Technical Data Sheet
Version 02 / 2010

Tooling & Composites

SikaBlock® M650
Model board

Areas of Application
- Data control models and cubings
- Master models in tool and mould construction
- Manufacture of moulds for low pressure reaction injection moulding
- Vacuum forming moulds for lower number of pieces

Product Benefits
- Very high dimensional stability
- Good compressive strength and edge stability
- Good solvent resistance
- High heat distortion temperature
- Easy machinability
- Low dust formation when milled
- Dense fine surface and good to varnish

Description
- Basis: Polyurethane, reddish brown
- Adhesive: **Biresin® Kleber braun**, two-component-PUR-system, brown
- Filler: **Biresin® Spachtel braun**, two-component-polyester-system, brown

Physical Data (approx.-values)

SikaBlock® M650			
Density	ISO 845	g/cm³	0.58
Shore hardness	ISO 868	-	D 58
Flexural strength	ISO 178	MPa	18
E-Modulus	ISO 604	MPa	700
Compressive strength	ISO 178	MPa	17*
Impact resistance	ISO 179 Ue	kJ/m²	5
Heat distortion temperature	ISO 75 B	°C	85
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 braun**	**Biresin® Spachtel braun**
Mixing ratio	in parts by weight	100 : 65	100 : 2
Potlife	min	20	5
Setting time	h	8 - 10	> 20 min

Packaging

Board materials	**SikaBlock® M650**	1500 mm x 500 mm x 30 mm, 40 pieces / pallet 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 braun**, resin	1.5 kg net
	Biresin® G53, hardener	4 kg; 0.975 kg net
Filler	**Biresin® Spachtel braun**, resin	2 x 8.74 kg net cartridges 6 x 1.76 kg net resin tins in a box
	BPO-Paste, hardener	2 x 0.16 kg net sticks (for cartridges) 6 x 0.04 kg net tubes in a box (for tins)

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 braun (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 braun (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

Further information available at:

Sika Deutschland GmbH
Stuttgarter Str. 139
D - 72574 Bad Urach
Germany

Tel: +49 (0) 7125 940 492
Fax: +49 (0) 7125 940 401
Email: tooling@de.sika.com
Internet: www.sika-tooling.com
www.sika.de/tooling