

## Biresin® U1305 B with Biresin® G55 B

### Elastomeric casting resin for foundry pattern making, Shore D 65

#### Areas of Application

- Casting of abrasion and impact resistant mouldings and tools, e. g. smaller core boxes
- Facecasting of tough-elastic coatings

#### Product Benefits

- Easy to mix by hand or with mechanical stirrer
- Favourable physiology
- Very good flowability
- Good abrasion resistance
- Good impact resistance and tensile strength
- Dyeable with **Biresin® Colour Paste**

#### Description

- Basis Two component PUR system
- Component A **Biresin® U1305 B, A -component**, polyol, beige, unfilled
- Component B **Biresin® G55 B, B-component**, MDI-based isocyanate, colourless

Processing Data		Component A	Component B
Individual components		<b>Biresin® U1305 B</b>	<b>Biresin® G55 B</b>
Viscosity, 25°C	mPa.s	~ 600	~ 250
Density	g /ml	1.03	1.22
Mixing ratio A : B	in parts by weight	100	95
		Mixture	
Mixed viscosity, 25°C	mPa.s	~ 550	
Potlife, 500 g, RT	min	6 - 8	
Demoulding time, RT	h	12 - 16	
Curing time, RT	d	3 - 5	

#### Physical Data (approx. values)

Biresin® U1305 B (A)		with component B	Biresin® G55 B
Colour			ivory
Density	ISO 1183	g/cm³	1.2
Shore hardness	ISO 868	-	D 65
Tear resistance	ISO 34	N/mm	80
Tensile strength	ISO 527	MPa	25
Elongation at break	ISO 527	%	190
Linear shrinkage	internal	%	0.18
Abrasion resistance	ISO 4649	mm³	130

#### Packaging

Individual components	<b>Biresin® U1305 B</b> , beige, (A)	12 kg; 6 kg net
	<b>Biresin® U1305 B</b> , black, (A)	12 kg net
	<b>Biresin® G55 B</b> (B)	225 kg; 20 kg; 5 kg net

## Processing

- The material, processing and mould temperature must be 18 - 25°C.
- Before use, component A must be mixed thoroughly.
- It is possible to add Biresin® Farbpaste to component B before processing if required.
- Pay attention to dry conditions and dry mould surfaces while processing.
- The resin and hardener components are to be mixed thoroughly and poured immediately into previously released moulds (e.g. with Sika® Liquid Wax-815 resp. Sika® Pasty Wax-818; for more information see product data sheet).
- Porous surfaces (wood, gypsum) have to be well sealed before processing.

## 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 on the safe handling, storage and disposal of chemical products, users shall refer to the most recent Safety Data Sheet (SDS) 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

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