

Biresin® S13 Elastomeric Gelcoat for foundry pattern making

Areas of Application

- Gelcoat for foundry patterns and core boxes

Product Benefits

- Both components without toxic classification
- Insensitive to moisture
- Good spreading properties
- High abrasion resistance

Description

- Basis Two component PUR system
- Component A **Biresin® S13**, isocyanate prepolymer, transparent
- Component B **Biresin® S13**, amine, blue-grey

Processing Data		Component A	Component B
Individual components		Biresin® S13	Biresin® S13
Viscosity, 25°C	mPa.s	~ 5.500	pasty
Density	g/ml	1.12	1.4
Mixing ratio resin (A) to hardener (B)	in parts by weight	100	60
		Mixture	
Mixed viscosity, 25°C	mPa.s	spreadable	
Potlife, RT	min	20 - 25	
Geltime, RT	min	45	
Demoulding time, RT	h	16	
Curing time, RT	d	5	

Physical Data (approx. values)

Biresin® S13 (A)		with component B	Biresin® S13
Colour			blue-grey
Density	ISO 1183	g/cm³	1.23
Shore hardness	ISO 868	-	D 66
Tensile strength	ISO 527	MPa	25
Elongation at break	ISO 527	%	50

Packaging

Individual components	Biresin® S13 (A) Biresin® S13 (B)	5 kg; 6 x 0,3 kg net in a box 3 kg; 6 x 0,18 kg net in a box
-----------------------	--	---

Processing

- The material, processing and mould temperature must be from 18 to 25°C.
- The A component must be mixed thoroughly before use.
- Then the thoroughly mixed (with spatula or slow speed mixing equipment) Biresin® S13 mixture is applied using a flat, short-haired brush. The coating is applied in an uniform direction to ensure a homogeneous, even and void-free surface coat on the mould surface. The mould surface has to be pre-treated with suitable release agents before.
- Within geltime a coupling layer or other backfilling layers can be applied to avoid adhesion problems.
- Pay attention to dry conditions and dry mould surfaces while processing.

Storage

- Minimum shelf life is 18 month under room conditions (18 - 25°C), when stored in original un-opened containers.
- After prolonged storage at low temperature, crystallisation of components may occur. This is easily removed by warming up for a sufficient time to a maximum of 70°C. Allow to cool to room temperature before use.
- Containers must be closed tightly immediately after use to prevent moisture ingress. The residual material needs to be used up as soon as possible.

Health and Safety Information

For information and advice on the safe handling, storage and disposal of chemical products, users shall refer to the most recent Safety Data Sheet (SDS) 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

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 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 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.

Further information available at:

Sika Deutschland GmbH

Subsidiary Bad Urach

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.com

