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# Mixing table vacuum casting systems

Properties		Colour	Mixing ratio p.b.w.	Pot life min.	Mould temperature in °C	Curing time in min.	*Shore hardness	*Flexural modulus in Mpa	*Flexural strength in Mpa	*Flexural strength at breakage in %	*Impact resistance (Charpy) in kJ/m²	*Heat resistance HDT °C	*Glass transition temperature T <sub>g</sub> °C
<b>Hard systems</b>			<b>Processing</b>				<b>Physical data</b>						
<b>MG 703 / Z 400</b>	high impact strength	white	<b>100 : 31</b>	8 – 12	40 – 60	40 – 45	D 77	1340	52	–	77	81	105
<b>MG 707 / Z 400</b>	middle E-modulus, HDT 107°C	white	<b>100 : 30</b>	8 – 12	40 – 60	40 – 45	D 79	1500	63	–	24	107	120
<b>MG 804 A / B</b>	high impact strength, very well castable, long pot life	white / black	<b>100 : 100</b>	10 – 13	60 – 70	45 – 60	D 78	2270	90	6,2	39	71	82
<b>MG 804 A / MG 804-1 B</b>			<b>100 : 100</b>	8 – 11	60 – 70	45 – 60	D 75	1975	80	6,3	31	82	87
<b>MG 804 A / 804 GF A / MG 804-1 B</b>	glassfibre filled, E-modulus variable	white / black	<b>100 : 100 : 150</b>	7 – 9	60 – 70	45 – 60	D 78	2600	78	4,9	17	89	90
<b>MG 804 GF A / MG 804-1 B</b>	glassfibre filled, very high E-modulus 4400 Mpa	white / black	<b>100 : 50</b>	7 – 9	60 – 70	45 – 60	D 80	4400	85	2,5	13	76	82
<b>MG 815 A / B</b>	high heat resistance, HDT 140°C, very high impact resistance	black	<b>100 : 70</b>	5 – 7	70	40 – 60	D 80	2100	100	8,6	75	130	122
<b>MG 815-1 A / MG 815 B</b>			<b>100 : 70</b>	5 – 7	70	40 – 60	D 80	2100	100	9	63	140	135
<b>MG 815 A / MG 815 GF B</b>	glassfibre filled, high rigidity	black	<b>100 : 90</b>	6 – 8	60 – 70	40 – 60	D 80	2510	87	7,8	22	–	122
<b>MG 815 A / MG 815 FR B</b>	flame retardant acc.to UL 94 V0,	black	<b>100 : 120</b>	5 – 7	70	40 – 60	D 83	2770	70	4,5	18	120	122
<b>MG 807 FR A / B</b>	flame retardant acc.to UL 94 V0, very high E-modulus	beige	<b>100 : 100</b>	6	40 – 70	35 – 45	D 85	4000	70	2,2	7,3	52	79
<b>Semi-hard system</b>													
<b>MG 822 A / B</b>	high impact resistance, high heat resistance, medium E-modulus, dyeable	transparent/black	<b>100 : 45</b>	7	70	60	D 72	1150	45	9,0	no break	120	n.a.

Flexible systems				Hours		Elongation %		Tear resistance		Tensile strength MPa		
<b>GM 900-1 A / B</b>	like rubber/ EPDM Shore hardness adjustable 13 - 45 Shore A	black / beige	<b>100 : 10</b>	17 – 27	RT	7 – 10	A 13	750	ISO 37	2,2 kN/m with incision		1,1
<b>GM 951-1 A / B</b>			<b>100 : 10</b>	17 – 27	RT	7 – 10	A 45	980	ISO 37	5,5 kN/m with incision		2,0
<b>GM 956 A / GM 956-30 B</b>	high tear strength, easily dyeable, free of mercury, shore hardness (flexibility) adjustable A 30- 80	transparent	<b>100 : 195</b>	20 – 30	70 **	3 – 4	A 30	2000	ISO 37	6,7 kN/m with incision		2,2
<b>GM 956 A / GM 956-80 B</b>			<b>100 : 80</b>	15 – 20	70 **	2 – 3	A 83	600	ISO 37	15 kN/m with incision		8
<b>GM 956-90 A / B</b>	shore A hardness 90, excellent flow properties, easily dyeable, high tear strength, odourless, free of mercury	transparent	<b>100 : 80</b>	15 – 18	70 **	1 – 2	A 90	280	ISO 37	48 kN/m		7
<b>GM 973 A / B</b>	high Shore A hardness	beige / black	<b>100 : 15</b>	12 – 15	RT	12 – 16	A 90	550	ISO 527	55 kN/m		16

\* max. values will be reached after post curing according to the technical data sheets

\*\* processing at room temperature possible

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