

Biresin® G27 LV Fastcast resin, filled

Areas of 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
- Casting of higher thicknesses (> 20 mm) is possible with addition of 300 pbw fillers to 100 parts resin and 100 parts hardener, for thinner layers up to 200 parts

Product Benefits

- Very good flowability
- Good wetting of fillers
- Short demoulding time, at mouldings with thin walls too
- 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 LV**, polyol, beige, unfilled
- Hardener **Biresin® G26**, MDI-based isocyanate, reddish-brown, unfilled

Processing Data		Resin	Hardener
Individual components		Biresin® G27 LV	Biresin® G26
Viscosity, 25°C	mPas	approx. 50	approx. 25
Density	g/ml	1.0	1.15
Mixing ratio resin to hardener	in parts by weight	100	100
		Mixture	
Mixed viscosity, 25°C	mPas	approx. 35	
Potlife, 200 g, RT	min	2' 20''	
Demoulding time, RT	min	> 15	
Curing time, RT	d	3	

Physical Data (approx.-values)

Biresin® G27 LV resin			with hardener	Biresin® G26	
Colour				beige	
Density	ISO 1183	g/cm³		1.1	
Shore hardness	ISO 868	-		D 70	
E-Modulus	ISO 178	MPa		1,050	
Flexural strength	ISO 178	MPa		45	
Tensile strength	ISO 527	MPa		30	
Elongation at break	ISO 527	%		18	
Impact resistance	ISO 179	kJ/m²		23	

Packaging

Individual components	Biresin® G27 LV resin	20 kg; 5 kg; 1 kg net
	Biresin® G26 hardener	200 kg; 50 kg; 20 kg; 5 kg; 1 kg net

Processing

- The material temperature must be 18 - 25°C.
- Both components must be shaken well 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 12 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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