

SikaBlock® M1000 Tooling board of low density

Areas of Application

- Manufacture of true-to-size gauges and moulds
- Manufacture of foundry models and master models

Product Benefits

- High dimensional stability and low density
- Low density for good handling
- Good edge stability
- Good heat distortion temperature
- Easily mechanically workable
- Dense, high-tensile surface
- Low thermal expansion coefficient

Description

- Basis Polyurethane, white
- Adhesive **Biresin® Power Adhesive Thix**, two-component-epoxy-system
- Filler **Biresin® Spachtel weiß**, two-component-polyester-system, white

Physical Data (approx. values)

SikaBlock® M1000

Density	ISO 845	g/cm ³	1.0
Shore hardness	ISO 868	-	D 75
Flexural strength	ISO 178	MPa	48
E-Modulus	ISO 604	MPa	1,800
Compressive strength	ISO 178	MPa	47
Impact resistance	ISO 179 Ue	kJ/m ²	13
Heat distortion temperature	ISO 75 B	°C	85
Coefficient of thermal expansion (CTE), α_T	DIN 53 752	K ⁻¹	55 x 10 ⁻⁶

Processing Data

Adhesives / Filler	Adhesive		Filler
	Biresin® Power Adhesive Thix	Biresin® Spachtel weiß	
Mixing ratio (A) to (B) in parts by weight	100 : 33		100 : 2
Potlife min	30		5
Setting time h	16		> 20 min

Packaging

Board materials	SikaBlock® M1000	1500 mm x 500 mm x 50 mm, 28 pc / pallet 1500 mm x 500 mm x 75 mm, 18 pc / pallet 1500 mm x 500 mm x 100 mm, 14 pc / pallet
Adhesive	Biresin® Power Adhesive Thix , resin (A) Biresin® Power Adhesive , hardener (B)	6 x 0.9 kg net resin (A) in a box 6 x 0.3 kg net hardener (B) in a box
Filler	Biresin® Spachtel weiß , resin (A) BPO-Paste , hardener (B)	2 x 9.84 kg net cartridges (A) 6 x 1.96 kg net tins (B) in a box 2 x 0.16 kg net sticks (B) (for cartridges - A) 6 x 0.04 kg net tubes (B) in a box (for tins - A)

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® Power Adhesive Thix (for more information see Product 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 weiß (for more information see Product 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, storage and disposal of chemical products, users shall refer to the most recent Safety Data Sheet (SDS) containing physical, ecological, toxicological and other safetyrelated 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

