

## Biresin® 407

### Elastomeric Casting resin for mould making, Shore A 85

#### Areas of Application

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

#### Product Benefits

- Good adhesion on dry, clean surfaces
- With primer **Icosit® KC330** for increased adhesion to metal surfaces
- Good flexibility and elongation
- High wear resistance
- Acceleration with **Biresin® HC 586** possible (for more informations see Technical Data Sheet)
- Dyeable with **Biresin® Farbpasten**

#### Description

- Basis Two-component-PUR-system
- Resin **Biresin® 407**, polyol, grey, unfilled
- Hardener **Biresin® G55**, MDI-based isocyanate, colourless, unfilled

Processing Data		Resin	Hardener
Individual Components		<b>Biresin® 407</b>	<b>Biresin® G55</b>
Viscosity, 25°C	mPas	approx. 800	approx. 250
Density	g/cm³	1.05	1.22
Mixing ratio resin to hardener	in parts by weight	100	53
		Mixture	
Mixed viscosity, 25°C	mPas	approx. 600	
Potlife, 500 g, RT	min	15	
Demoulding time, tool temperature 50°C	h	16 - 24	
Curing time, RT	d	3 - 7	

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

Biresin® 407 resin		with hardener	Biresin® G55
Colour			grey
Density	ISO 1183	g/cm³	1.15
Shore hardness	ISO 868		A 85
Tear resistance	ISO 34	N/mm	17
Tensile strength	ISO 527	MPa	13
Elongation at break	ISO 527	%	220
Linear shrinkage	internal	%	0.15
Abrasion resistance	ISO 4649	mm³	220

## Packaging

Individual components	<b>Biresin® 407</b> resin	10 kg net
	<b>Biresin® G55</b> hardener	20 kg; 5 kg net

## Processing

- The material temperature must be 18 - 25°C.
- The resin component must be mixed thoroughly before use.
- It is possible to add Biresin® Farbpaste to the hardener component before processing if required.
- 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

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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