

TECHNICAL DATA SHEET

ALCHEMIX[®] MG 1300 A/B

Fast-cure polyurethane adhesive system

MG 1300 is an odourless two component polyurethane adhesive. MG 1300 can also be used unfilled in prototyping and model-making areas, or filled with mineral or metallic fillers in pattern-making. The colour of MG 1300 is designed to camouflage the bond line when used as an adhesive for model board M 1300.

Main Features

Coloured as model board M 1300 solvents

Odourless – contains no hazardous

Good thermal resistance

Very low viscosity

Mixing Ratio by weight

**MG 1300 A: MG 1300 B
100 : 100**

Product Data

	MG 1300 A	MG 1300 B	MIXTURE
Material	polyol	Isocyanate	
Appearance	red liquid	Brown liquid	red liquid
Density @ 25°C	0.99 g/ml	1.12 g/ml	1.06 g/ml
Viscosity @ 25°C	175-180 mPa.s	25-35 mPa.s	80 mPa.s
Pot life (200 g) @ 20°C			140-160 seconds
Handling time (20 deg C)			25-30 minutes

Surface Preparation

Ensure that the surface is clean and dry and free of dust and swarf.

Resin Preparation

Shake the Part A can thoroughly in order to homogenise the resin. For best results, make sure the two components are at least 20°C before mixing.

Mixing instructions

Add the correct amount of Part B to the Part A and stir for 15-30 seconds. Brush, spread or spray on to both faces to be bonded. Bring the faces together promptly. If necessary, clamp the boards together to ensure a perfect bond.

Curing

The laminated board can generally be handled in 15-30 minutes at room temperature. The precise handling time will vary with temperature. Maintain temperature at a minimum 20 C during cure.

Cured Properties

Property	Cured 48 hrs @ 25°C
Shore hardness (D)	70-75
Linear Shrinkage (500 x 50 x 10 mm)	0.05% (150% A91)
Tensile Strength ISO 527-2:1993	20-25 MPa
Elongation @ break ISO 527-2:1993	10-15%
Flexural Strength ISO 178:1993	30-35 MPa
Flexural Modulus ISO 178:1993	1000-1350 MPa
Glass Transition (Tg) (DSC)	110°C

Storage

Store both components A and B at 20-25°C. The Part B may crystallise partially or completely if not stored at above 20°C. The two components are moisture sensitive (like all PU's) **KEEP THE PACKING TIGHTLY SEALED WHEN NOT IN USE.** Moisture absorption will cause excessive aeration in cast parts. Shelf life is 6 months unopened.

Packaging

MG 1300 A	1 kg	5 kg	20 kg
MG 1300 B	1 kg	5 kg	20 kg

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