

## 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

Processing Data		Resin	Hardener
Individual components		<b>Biresin® G24</b>	<b>Biresin® G24</b>
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 (approx.-values)

Biresin® G24 resin			with hardener	Biresin® 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	<b>Biresin® G24 A+B Pack</b>	6 x 0.75 kg net resin + 6 x 0.75 kg net hardener in a box
Individual components	<b>Biresin® G24 resin</b> <b>Biresin® G24 hardener</b>	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 Sheet).
- 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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