

## SikaBlock® M440 Model board

### Areas of Application

- Manufacture of design and styling models
- Manufacture of substructure for cubing and data control models
- Simple laminating moulds

### Product Benefits

- Excellent surface quality
- Easily workable
- Very good milling behaviour
- Very low dust formation

### Description

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

### Physical Data (approx. values)

SikaBlock® M440			
Density	ISO 845	g/cm <sup>3</sup>	0.35
Shore hardness	ISO 868	-	D 38
Flexural strength	ISO 178	MPa	9
E-Modulus	ISO 178	MPa	310
Compressive strength	ISO 844	MPa	8
Heat distortion temperature	ISO 75 B	°C	60
Linear thermal expansion coefficient $\alpha_t$	DIN 53 752	K <sup>-1</sup>	65 x 10 <sup>-6</sup>

### Processing Data

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

### Packaging

Board materials	<b>SikaBlock® M440</b>	1500 mm x 500 mm x 50 mm, 36 pieces / pallet 1500 mm x 500 mm x 75 mm, 24 pieces / pallet 1500 mm x 500 mm x 100 mm, 18 pieces / pallet 1500 mm x 500 mm x 150 mm, 12 pieces / pallet 1500 mm x 500 mm x 200 mm, 8 pieces / pallet
Adhesives	<b>Biresin® Kleber orange</b> , (A) <b>Biresin® G53</b> , (B)	1.5 kg net 4 kg; 0,975 kg net
Filler	<b>Biresin® Spachtel orange</b> , (A) <b>BPO-Paste</b> , (B)	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.
- For bondings use e. g. Biresin® Kleber orange (for more information see Product Data Sheet). Bonding areas must be clean, dry and free of dust and grease or oil.
- 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 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 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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