

Basis	Very well castable fast casting resin system
Resin	SG 600
Hardener	PUR 4 Comp. B
Colour	red

Applications

- Foundry patterns
- Core boxes
- Control castings
- Negatives
- Prototypes
- Mould probes for trimming of prototypes

Properties

- fine structure
- well workable
- very well castable

Processing data

Product		Mixture SG 600 / PUR 4	Resin SG 600	Hardener PUR 4 Comp. B
Colour		red	red	brown
Mixing ratio	p. b. w.		100	15
Viscosity at 25°C	mPas	1100 ± 200	2700 ± 700	90 ± 20
Density at 20°C	g / cm ³	1,60 ± 0,05	1,65 ± 0,05	1,22 ± 0,02
Pot life 200 g / 20°C	min.	4 - 6	-	-
Curing time at RT	hrs.	1 - 2	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	40 ± 5
Flexural modulus	EN ISO 178	MPa	5400 ± 500
Flexural strength at breakage	EN ISO 178	%	0,90 ± 0,1
Compressive strength	EN ISO 604	MPa	70 ± 8
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	2,6 ± 0,2
Heat resistance (Martens)	DIN 53458	°C	71 ± 2
Shore hardness	DIN 53505	Shore D	85 ± 3
Coefficient of linear expansion	DIN 53752	10 ⁻⁶ K ⁻¹	-
Linear shrinkage	internal	%	-

Sales units (packages)

Packing size	B-Pack	SG 600 / PUR 4	Resin 10 x 1,000 kg / Hardener 10 x 0,150 kg = 11,500 kg
Units	Comp. A	SG 600	8,000 kg / 25,000 kg
	Hardener	PUR 4 Comp. B	1,000 kg / 1,500 kg / 3,000 kg / 6,000 kg

In General

SG 600 is a very thin liquid two-component Polyurethane casting resin, which cures very fast at room temperature. The fine structure and the very good flow properties, make it possible to produce exact castings with high mechanical and thermal properties.

SG 600 cures very fast at room temperature, so that the produced castings can be demoulded after 30 minutes. SG 600 can be easily processed and is very well mechanically workable, so that the material can be used versatile.

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.

ebalta Kunststoff GmbH . Erlbacher Straße 100 . 91541 Rothenburg ob der Tauber / Germany
Tel.: +49 9861 7007-0 . Fax: +49 9861 7007-77 . info@ebalta.de . www.ebalta.de