

Basis **Prototype casting resin MG 804 GF**  
 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
- well castable
- excellent dissolving
- easily dyeable
- low agressiveness against silicones

### Processing data

Product		Mixture MG 804 GF / MG 804-1	Paste MG 804 GF paste	Hardener MG 804-1 Comp. B
Colour		white	whitish	light amber
<b>Mixing ratio</b>	<b>p. b. w.</b>		<b>100</b>	<b>50</b>
Viscosity at 25°C	mPas	-	thixotrop	50 ± 5
Density at 20°C	g / cm <sup>3</sup>	1,35 ± 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	85 ± 5
Flexural modulus	EN ISO 178	MPa	4400 ± 400
Flexural strength at breakage	EN ISO 178	%	2,5 ± 0,3
Tensile strength	EN ISO 527	MPa	52 ± 8
Breaking elongation (tensile)	EN ISO 527	%	12 ± 2
Compressive strength	EN ISO 604	MPa	-
Impact resistance (Charpy)	EN ISO 179	kJ/m <sup>2</sup>	13 ± 2
Impact strength	ASTM D - 256	J/m	-
Heat resistance (Martens)	DIN 53458	°C	75 ± 3
TG in TMA T <sub>G</sub>	Methode TMA	°C	82
Shore hardness	DIN 53505	Shore D	80 ± 2
Linear shrinkage	internal	%	ca. 0,1

### Sales units (packages)

Units                      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. Higher heat resistance is reached with MG 804-1.

To get a better E-modulus, e.g. more stiffness of the parts glass fibre paste MG 804 GF could be used. With only this product the maximum stiffness can be achieved. Due to higher viscosity the casting has to be made in a vacuum chamber.

Further data sheets: MG 804/ Komp. A + B;  
MG 804 / MG 804-1;  
MG 804, 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.  
The processing is preferably made in customary vacuum pouring plant.  
Manual processing possible.  
Maximum wall thicknesses of the parts: from 5 – 10 mm.

## Storing

Storage at room temperature (18-25 °C) in closed original container 6 months.

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

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