

SikaBlock® M450 Model board

Areas of Application

- Manufacture of design and styling models
- Manufacture of substructure for cubing and DCM

Product Benefits

- Very high dimensional stability and low density
- Fine structure and homogeneous surface
- Resistant surface with good edge stability
- Easily workable
- Good formation of shavings by milling
- Dense and smooth surface
- Easy to seal and good to varnish

Description

- Basis Polyurethane, orange
- Adhesive **Biresin® Kleber orange**, two-component-PUR-system
- Filler **Biresin® Spachtel orange**, two-component-polyester-system

Physical Data (approx.-values)

SikaBlock® M450			
Density	ISO 845	g/cm ³	0.45
Shore hardness	ISO 868	-	D 50
Flexural strength	ISO 178	MPa	12
E-Modulus	ISO 604	MPa	430
Compressive strength	ISO 178	MPa	10*
Heat distortion temperature	ISO 75 B	°C	78
Linear thermal expansion coefficient α_T	DIN 53 752	K ⁻¹	55 x 10 ⁻⁶

* at 10% compressive strain

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

Packaging

Board materials	SikaBlock® M450	1500 mm x 500 mm x 50 mm, 25 pieces / pallet 1500 mm x 500 mm x 75 mm, 16 pieces / pallet 1500 mm x 500 mm x 100 mm, 12 pieces / pallet 1500 mm x 500 mm x 150 mm, 8 pieces / pallet 1500 mm x 500 mm x 200 mm, 6 pieces / pallet
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 and so on with high performance tools 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.

Health and Safety Information

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.

Value Bases

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

Legal Notice

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