

## Biresin® 411

### Elastomeric Casting resin for mould making, Shore A 87

#### Areas of Application

- Casting of flexible moulds for direct casting of decorative and safety edges on panels e.g. for furniture

#### Product Benefits

- For processing of two-component dosage and mixing machines
- Fast curing
- Good flexibility and elongation
- Casting thickness up to 20 mm

#### Description

- Basis Two-component-PUR-system
- Resin **Biresin® 411**, polyol, yellowish, unfilled
- Hardener **Biresin® G53**, MDI-based isocyanate, amber, unfilled

Processing Data		Resin	Hardener
Individual Components		<b>Biresin® 411</b>	<b>Biresin® G53</b>
Viscosity, 25°C	mPas	approx. 1,000	approx. 175
Density	g/cm³	1.02	1.23
Mixing ratio resin to hardener	in parts by weight	100	48
		Mixture	
Mixed viscosity, 25°C	mPas	approx. 800	
Potlife, 500 g, RT	s	60	
Demoulding time, tool temperature 50°C	min	90	

#### Physical Data (approx.-values)

Biresin® 411 resin		with hardener	Biresin® G53
Colour			beige
Density	ISO 1183	g/cm³	1.1
Shore hardness	ISO 868		A 87
Tear resistance	ISO 34	N/mm	21
Tensile strength	ISO 527	MPa	14
Elongation at break	ISO 527	%	100

#### Packaging

Individual components **Biresin® 411** resin 200 kg; 50 kg net  
**Biresin® G53** hardener 200 kg; 20 kg net



## Processing

- The material temperature must be 18 - 25°C.
- The resin component must be mixed thoroughly before use.
- 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 water tight immediately after use and prevented from moisture. The residual material has 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

The information, and, in particular, the recommendations relating to the application and end-use of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.



**SCABRO**  
*Ideeen Krijgen Vorm*

Distributeur voor Nederland, België en Luxemburg: Scabro Composites

Vliegveld Valkenburg Wassenaarseweg 75-3265 NL - 2223 LA Katwijk The Netherlands

Tel: +31 (0) 71 4017246 Fax: +31 (0) 84 7402572 Email: info@scabro.com www.scabro.com