

Basis	high grade fast casting resin
Resin	SG 140 Comp. A
Hardener	PUR 12 Comp. B
Colour	beige

Applications

- Pattern plates
- Foundry patterns
- Core boxes
- Control castings
- Coping models
- Negatives
- Prototypes
- Mould probes for trimming of prototypes

Properties

- high strength
- unfilled

Processing data

Product		Mixture SG 140 / PUR 12	Resin SG 140 Comp. A	Hardener PUR 12 Comp. B
Colour		beige	whitish	brown transparent
Mixing ratio	p. b. w.		100	100
	volume		100	91
Viscosity at 25°C	mPas	70 ± 10	165 ± 30	60 ± 5
Density at 20°C	g / cm ³	1,05 ± 0,02	1,00 ± 0,02	1,10 ± 0,02
Pot life 200 g / 20°C	min.	2,5 - 3,5	-	-
Curing time at RT	min.	30 - 60	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	45 ± 5
Flexural elongation at break	EN ISO 178	%	6,4 ± 0,2
Flexural modulus	EN ISO 178	MPa	1350 ± 80
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	15 ± 3
Compressive strength	EN ISO 604	MPa	35 ± 5
Shore hardness	DIN ISO 7619-1	Shore D	72 ± 3
Coefficient of thermal expansion	internal test / Dilatometer	10 ⁻⁶ K ⁻¹	-
Linear shrinkage	internal	%	-

Sales units (packages)

Units	Comp. A	SG 140 Comp. A	1,000 kg / 5,000 kg / 50,000 kg
	Comp. B	PUR 12 Comp. B	1,000 kg / 5,000 kg

Processing instructions

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

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

This is a Polyurethane system.

Material should be carefully stirred up/ shaken before use.

Filler content and sales units are on the separate mixing table noted.

Storing

Storage at room temperature 18-25 °C.

Opened containers should be closed immediately after use and should be used up as soon as possible.

Shelf life is indicated on the labels.

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.