Tooling & Composites

Product Data Sheet
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Biresin® G26
Fastcast resin, unfilled

Areas of Application

- Casting of master and core models, negatives and mouldings of small up to medium dimensions
- Applicable for thinner and thicker layers
- For casting of art and crafts articles with excellent detail reproduction
- Applicable unfilled and filled

Product Benefits

- Very good flowability
- Very good wetting of fillers
- Short demoulding time
- Applicable with high admixture of filler; up to 400 parts of TE-Filler
- Good adhesion to wooden materials
- Very fine structure
- Very good mechanically workable

Description

Basis	Two-component-PUR-system
Resin (A)	**Biresin® G26**, polyol, beige, unfilled
Hardener (B)	**Biresin® G26**, MDI-based isocyanate, reddish-brown, unfilled
Hardener (B)	**Biresin® G27**, MDI-based isocyanate, brown, unfilled
Filler	**TE-Füller**, aluminium hydroxide powder, white, grain 0-0.032 mm

Processing Data		**Resin (A)**	**Hardener (B)**	**Filler**	**Hardener (B)**
Individual components		**Biresin® G26**	**Biresin® G26**	**TE-Füller**	**Biresin® G27**
Viscosity, 25°C	mPas	~ 110	~ 25	-	~ 60
Density	g/ml	1.0	1.15	2.4	1.14
Mixing ratio	in parts by weight	100	100	400	100
		Mixtures			
Mixed viscosity, 25°C	mPas	~ 70		flowable	~ 130
Potlife, 200 g, RT	min	3 - 4		3 - 4	1´ 40´´
Demoulding time, RT	min	> 30		> 30	> 15
Curing time, RT	d	3			

Physical Data (approx. values)					
Biresin® G26 resin (A)		with hardener (B)	**Biresin® G26**	**G26 + TE-Füller**	**Biresin® G27**
Colour			beige	light beige	beige
Density	ISO 1183	g/cm³	1.1	1.65	1.1
Shore hardness	ISO 868	-	D 70	D 80	D 72
E-Modulus	ISO 178	MPa	1,250	4,400	1,200
Flexural strength	ISO 178	MPa	40	30	71
Tensile strength	ISO 527	MPa	30		
Elongation at break	ISO 527	%	3		
Impact resistance	ISO 179	kJ/m²	20		24
Compressive strength	ISO 604	MPa		45	
Heat distortion temperature	ISO 75B	°C	75	80	104*

* values after post curing: RT + 4 h / 80°C

Packaging

Individual components	**Biresin® G26** resin (A)	50 kg; 20 kg; 5 kg; 6 x 1 kg in a box net
	Biresin® G26 hardener (B)	50 kg; 20 kg; 5 kg; 6 x 1 kg in a box net
	Biresin® G27 hardener (B)	20 kg; 5 kg; 6 x 1 kg in a box net
	TE-Füller	25 kg net

Processing

- The material, processing and mould temperature must be from 18 to 25°C.
- Both components must be shaked well before use.
- Pay attention to dry conditions and dry mould surfaces while processing.
- Mix the fillers if necessary thorougly in the resin (A) or half in both components before mixing the components.
- Porous surfaces (wood) have to be well sealed before.
- The resin mix can be poured, beginning at the lowest point into previously released moulds (e. g. with Sika® Liquid Wax-815 resp. Sika® Pasty Wax-818, for more information see Product Data Sheet).
- For cleaning of cured mouldings from wax residues we recommend Sika® Reinigungsmittel 5. Before application of other cleaners test their compatibility with resin.

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 safetyrelated 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.

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