

|          |   |
|----------|---|
| -UKBasis | <b>High quality, very thin liquid fast casting resin system</b> |
| Resin    | <b>SG 2000 Comp. A</b>  |
| Hardener | <b>SG 2000 Comp. B</b>  |
| Colour   | ivory   |

### Applications

- Foundry patterns
- Core boxes
- Negatives
- Control castings
- Coping models
- Vacuum forming tools
- Mould probes for trimming of prototypes

### Properties

- unfilled
- very thin liquid
- high filler content possible
- good curing
- very high strength
- very heat resistant

### Processing data

| Product               |                     | Mixture<br>SG 2000 / Comp. A+B | Resin<br>SG 2000 Comp. A | Hardener<br>SG 2000 Comp. B |
|-----------------------|---------------------|--------------------------------|--------------------------|-----------------------------|
| Colour                |                     | ivory                          | white                    | light yellow                |
| <b>Mixing ratio</b>   | <b>p. b. w.</b>     |                                | <b>100</b>               | <b>100</b>                  |
| Viscosity at 25°C     | mPas                | 50 ± 5                         | 80 ± 10                  | 25 ± 5                      |
| Density at 20°C       | g / cm <sup>3</sup> | 1,10 ± 0,02                    | 1,02 ± 0,02              | 1,14 ± 0,02                 |
| Pot life 200 g / 20°C | min.                | 2,5 - 3,5                      | -                        | -                           |
| Curing time at RT     | hrs.                | 0,5 - 1                        | -                        | -                           |

### Physical data

| Properties                      | Inspect. requirem. | Unit                             | Value      |
|---------------------------------|--------------------|----------------------------------|------------|
| Flexural strength               | EN ISO 178         | MPa                              | 57 ± 5     |
| Flexural modulus                | EN ISO 178         | MPa                              | 1500 ± 100 |
| Flexural strength at breakage   | EN ISO 178         | %                                | 7,5 ± 0,4  |
| Compressive strength            | EN ISO 604         | MPa                              | 45 ± 5     |
| Impact resistance (Charpy)      | EN ISO 179         | kJ/m <sup>2</sup>                | 24 ± 4     |
| Heat resistance (HDT)           | DIN EN ISO 75 B    | °C                               | 86 ± 3     |
| Shore hardness                  | DIN 53505          | Shore D                          | 72 ± 2     |
| Coefficient of linear expansion | DIN 53752          | 10 <sup>-6</sup> K <sup>-1</sup> | -          |
| Linear shrinkage                | internal           | %                                | -          |

### Sales units (packages)

|       |          |                 |   |
|-------|----------|-----------------|---|
| Units | Resin    | SG 2000 Comp. A | 1,000 kg / 5,000 kg / 25,000 kg / 50,000 kg |
|       | Hardener | SG 2000 Comp. B | 1,000 kg / 5,000 kg / 25,000 kg / 50,000 kg |

## Processing instructions

The fillers should be stirred into the single components A and B , so that these have nearly the same viscosity. After that both components can be mixed very well.

In case of small quantities and sufficient experience it is also possible to mix the unfilled components first and then to stir in the filler, without making the potlife too short for casting.

## In General

The product group **ebalta** SG 2000 consists of high-quality, nearly odourless two-component-Polyurethane casting resins without mixed in filler. The filler is stirred in when the components are mixed. There are different resin components available, which are processed with one hardener. The single types differ in potlife and curing time.

We have different resins -with one hardener- available. The various types differ in potlife and curing time:

SG 2000 S, potlife 1,5 – 2,5 minutes

SG 2000, potlife 2,5 – 3,5 minutes

SG 2000 L, potlife 7 – 8 minutes

SG 2015 potlife 14 - 18 minutes

The fast curing of the materials leads to a short demoulding time. The very thin binding agent effects a high filler content. The addition of different fillers determines the properties and strength.

Material should be carefully stirred up/ shaken before use.

Filler content and delivery form are mentioned on the separate mixing table.

The product can be subject to colour variations due to raw materials, but these colour variations have no influence on the quality and the properties of the product.

## 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.

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