

Technical Data Sheet

Hardener green

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Hardener green offers in combination with a metal component a longer pot life
and a lower viscosity.

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the MetalExistenceCompany™

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Technical Data Sheet

Hardener green

Product description

Hardener green can alternatively be used instead of Hardener yellow. Opposite to Hardener yellow Hardener green offers in combination with a metal component a longer pot life and a lower viscosity.

Hardener green can be used together with the following metal components:

- MM-metal SS-steelceramic, paste
- MM-metal SS-steel, liquid
- MM-metal SS-aluminium, liquid
- MM-metal SS-copper, liquid
- MM-metal SS-bronze, liquid

Technical data for the usage of Hardener green with MM-metal SS-steelceramic

Application consistency:	liquid
Colour after full curing:	dark grey
Compressive strength (DIN ISO 604):	165 MPa (23925 psi)
Tensile strength:	65 MPa (9425 psi)
Bending strength (DIN 53452):	60 MPa (8700 psi)
Tensile shearing strength on steel:	27 MPa (3915 psi)
Brinell hardness (DIN 50351):	32
Specific passage resistance:	$5,65 \times 10^{13} \Omega\text{cm}$
Linear shrinkage (ASTM D 2566):	0,0002165 cm/cm
Linear expansion coefficient at 25-45 °C:	$3,4 \times 10^{-6} \text{ K}$
Heat resistance:	ca -150 °C to +260 °C
Corrosion:	none
Electrochemical corrosion (DIN 50900):	none
Machinability:	machinable with SiC- or diamond-grinding plates; metal cutting only with diamond tools
Cutting speed:	$v_c = 60 - 125 \text{ m/min}$
Cutting depth:	$a_p = 0,5 - 1 \text{ mm}$
Feed:	$f = 0,1 - 0,2 \text{ mm/r}$
Density (mixed components):	$2,28 \text{ g/cm}^3$

Technical data for the usage of Hardener green with MM-metal SS-steel / aluminium / copper / bronze

Application consistency:	liquid
Compressive strength:	data are ca 10% reduced compared with Hardener yellow (compare with data sheet of relevant metal component)
Tensile strength	
Bending strength	
Tensile shearing strength	
Brinell hardness	
Temperature resistance	
Further technical data	data identical with Hardener yellow, where not mentioned otherwise (compare with data sheet of relevant metal component)
Density of Hardener green mixed g/cm^3	
with MM-metal SS-steel	2,45
with MM-metal SS-aluminium	1,62

with MM-metal SS-copper	2,55
with MM-metal SS-bronze	2,55

Processing data for the usage of Hardener green

Temperature	Pot life	part. cured	Fully cured
ca 20 °C	ca 50 min	ca 10 h	ca 24 h

After partial curing, machining is possible. After full curing time, the full functional strength has been reached. Do not use the PolymerMetal at temperatures below + 5 °C, as it doesn't cure completely at low temperatures.

Processing data for the usage of Hardener green with MM-metal SS-steelceramic

Mixing ratio by:	Weight	Volume
MM-metal SS-steelceramic	10	4
Hardener green	1	1
Tool		Measuring spoon green

Processing data for the usage of Hardener green with MM-metal SS-steel / copper / bronze

Mixing ratio by:	Weight	Volume
MM-metal SS-steel or MM-metal SS-copper or MM-metal SS-bronze	10	4
Hardener green	1	1
Tool		Measuring spoon green

Processing data for the usage of Hardener green with MM-metal SS-aluminium

Mixing ratio by:	Weight	Volume
MM-metal SS-aluminium	6	4
Hardener green	1	1
Tool		Measuring spoon green

Surface preparation

Application instruction

Reinforcement

Aftercuring

Information on the above can be found in the data sheet of MM-metal SS-steelceramic, MM-metal SS-steel, MM-metal SS-aluminium, MM-metal SS-copper and MM-metal SS-bronze.

Hint: The available measuring spoons green can be used to measure the required volume parts of the components. The big measuring spoon is for the use of MM-metal SS-steelceramic, MM-metal SS-steel, MM-metal SS-aluminium, MM-metal SS-copper and MM-metal SS-bronze, the small spoon is for Hardener green. Spoons must be filled levelled.

Working security

Avoid eye and skin contact. In case of skin contact, wash thoroughly with soap and water. In case of eye contact, rinse thoroughly with water.

Storage

Hardener green can be stored for at least 5 years, if kept at temperatures below 25 °C. The material does not lose



its high quality performance after repeated openings of the containers.

Order information

No.	Product	Unit
259	Hardener green, liquid	100 g

No.	Accessories	Unit
28	Measuring spoon green	1 set

Availability

Technical data sheets are generally available in German or English language. PolymerMetals are only produced in Germany and delivered worldwide within short time by MultiMetall. In addition to that MM-products are internationally available from many MultiMetall-partners. Ask for further products from MultiMetall.

Note

The product information and instructions provided in this leaflet were prepared to the best of our knowledge and serve information purposes only. We recommend that appropriate tests are carried out prior to application in order to ensure that the products and methods fulfil the purpose desired by the user. In this procedure, the given data may serve as a basis. Application and processing of the products lie outside our possible control and are therefore the sole responsibility of the user.

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