



## DATA SHEET: VACUUM CASTING RESIN SG95

<b>Description:</b>		Similar to ABS	
<b>Features:</b>		Excellent all-round properties, strong, optical properties	
<b>Suitable for:</b>		Snap fits, low temperature application, colour matching	
<b>Cured Properties</b>		<b>Test/ISO standard where applicable</b>	
Colour	Colourless		
Transparency	Transparent		
Shore hardness	At 23 °C	82 D	868
	At 60 °C	77 D	
	At 80 °C	74 D	
Flexural strength	88.6 N/mm <sup>2</sup>		178
Flexural modulus	2195 N/mm <sup>2</sup>		178
Tensile strength	54 N/mm <sup>2</sup>		R 527
Tensile modulus	2521 N/mm <sup>2</sup>		R 527
Izod impact	7.3 kJ/ m <sup>2</sup>		180
Yield strength	64.2 N/mm <sup>2</sup>		R 527
Elongation yield	6%		
Elongation at break	12%		R 527
Tear Strength	Not measured		34
Thermal Conductivity	0.208 W/mK		BS 874
Heat deflection temperature	72 °C		(test piece 110 mm x 12.7 mm x 6.4 mm)
Glass transition temperature	85 °C		
Optical Properties	Refractive Index 1.51 Diffused lights 0.9	Transmissivity 88.1 Paralleled lights 87.2	
<b>Processing Information</b>		<b>Notes</b>	
Viscosity	Part A	1300 cPs	At 25 °C
	Part B	130 cPs	
Specific gravity	Part A	1.07	At 25 °C
	Part B	1.19	
Mix ratio A:B	100:150		By Weight
Mixing Time	45 s to 60 s		
Resin temperature	40 °C		Heating Chamber
Mould temperature	70 °C		Heating Chamber
Curing temperature	70 °C		Heating Chamber
Curing time in mould	45 min		
Pot life	300 s		100 g at 25 °C
Post curing process	None		
Typical shrinkage	0.2%		

The information in this data sheet is provided for general guidance only and must not be relied upon as a definitive statement of the product's properties or suitability. CBM will not be liable for the consequences of any decision by you to use the product and you must conduct your own testing to determine whether or not the product is suitable for your needs.