

Biresin® RG50

Low pressure RIM-system, rubber-like

Areas of Application

- Manufacture of rubber-like, flexible prototype parts
- Manufacture of sealings, bellows and other rubber-like mouldings
- Manufacture of thinwalled mouldings with complex structure

Product Benefits

- Simulation of rubber and soft PVC
- Fast curing with good flowability
- Short demoulding time
- Very flexible

Description

- Basis Two-component-PUR-system
- Resin **Biresin® RG50**, polyol, black, unfilled
- Hardener **Biresin® G53**, MDI-based isocyanate, amber, unfilled

Processing Data		Resin	Hardener
Individual components		Biresin® RG50	Biresin® G53
Viscosity, 25°C	mPas	approx. 1,200	approx. 175
Density	g/cm³	1.06	1.23
Mixing ratio resin to hardener	in parts by weight	100	18
Mixing ratio resin to hardener	in parts by volume	100	15
		Mixture	
Potlife, RT	s	100	
Demoulding time, plastic mould, RT	min	15	
Curing time, RT	d	approx. 1	

Physical Data (approx.-values)

Biresin® RG50 resin			Biresin® G53
		with hardener	
Density	ISO 1183	g/cm³	1.1
Shore hardness	ISO 868	-	A 70
Tensile strength	ISO 527	MPa	5
Elongation at break	ISO 527	%	200
Tear resistance	ISO 34	N/mm	9

Packaging

Individual components	Biresin® RG50 resin	20 kg net
	Biresin® G53 hardener	20 kg; 10 kg net

Processing

- The material and processing temperature must be 18 - 25°C. Preheated moulds shorten the demoulding time.
- Before use the resin component must be mixed thoroughly through stirring with as suitable mixing device.
- For processing a two-component dosage mixing machine is necessary which conforms to reactivity of resin and volume of casting parts.
- Machine vessel for resin component (part A - polyol) must have a mixing unit and heating.
- Machine vessel for hardener component (Part B - isocyanate must be moisture tight, e. g. by installation of a silicagel filter.
- Prior to casting, ensure moulds are thoroughly released. If the application of silicone free release agents is necessary, Sika® Trennmittel 810 and 815 Quick or Sika® Trennwachs 818 (for more information see Technical Data Sheet) are recommended.

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 regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Material Safety Data Sheets 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

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 accordance with Sika's recommendations. 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 user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.



SCABRO
Ideeën Krijgen Vorm

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