

Basis	Prototype casting resin
Resin	MG 807 FR Comp.A (Polyole)
Hardener	MG 807 FR Comp. B (isocyanate)
Colour	beige

Applications

- High quality prototypes, like ABS

Properties

- flame retardant
- well castable
- long potlife
- RoHS conform

Processing data

Product		Mixture MG 807 FR Comp. A+B	Resin MG 807 FR Comp.A (Polyole)	Hardener MG 807 FR Comp. B (isocyanate)
Colour		beige	beige	light grey
Mixing ratio	p. b. w.		100	100
Viscosity at 25°C	mPas	1000 ± 150	1300 ± 200	400 ± 100
Density at 20°C	g / cm ³	1,30 ± 0,02	1,22 ± 0,02	1,45 ± 0,02
Pot life 200 g / 20°C	min.	5 - 7	-	-
Curing time at 70° C	min.	35 - 45	-	-
Post curing	Time in h/ Temperature in °C	4 / 60	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	75 ± 5
Flexural elongation at break	EN ISO 178	%	2,4 ± 0,1
Flexural modulus	EN ISO 178	MPa	3700 ± 100
Tensile strength	EN ISO 527-1	MPa	5,0 ± 3
Elongation of tensile strength	EN ISO 527-1	%	-
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	8,4 ± 1,5
Heat resistance (HDT)	DIN EN ISO 75 B	°C	62 ± 2
Glass transition temperature TG	TMA	°C	80
Shore hardness	DIN ISO 7619-1	Shore D	83 ± 3
Coefficient of thermal expansion	internal test / Dilatometer	10 ⁻⁶ K ⁻¹	ca. 100
Flammability	according UL 94	coating thickness 4 mm	VO
Linear shrinkage	internal	%	-

Sales units (packages)

Units	Comp. A	MG 807 FR Comp.A (Polyole)	1,000 kg
	Comp. B	MG 807 FR Comp. B (isocyanate)	1,000 kg

Processing instructions

Since contents tend to sedimentation, stir comp.A and B properly before use.

Processing parameters: Temperature of resin: 20-30°C / Temperature of mould: 40 - 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.

In General

This product is a polyurethane system.

The processing is preferably made in customary vacuum pouring plant.

Manual processing possible.

Mouldmaterial: we recommend silicone moulds, for example **Silastic®** RTV 4234-T40.

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.