

SikaBlock® M80

Model board

Application

- Manufacture of substructure for design, styling and clay models
- Manufacture of styling models and design studies
- For test milling

Properties

- Easily workable
- Very low thermal expansion
- Good adhesion of fillers

Description

- Basis Hard polyurethane foam, beige
- Adhesive Biresin® Kleber orange, two-component-PUR-system
- Filler Biresin® Spachtel orange, two-component-polyester-system

Physical Data (approx.-values)

SikaBlock® M80			
Density	ISO 845	g/cm ³	0.08
Flexural strength	ISO 178	MPa	1.2
E-Modulus	ISO 604	MPa	24
Compressive strength	ISO 178	MPa	0.75
Temperature use		°C	-80 up to +130
Linear thermal expansion coefficient α_L	DIN 53 752	K ⁻¹	70×10^{-6}

Processing Data

Adhesive / Filler		Biresin® Kleber orange	Biresin® Spachtel orange
Mixing ratio	in parts by weight	100 : 65	100 : 2
Potlife	min	20	5
Setting time	h	6	> 20 min

Delivery

Board materials	SikaBlock® M80	2000 mm x 1000 mm x 100 mm 2000 mm x 1000 mm x 200 mm blocks up to 600 mm thickness on demand
Adhesive	Biresin® Kleber orange, resin Biresin® G53, hardener	1.5 kg net 4 kg; 0.975 kg net
Filler	Biresin® Spachtel orange, resin BPO-Paste, hardener	6 x 1.26 kg net resin tins in a box 6 x 0.04 kg net tubes in a box



Processing

- The material must be acclimatised to 18 - 25°C prior to machining.
- Machining of the block is easily accomplished by sawing, milling or drilling with machines or by hand.
- Bonding areas must be clean, dry and free of dust and grease or oil. For bondings use e. g. Biresin® Kleber orange (for more information see Technical Data Sheet).
- For more information about milling please seek advice from cutting tool manufacturer or our separate leaflet.
- For correction or finishing of surface use Biresin® Spachtel orange (for more information see Technical Data Sheet).

Storage

- Product has un-limited shelf life when stored flat in dry conditions.
- During storage and transport of finished tools and models temperature variations should be kept as moderate as could be.

Precautions

For information and advice on the safe handling and storage of products, users should refer to the current Safety Data Sheet 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.

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 practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a 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 proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users should always refer to the most recent issue of the Technical Data Sheet for the product concerned, copies of which will be supplied upon request.

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