

Product Type **High Quality PU Elastomer**
 Resin **MG 65 Comp. A**
 Hardener **MG 65 Comp. B**
 Colour **Black / Neutral**

Applications

- Soft Automotive Parts
- Scenography
- Leather Look Reproduction
- Film & TV Props

Properties

- 65 Shore A
- Durable
- Resilient
- Can be used with in mould paint

Processing Data

Product		Mixture MG 65 A/B	Resin MG 65 Comp. A	Hardener MG 65 Comp. B
Colour		Black / Neutral	Black	Hazy Yellow
Mixing Ratio	P.B.W		100	100
	Volume			
Viscosity at 25°C	cPs		350 - 750	1500 - 2500
Density at 20°C	g / cm ³		1.03 +/- 0.02	1.10 +/- 0.02
Pot Life 100g / 20°C	Sec.	90 - 150	-	-
Demould Time	Mins.	25 - 35	-	-

Physical Data

Properties	Test Method	Unit	Value
Shore Hardness		Shore A	65 - 70
Specific Gravity			1.05
Tensile Strength		psi	-
Elastic Modulus		psi	-
Elongation		%	-
Tear Strength		pli	-

Sales Units (Packages)

Units	Resin	MG 65 Black Comp. A	25.00 kg
		MG 65 Neutral Comp. A	25.00 kg
	Hardener	MG 65 Comp. B	25.00 kg

Processing Instructions

MG 60 resin may require some agitation before use, in order to effect redispersion of any pigment. Recirculation of both components from the barrel, through the machine's heater blocks and back to the barrel, is recommended when using standard 2:1 or 1:1 transfer pumps, in order to prime the materials and machine. 30 minutes of recirculation to warm the components to around 40°C will be adequate.

MG 60 A / B is processed through specially designed dispensing equipment having accurate metering pumps for the two components. The components should be maintained at 35-55°C and mixed and dispensed by the appropriate equipment, on which our technical staff can advise.

Ambient conditions should be suitable for PU processing, with particular emphasis on humidity is 90% or above or the substrate temperature is less than 3°C above the local dew point

In General

In-mould paint can be used to achieve exact colours, with further finishing effects applied afterwards. With good release agent items can be demoulded in five minutes.

Care should be taken when demoulding items as the hardness and strength of the elastomer is still developing. Please allow up to 7 days for the achievement of full hardness. Use of release agent is required. Silicone release agents specifically designed for use with polyurethane are recommended. If in any doubt, please consult **ebalta** Distribution Technical Department.

Low temperature will slow the rate of cure and so the end-user should avoid casting/curing this system in areas where the temperature is likely to fall below 15°C at any time.

Handling Precautions

For further questions, relating to processing and application, please contact our technical department. The end-user should always familiarise themselves with the material safety datasheets before use of these materials.

Storing

The polyol and isocyanate described in this instruction sheet have six-month shelf lives provided they are stored at 20 - 25°C in a dry place, out of direct sunlight and in suitable sealed containers, preferably those in which they are supplied. Neither component should be stored at a temperature above 40°C.

tooling resins	.	blocks	.	ancillaries	.	silicone
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Shelf life is indicated on the labels.

Safety Measure

Please follow the precaution instructions of the Government Safety Organisation of the chemical industry when working with this material. Please follow safety advice.

Waste Disposal

According to arrangement with local authorities cured material can be disposed as domestic or commercial waste. Non-cured products are waste which is subject to inspection and has to be disposed accordingly. In case of further questions please do not hesitate to contact our Department for Product Safety.

The instructions and recommendations are given in good faith and are based on long experience and careful tests. Since the conditions of use are beyond our control, and due to versatility of applications and working methods, we can't give any guarantee. All information are non-binding and are no guarantee for special characteristics or properties of the product. Despite information given from **ebalta** the customer has to make his own tests regarding applications and processing. If any special warranty is requested, written agreement on this subject is essential.

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