

Biresin® 405 Elastomeric Casting resin, Shore A 66

Areas of Application

- Casting of flexible and wear-resistant mouldings and coatings
- Encapsulation of sensitive instruments for protection against mechanical and water influence
- Production of switch mats

Product Benefits

- Good adhesion on dry, clean surfaces
- Good flexibility and elongation
- High wear resistance

Description

- Basis Two-component-PUR-system
- Resin **Biresin® 405**, polyol, beige, unfilled
- Hardener **Biresin® G55**, MDI-based isocyanate, colourless, unfilled

Processing Data		Resin	Hardener
Individual Components		Biresin® 405	Biresin® G55
Viscosity, 25°C	mPas	approx. 11,000	approx. 250
Density	g/cm³	1,18	1,22
Mixing ratio resin to hardener	in parts by weight	100	33
		Mixture	
Mixed viscosity, 25°C	mPas	approx. 8,000	
Potlife, 500 g, RT	min	9	
Potlife, 500 g, 40°C	min	4	
Demoulding time, tool temperature 50°C	h	1	
Curing time, RT	d	3 - 7	

Physical Data (approx.-values)

Biresin® 405 resin		with hardener	Biresin® G55
Colour			beige
Density	ISO 1183	g/cm³	1.25
Shore hardness	ISO 868		A 66
Tear resistance	ISO 34	N/mm	6 - 7
Tensile strength	ISO 527	MPa	4 - 5
Elongation at break	ISO 527	%	240
Linear shrinkage (tool temperature 50°C)	internal	%	< 0.5
Abrasion resistance	ISO 4649	mm³	120

Packaging

Individual components	Biresin® 405 resin	200 kg; 25 kg net
	Biresin® G55 hardener	20 kg; 5 kg net

Processing

- The material temperature must be 18 - 25°C.
- Pay attention to dry conditions and dry mould surfaces while processing.
- The resin and hardener components are to be mixed thoroughly and poured immediately into previously released moulds (e. g. with Sika® Trennmittel 810 or 815 Quick resp. Sika® Trennwachs 818 (for more information see Technical Data Sheet).
- Porous surfaces (wood, gypsum) have to be well sealed before processing.

Storage

- Minimum shelf life is 12 month under room condition (18 - 25°C), when stored in original un-opened containers.
- After prolonged storage at low temperature, crystallisation of components may occur. This is easily removed by warming sufficient time to a maximum of 70°C. Allow to cool to room temperature before use.
- Containers must be closed tightly immediately after use to prevent moisture ingress. The residual material needs to be used up as soon as possible.

Health and Safety Information

For information and advice on the safe handling and storage of products, users should refer to the current Safety Data Sheet containing physical, ecological, toxicological and other safety related data.

Disposal considerations

Product Recommendations: Must be disposed of in a special waste disposal unit in accordance with the corresponding regulations.

Packaging Recommendations: Completely emptied packagings can be given for recycling. Packaging that cannot be cleaned should be disposed of as product waste.

Value Bases

All technical data stated in this Product Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

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