MG 804 GF / MG 804-1

ebalta

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 agressivenes 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
Mixing ratio	**p. b. w.**		**100**	**50**
Viscosity at 25°C	mPas	-	thixotrop	50 ± 5
Density at 20°C	g / cm^3	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
Impact resistance (Charpy)	EN ISO 179	kJ/m^2	13 ± 2
TG in TMA T_G	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

tooling resins . **blocks** . **auxiliaries** . **silicones**

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.

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

tooling resins	.	blocks	.	auxiliaries	.	silicones