

Basis	High quality, very thin liquid fast casting resin system
Resin	SG 2015 Comp. A
Hardener	SG 2000 Komp. B
Colour	yellowish transparent

### Applications

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

### Properties

- unfilled
- very low viscosity
- high filler content possible
- high strength

### Processing data

Product		Mixture SG 2015 Comp. A + B	Resin SG 2015 Comp. A	Hardener SG 2000 Komp. B
Colour		yellowish transparent	whitish	light yellow
Mixing ratio	p. b. w.		100	100
	volume		100	88
Viscosity at 25°C	mPas	60 ± 10	120 ± 20	25 ± 5
Density at 20°C	g / cm <sup>3</sup>	1,10 ± 0,02	1,00 ± 0,02	1,14 ± 0,02
Pot life 200 g / 20°C	min.	10 - 15	-	-
Curing time at RT	hrs.	3 - 5	-	-

### Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	50 ± 5
Flexural elongation at break	EN ISO 178	%	7,3 ± 0,5
Flexural modulus	EN ISO 178	MPa	1200 ± 200
Impact resistance (Charpy)	EN ISO 179	kJ/m <sup>2</sup>	30 ± 5
Compressive strength	EN ISO 604	MPa	36 ± 5
Shore hardness	DIN ISO 7619-1	Shore D	70 ± 3
Heat resistance (HDT)	DIN EN ISO 75 B	°C	72 ± 2
Coefficient of thermal expansion	internal test / Dilatometer	10 <sup>-6</sup> K <sup>-1</sup>	-
Linear shrinkage	internal	%	-

### Sales units (packages)

Units	Comp. A	SG 2015 Comp. A	1,000 kg / 5,000 kg / 50,000 kg
	Comp. B	SG 2000 Komp. B	1,000 kg / 5,000 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.

Injection strength less 30 mm is not recommendable due to the long curing time.

## 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

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.