixture MG 933 / Comp. A+B	Resin MG 933 Comp. A	Hardener MG 933 Comp. B
Colour		black	black	brown transparent
Mixing ratio	p. b. w.		100	91
Viscosity at 25°C	mPas	1000 ± 100	1500 ± 500	200 ± 50
Density at 20°C	g / cm ³	1,18 ± 0,02	1,04 ± 0,02	1,23 ± 0,02
Pot life 200 g / 20°C	min.	4 - 5	-	-
Curing time at RT	hrs.	3 - 4	-	-
Post curing	Time in h/ Temperature in °C	6 / 70	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	80 ± 5
Flexural modulus	EN ISO 178	MPa	2000 ± 150
Flexural strength at breakage	EN ISO 178	%	7,2 ± 0,3
Tensile strength	EN ISO 527	MPa	-
Breaking elongation (tensile)	EN ISO 527	%	-
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	83 ± 10
Heat resistance (HDT)	DIN EN ISO 75 B	°C	73 ± 3
TG in TMA T _g	Methode TMA	°C	84
Shore hardness	DIN 53505	Shore D	83 ± 3

Sales units (packages)

Units Resin MG 933 Comp. A 1,000 kg / 2,500 kg / 20,000 kg
 Hardener MG 933 Comp. B 0,910 kg / 2,280 kg / 18,200 kg

Processing instructions

It is essential to stir component A before use, as the additives tend to sedimentation. Component B has not to be stirred.

The moulding tools should be made of a polyurethane- resp. epoxy resin system, with a high-quality surface. For the vacuum casting we recommend a silicone mould.

In order to improve the surface appearance of the component, it is possible:

- to preheat the material to 30°C
- to preheat the moulds to 40 - 50°C

A combination of preheated material and moulds is the optimum.

The wall thicknesses of the components are approx. 3 - 4 mm. Ribs or bigger material accumulations can also be produced.

The shrinkage is 0,5 %. But the shrinkage can be slightly influenced by the geometry of the respective component.

The components can be demoulded after approx. 90 – 120 min. This can differ accordingly to wall thickness and temperature.

The postcuring has to be made by means of a supporting structure.

In General

Preferential processing in usually used vacuum pouring plants as well as on a two low pressure device.

After grinding with a sand paper , grit 280, the surface can be varnished with a commercial lacquer. For better adhesion we recommend the use of a primer coat. Nitrocellulose lacquers have a better adhesion on polyurethane surfaces than on acryl-lacquer-systems.

Release agent – please see category release agent

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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