

# Ebalta MG 804, 804 GF / MG 804-1

Polyurethane

Ebalta Kunststoff GmbH

## Message:

This product is a polyurethane system.

Preferential processing in usually used vacuum pouring plants.

Maximum wall thicknesses of the parts: from 5 - 10 mm.

### Applications

High quality prototypes, like ABS

High quality prototypes, like PA

### Properties

long potlife

very well castable

good impact strength

high rigidity adjustable

easily dyeable

low aggressiveness against silicones

General Information			
Features	Good Colorability		
	Good Impact Resistance		
	High Rigidity		
Uses	Prototyping		
Appearance	White		
Processing Method	Casting		
Physical	Nominal Value	Unit	Test Method
Molding Shrinkage	0.10	%	Internal Method
Hardness	Nominal Value	Unit	Test Method
Shore Hardness (Shore D)	76 to 80		ISO 7619
Mechanical	Nominal Value	Unit	Test Method
Flexural Modulus	2450 to 2750	MPa	ISO 178
Flexural Stress	73.0 to 83.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Unnotched Impact Strength	15 to 19	kJ/m <sup>2</sup>	ISO 179
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (0.45 MPa, Unannealed)	86.0 to 92.0	°C	ISO 75-2/B
Glass Transition Temperature	90.0	°C	TMA
Thermoset	Nominal Value	Unit	
Thermoset Components			
Hardener	Mix Ratio by Weight: 150		
Resin	Mix Ratio by Weight: 100		
Post Cure Time (60°C)	4.0	hr	

Uncured Properties	Nominal Value	Unit
Density (20°C)	1.08 to 1.12	g/cm <sup>3</sup>
Curing Time (60°C)	0.75 to 1.0	hr
Pot Life <sup>1</sup> (20°C)	7.0 to 9.0	min
NOTE		
1.	200 g	

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