

Rapid Prototyping. Rapid Manufacturing. Rapid Tooling. Low-pressure RIM casting systems (RIM)

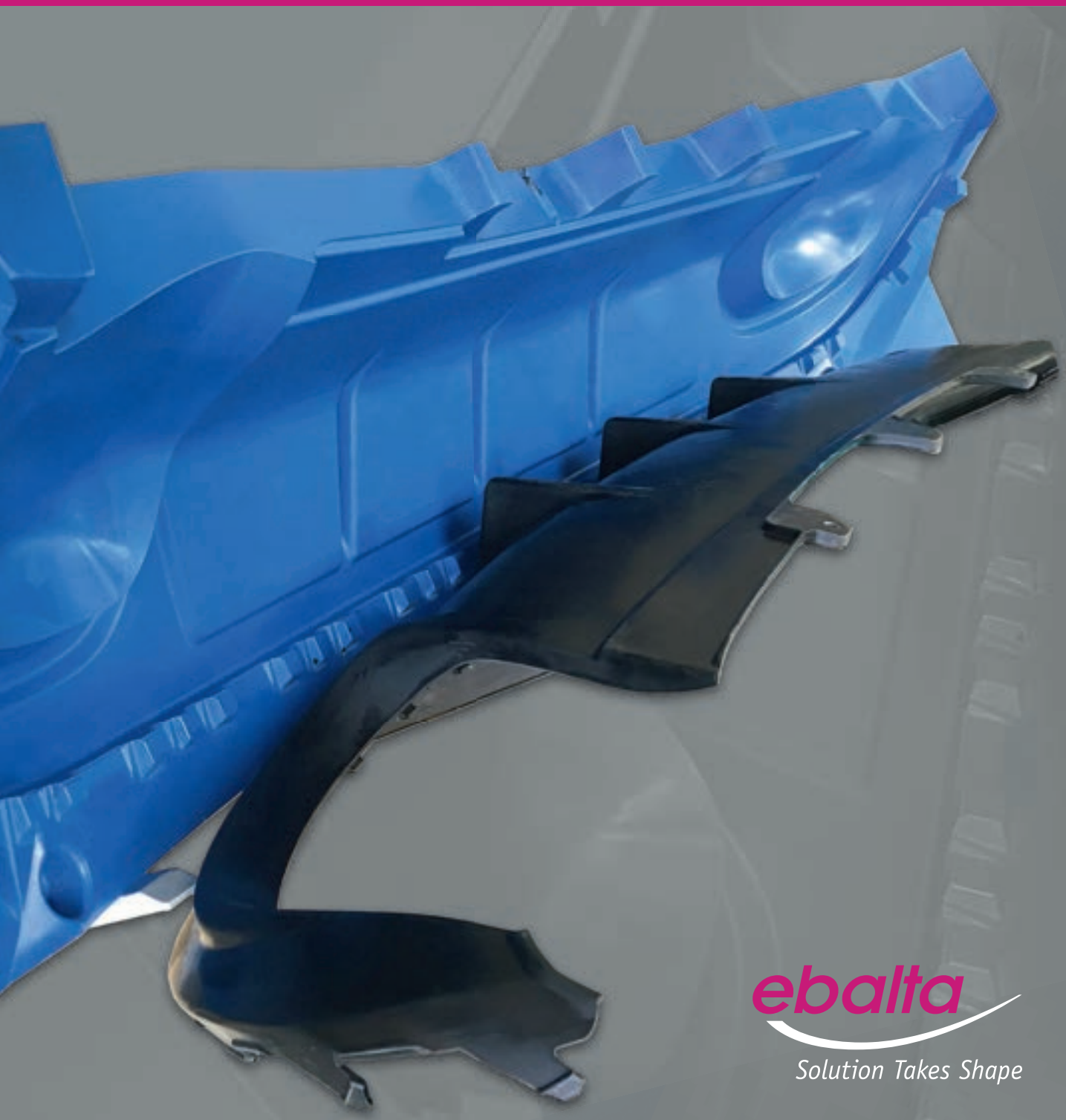
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Mixing table RIM casting systems

Properties	Colour	Mixing ratio p.b.w.	Properties in volume	Pot life in sec.	Curing time in min.	Viscosity of mixture in mPas	*Shore D	*Flexural modulus of elasticity in Mpa	*Flexural strength in Mpa	*Flexural strength at breakage in %	Impact resistance (Charpy) in kJ/m ²	Heat resistance HDT °C	*TG in TMA TG in °C	
Semi rigid systems														
MG 400 / PUR 19	very low E-modulus, very high impact strength, low viscosity	black	100 : 80	100 : 69	50 – 60	20 – 30	750	74	630	28	7,6	n.b.*	n.a.	65
MG 475 / PUR 19	low E-modulus, very high impact strength, low viscosity	black	100 : 90	100 : 77	100 – 120	30 – 40	750	76	1050	43	7,2	n.b.*	n.a.	74
Hard systems														
MG 425 / PUR 19	high impact resistance, low viscosity	black	100 : 90	100 : 77	50 – 60	20 – 30	750	75	1550	62	6,8	80	73	80
MG 426 A / B	long potlife, high E-modulus	black	100 : 100	100 : 89	150 – 160	1,5 – 2 Std.	700	80	2185	85	7,0 n.b.*	42	95	n.a.
MG 453 A / B	short demoulding time, high heat resistant	black	100 : 75	100 : 66	55 – 66	10 – 15	n.a.	80	1640	65	7,4	38	102	124
Glassfibre systems														
MG 453 GF A / B	glassfibre filled, high heat resistance	black	100 : 60	100 : 61	55 – 60	10 – 15	n.a.	84	2510	90	6,2	18	108	124
Flame retardant systems														
MG 321 FR-S A / B	self-extinguishing, UL 94 V0 and 5 VA high heat resistance 120°C classification accord. to DIN 5510-2	black/natur	100 : 50	100 : 51	50 – 60	15 – 20	2000	80	2000	64	7,2	21	120	133
Lightly foaming systems														
MG 454 A / B	lightly foaming, density under 1, glassfibre filled	black	100 : 60	100 : 57	60 – 80	**5 – 15	n.a.	77	2100	57	6,3	11	95	107
Comp. A = Polyole; Comp. B = Isocyanate individual pot life and colours on enquiry n.b. non breaking* max. values will be reached after post curing according to the technical data sheets ** heated moulds (40-50 C°)														

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