

## Biresin® G27 - Resin with several hardeners

### Fastcast resin, unfilled

#### Application

- Casting of master and core models, negatives and mouldings of small up to medium dimensions
- Applicable for thinner and thicker layers
- For casting of art and crafts articles with excellent detail reproduction
- **Biresin® G27** with hardener **Biresin® G55** is especially suitable for spin production of hollow mouldings.

#### Properties

- Good wetting of fillers
- With hardener **Biresin® G27** for good flowability and short demoulding time
- With hardener **Biresin® G27 weiß** for increased flowability and short demoulding time
- With hardener **Biresin® G55** for shorter potlife and shorter demoulding time
- High quality of surface detail reproduction
- Low shrinkage and good dimensional stability
- Very good mechanically workable
- Very fine structure

#### Description

- Basis Two-component-PUR-system
- Resin **Biresin® G27**, polyol, beige, unfilled, approx. 70 mPas
- Hardener **Biresin® G27**, standard hardener, MDI-based isocyanate, brown, unfilled, approx. 60 mPas
- Hardener **Biresin® G27 weiß**, MDI-based isocyanate, white, unfilled, 13 mPas
- Hardener **Biresin® G55**, MDI-based isocyanate, colourless, unfilled, approx. 250 mPas

#### Processing Data

Mixing ratio <b>Biresin®G27</b> resin to hardener in parts by weight	<b>Biresin® G27</b>	<b>Biresin® G27 weiß</b>	<b>Biresin® G55</b>	
	100 : 100	100 : 100	100 : 80	
Mixing viscosity, 25°C	mPas	50	30	140
Potlife, 200 g, RT	min	2' 15''	2' 15''	1' 30''
Demoulding time, RT	min	> 20	> 20	> 15
Curing time, RT	d	3	3	3

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

<b>Biresin® G27</b> resin with hardener			<b>Biresin® G27</b>	<b>Biresin® G27 weiß</b>	<b>Biresin® G55</b>
Colour			beige	white	white
Density	ISO 1183	g/cm³	1,1		
Shore hardness	ISO 868	-	D 70	D 70	D 75
E-Modulus	ISO 178	MPa	1,300	900	1,500
Flexural strength	ISO 178	MPa	55	42	60
Tensile strength	ISO 527	MPa	32	22	40
Elongation at break	ISO 527	%	7	10	7
Impact resistance	ISO 179	kJ/m²	25	60	50
Heat distortion temperature	ISO 75B	°C	80	75	75
Linear shrinkage	internal	%	0.2		

## Delivery

Individual components	<b>Biresin® G27 resin</b>	50 kg; 20 kg; 5 kg; 1 kg net
	<b>Biresin® G27 hardener</b>	50 kg; 20 kg; 5 kg; 1 kg net
	<b>Biresin® G27 weiß hardener</b>	20 kg; 5 kg; 1 kg net
	<b>Biresin® G55 hardener</b>	20 kg; 5 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.
- 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 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.

## Precautions

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.

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 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 proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users should always refer to the most recent issue of the Technical Data Sheet for the product concerned, copies of which will be supplied upon request.



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