

# Biresin® G24 Fastcast resin, filled

# **Areas of Application**

- Casting of master and core models, negatives and mouldings of larger dimensions
- For high surface quality and mould precision

# **Product Benefits**

- Almost odourless
- Good mixable by hand, very good flowability
- Very low shrinkage
- Good adhesion to wooden materials
- Very good mechanically workable, e. g. by milling and drilling resp. additional finishing with fine abrasives to high-quality surfaces

#### **Description**

Basis Two-component-PUR-system Resin Biresin® G24, polyol, blue, filled

Hardener Biresin® G24, MDI-based isocyanate, beige, filled

Processing Data		Resin	Hardener
Individual components		Biresin® G24	Biresin® G24
Viscosity, 25°C	mPas	approx. 800	approx. 500
Density	g/ml	1.55	1.7
Mixing ratio resin to hardener	in parts by weight	100	15
		Mixture	
Mixed viscosity, 25°C	mPas	approx. 600	
Potlife, 200 g, RT	min	8	
Demoulding time, RT	h	> 2	
Curing time, RT	d	;	3

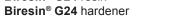
Physical Data (approxvalues)			
Biresin® G24 resin	with hardener		Biresin <sup>®</sup> G24
Colour			blue
Density	ISO 1183	g/cm³	1.7
Shore hardness	ISO 868	-	D 80
E-Modulus	ISO 178	MPa	4,500
Flexural strength	ISO 178	MPa	44
Compressive strength	ISO 604	MPa	80
Impact resistance	ISO 179	kJ/m²	7
Heat distortion temperature	ISO 75B	°C	75
Linear shrinkage	internal	%	0.16

### **Packaging**

Working packages Biresin® G24 A+B Pack 6 x 0.75 kg net resin +

6 x 0.75 kg net hardener in a box

Individual components Biresin® G24 resin 8 kg net 8 kg net





#### **Processing**

- The material temperature must be 18 25°C.
- Both components must be mixed thoroughly before use.
- It is necessary to pay attention to dry conditions and dry mould surfaces while processing.
- Porous surfaces (wood) have to be well sealed before.
- The resin mix can be poured, beginning at the lowest point into previously released moulds (e. g. with Sika® Trennmittel 810, 815 Quick resp. Sika® Trennwachs 818, for more information see Technical Data
- For cleaning of cured mouldings from wax residues we recommend Sika® Reinigungsmittel 5. Before application of other cleaners test their compatibility with resin.

#### **Storage**

- Minimum shelf life is 6 month under room conditions (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 up for a 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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