

Biresin® 408

Elastomeric Casting resin, Shore A 94

Areas of Application

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

Product Benefits

- Good mixable with mechanical stirrer
- Good flexibility and elongation
- High wear resistance

Description

- Basis Two-component-PUR-system
- Resin **Biresin® 408**, polyol, beige, unfilled
- Hardener **Biresin® G55**, MDI-based isocyanate, colourless, unfilled

Processing Data		Resin	Hardener
Individual Components		Biresin® 408	Biresin® G55
Viscosity, 25°C	mPas	approx. 9,000	approx. 250
Density	g/cm³	1.15	1.22
Mixing ratio resin to hardener	in parts by weight	100	66
		Mixture	
Processing temperature resin	°C	40	
Mixed viscosity, 40°C	mPas	approx. 2,300	
Potlife, resin and hardener at 40°C	s	100 - 110	
Demoulding time, Al-tool temperature 50°C	h	1	
Curing time, RT	d	3 - 5	

Physical Data (approx.-values)

Biresin® 408 resin		with hardener	Biresin® G55
Colour			beige
Density	ISO 1183	g/cm³	1.25
Shore hardness	ISO 868		A 94
Tear resistance	ISO 34	N/mm	45
Tensile strength	ISO 527	MPa	20
Elongation at break	ISO 527	%	340
Linear shrinkage (tool temperature 50°C, 20 mm thickness)	internal	%	0.85
Abrasion resistance	ISO 4649	mm³	70

Packaging

Individual components **Biresin® 408** resin 50 kg net
Biresin® G55 hardener 20 kg; 5 kg net



Processing

- The resin component must be mixed thoroughly before use.
- The material temperature must be 40°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.

Legal Notice

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