

Biresin® G32 EP-Casting resin, for backfilling

Areas of Application

- For backfilling in foundry pattern and mould making

Product Benefits

- Good flowability and long potlife
- High casting thickness, unfilled up to 40 mm, dependent on thermal conductivity of the mould material
- Can be filled with high contents, e. g. of Aluminium grit up to 100:100 pbw per resin component
- Casting thicknesses more than 100 mm are possible with component B **Biresin® F2**, filled with Aluminium grit
- Good mechanical properties, e. g. hardness

Description

- Basis Two component PUR system
- Component A **Biresin® G32**, epoxy resin, green
- Component B **Biresin® F4**, amine, colourless
- Component B **Biresin® F2**, amine, yellowish

Processing Data		Component A	Component B	
Individual components		Biresin® G32	Biresin® F4	Biresin® F2
Viscosity, 23°C	mPa.s	~ 14.000	< 10	~ 330
Density	g/ml	1.7	0.87	0.95
Mixing ratio A : B	in parts by weight	100	7	17
		Mixtures		
Mixing viscosity, 23°C	mPa.s		~ 2,100	~ 2,600
Potlife, 500 g, RT	min		70	180
Demoulding time, RT	h		24	48

Physical Data (approx. values)

Biresin® G32 (A)	with component B	Biresin® F4	Biresin® F2
Density	ISO 1183 g/cm ³	1.6	
Shore hardness	ISO 868 -	D 90	D 86
E-Modulus	ISO 178 MPa	6,100	3,100
Flexural strength	ISO 178 MPa	70	51
Compressive strength	ISO 604 MPa	112	71
Impact resistance	ISO 179 kJ/m ²	8	10
Heat distortion temperature	ISO 75B °C	51	48
Linear shrinkage	internal %	0.12	0.26

Packaging

Individual components	Biresin® G32 (A)	25 kg; 5 kg net
	Biresin® F4 (B)	2.5 kg net
	Biresin® F2 (B)	15 kg; 2.5 kg net

Processing

- The material, processing and mould temperature must be from 18 to 25°C.
- Component A must be mixed thoroughly before use.
- Take care that the two components are mixed thoroughly without air entrapment.
- The resin mix can be poured, beginning at the lowest point into previously released moulds (e. g. with Sika® Trennmittel 810, 815 Quick resp. Sika® Liquid 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 condition (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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