

## PRODUCT DATA SHEET

# SikaBiresin<sup>®</sup> RG826 (RIM 826)

LOW PRESSURE RIM SYSTEM WITH GOOD IMPACT RESISTANCE – SIMULATION OF PE / PP

## APPLICATIONS

- Manufacture of housings and coverings
- Manufacture of impact resistant technical parts, e.g. tuning parts for cars
- Manufacture of thin walled mouldings with complex structure

## MAIN PROPERTIES

- Simulation of PE / PP
- Good impact resistance
- Fast curing with good flowability
- Good temperature resistance
- Good ability for bonding and painting

## DESCRIPTION

Basis	Two component polyurethane system
Component A	<b>SikaBiresin<sup>®</sup> RG826</b> , polyol, black
Component B	<b>SikaBiresin<sup>®</sup> RG902</b> , MDI-based isocyanate, straw yellow

## PHYSICAL PROPERTIES

		Polyol (A)	Isocyanate (B)
Components		<b>SikaBiresin<sup>®</sup> RG826</b>	<b>SikaBiresin<sup>®</sup> RG902</b>
Viscosity, 25 °C	mPa.s	~ 2,000	~ 600
Density, 25 °C	g/cm <sup>3</sup>	1.05	1.20
Mixing ratio A:B	in parts by weight	100	100
Mixing ratio A:B, 25 °C	in parts by volume	100	88
		Mixture	
Colour		black	
Viscosity, 25 °C	mPa.s	~ 800 – 1,200	
Pot life, 25 °C, 100 g	s	~ 80 – 100	
Demoulding time, 23 °C	min	~ 25	
Maximal casting thickness	mm	10	

## MECHANICAL PROPERTIES

approx. values

Density, 25 °C	ISO 2781	g/cm <sup>3</sup>	1.12
Shore hardness	ISO 868	–	D 73*
Flexural modulus	ISO 178	MPa	800*
Tensile strength	ISO 527	MPa	28*
Elongation at break	ISO 527	%	50*
Impact resistance	ISO 179	kJ/m <sup>2</sup>	100*
Linear shrinkage on parts at 23°C :			
- thickness 2 to 3 mm			4 – 6*
- thickness 4 to 5 mm	Internal test	mm/m	6 – 8*
- thickness 5 to 10 mm			8 – 10*

## THERMAL AND SPECIFIC PROPERTIES

approx. values

Using temperature		°C	-40 – 90*
Glass transition temperature	ISO 11359	°C	95*
Coefficient of thermal expansion, [0 to 90 °C)	ISO 11359	10 <sup>-6</sup> K <sup>-1</sup>	140*

\* values after post curing: 12 h / 80 °C

## PACKAGING UNITS

- |                                             |                |
|---------------------------------------------|----------------|
| ■ Polyol (A), <b>SikaBiresin® RG826</b>     | 20 kg / 200 kg |
| ■ Isocyanate (B), <b>SikaBiresin® RG902</b> | 20 kg / 200 kg |

## PROCESSING DATA

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- The material and processing temperature should be at least 18 – 25 °C, mould temperature at least 20 – 60 °C.
- Component A must be stirred thoroughly before use.
- For processing, a suitable two-component meter mix and dispense machine should be used.
- The machine should be conform to the reactivity of the material and the volume of the casted parts. A static-dynamic or dynamic mixing unit is recommended.
- The machine vessel for component A must have a mixing unit. Furthermore, a heating unit for the machine vessels of both components is recommended.
- Machine vessel for both components must be moisture tight, e.g. by installation of a silicagel filter.
- Recommended release agents are Sika® Liquid Wax-852 or Sika® Liquid Spray-872. For more information, see Product Data Sheets of the release agents.
- Pay attention to dry conditions and dry mould surfaces (moisture content of wood < 7 %) while processing.
- Increased mould temperatures are decreasing the demoulding time.
- Further post curing of the demoulded part can improve the final mechanical properties. The final thermal properties depend on the process and production conditions.
- Depending on the geometry and weight of the part, it is recommended to use a conformer while post curing.
- Before overpainting, the parts have to be grinded or sandblasted. A polyurethane paint is recommended.
- Adekit A 300 adhesive is particularly recommended for bonding this resin to itself or with different materials, such as thermoplastics, steel, etc.
- Before repairing or bonding surfaces, degrease the part with alcohol or acetone. We recommend to use Sika® Reinigungsmittel-5.

## STORAGE CONDITIONS

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Shelf life	<ul style="list-style-type: none"><li>▪ Polyol (A), <b>SikaBiresin® RG826</b> 12 months</li><li>▪ Isocyanate (B), <b>SikaBiresin® RG902</b> 12 months</li></ul>
Storage temperature	<ul style="list-style-type: none"><li>▪ Polyol (A), <b>SikaBiresin® RG826</b> 15 – 25 °C</li><li>▪ Isocyanate (B), <b>SikaBiresin® RG902</b> 15 – 25 °C</li></ul>
Crystallization	<ul style="list-style-type: none"><li>▪ After prolonged storage at low temperature, crystallization of B component may occur.</li><li>▪ This is easily removed by warming up for a sufficient time to a maximum of 40 °C.</li><li>▪ Allow to cool to requested processing temperature before use.</li></ul>
Opened packagings	<ul style="list-style-type: none"><li>▪ Containers must be closed tightly immediately after use to prevent moisture ingress. Any open can must be tightly closed under dry nitrogen.</li><li>▪ The residual material needs to be used up as soon as possible.</li></ul>

## FURTHER INFORMATION

The information herein is offered for general guidance only. Advice on specific applications is available on request from the Technical Department of Sika Advanced Resins. Copies of the following publications are available on request: Safety Data Sheets

## BASIS OF PRODUCT DATA

All technical data stated in this document are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

## HEALTH AND SAFETY INFORMATION

For information and advice regarding transportation, handling, storage and disposal of chemical products, users shall refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

## LEGAL NOTICE

The information, and, in particular, the recommendations relating to the application and end use of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

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## Contact

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**SIKA DEUTSCHLAND GMBH**  
Stuttgarter Straße 139  
72574 Bad Urach - GERMANY  
Phone: +49 7125 940 492  
Fax: +49 7125 940 401  
E-Mail: [tooling@de.sika.com](mailto:tooling@de.sika.com)  
Website: [www.sikaadvancedresins.de](http://www.sikaadvancedresins.de)

**SIKA AUTOMOTIVE FRANCE S.A.S.**  
ZI des Béthunes - 15, Rue de l'Équerre  
95310 Saint-Ouen-l'Aumône  
CS 40444  
95005 Cergy Pontoise Cedex - FRANCE  
Phone: +33 1 34 40 34 60  
Fax: +33 1 34 21 97 87  
E-Mail: [advanced.resins@fr.sika.com](mailto:advanced.resins@fr.sika.com)  
Website: [www.sikaadvancedresins.fr](http://www.sikaadvancedresins.fr)

**AXSON TECHNOLOGIES SPAIN, S.L.**  
Ramon Turro 100,1°  
08005 Barcelona - SPAIN  
Phone: +34 93 225 16 20  
Fax: +34 93 225 03 05  
E-Mail: [spain@axson.com](mailto:spain@axson.com)  
Website: [www.sikaadvancedresins.es](http://www.sikaadvancedresins.es)

**AXSON ITALIA S.R.L.**  
Via Morandi 15  
21047 Saronno (Va) - ITALY  
Phone: +39 02 96 70 23 36  
Fax: +39 02 96 70 23 69  
E-Mail: [axson@axson.it](mailto:axson@axson.it)  
Website: [www.sikaadvancedresins.it](http://www.sikaadvancedresins.it)

**AXSON UK LTD**  
Unit 15 Studlands Park Ind. Estate  
Newmarket Suffolk, CB8 7AU - UNITED KINGDOM  
Phone: +44 1638 660 062  
Fax: +44 1638 665 078  
E-Mail: [sales.uk@axson.com](mailto:sales.uk@axson.com)  
Website: [www.sikaadvancedresins.uk](http://www.sikaadvancedresins.uk)

**SIKA AUTOMOTIVE SLOVAKIA S.R.O.**  
Tovarenska 49  
953 01 Zlate Moravce - SLOVAKIA  
Phone: +421 37 6422 526  
Fax: +421 376 42 25 27  
E-Mail: [axson.sk@axson.com](mailto:axson.sk@axson.com)  
Website: [www.sikaadvancedresins.sk](http://www.sikaadvancedresins.sk)

**SIKA ADVANCED RESINS US**  
31200 Stephenson Hwy, Madison Heights,  
MI 48071 - USA  
Phone: +1 248 588 2270  
Fax: +1 248 588 5909  
E-Mail: [axsonmh@axson.com](mailto:axsonmh@axson.com)  
Website: [www.sikaadvancedresins.us](http://www.sikaadvancedresins.us)

**SIKA AUTOMOTIVE EATON RAPIDS, INC.**  
1611 Hults Drive MI 48827 Eaton Rapids - USA  
Phone: +1 517 663 81 91  
Fax: +1 517 663 05 23  
E-Mail: [axsonmh@axson.com](mailto:axsonmh@axson.com)  
Website: [www.sikaadvancedresins.us](http://www.sikaadvancedresins.us)

**SIKA AUTOMOTIVE MEXICO S.A. DE C.V.**  
Ignacio Ramirez #20 Despacho 202 Col.  
Tabacalera C.P. 06030 CDMX - MEXICO  
Phone: +52 55 5264 49 22  
Fax: +52 55 5264 49 16  
E-Mail: [marketing@axson.com.mx](mailto:marketing@axson.com.mx)  
Website: [www.sikaadvancedresins.mx](http://www.sikaadvancedresins.mx)

**SIKA AUTOMOTIVE SHANGHAI CO. LTD.**  
N°53 Tai Gu Road  
Wai Gao Qiao  
Free Trade Zone, Pudong  
200131 Shanghai - CHINA  
Phone: +86 21 58 68 30 37  
Fax: +86 21 58 68 26 01  
E-Mail: [marketing.china@axson.com](mailto:marketing.china@axson.com)  
Website: [www.sikaaxson.cn](http://www.sikaaxson.cn)

**AXSON JAPAN KK**  
2-5-12 Onishi Okazaki Aichi  
444-0871 - JAPAN  
Phone: +81 564 26 2591  
Fax: +81 564 26 2593  
E-Mail: [sales.japan@axson.com](mailto:sales.japan@axson.com)  
Website: [www.sikaadvancedresins.jp](http://www.sikaadvancedresins.jp)

**AXSON INDIA PVT. LTD.**  
Office n°8, Building Symphony C - 3rd Floor  
Range Hills Road  
Bhosale Nagar  
Pune 411 020 - INDIA  
Phone: +91 20 25560 710  
Fax: +91 20 25560 712  
E-Mail: [info.india@axson.com](mailto:info.india@axson.com)  
Website: [www.sikaadvancedresins.in](http://www.sikaadvancedresins.in)