

Biresin® M68

Near net shape or block cast mass casting resin in various densities

Areas of Application

- Variable blank density from 1.2 to 1.85 g/cm³
- Near net shape cast blanks for moulds and gauges, with low wall thickness too
- **Unfilled / lower density range:** face casting for metal sheet forming tools and foundry models
- **Medium density range:** vacuum forming moulds, gauges, RIM moulds, hammer forms
- **Upper density range:** backfilling and cores for metal sheet forming tools and foundry models
- Series casting of finished parts

Product Benefits

- Very fine dense surface
- Easily workable
- High dimensional and edge stability
- High abrasion and impact resistance

Description

- Basis PUR, opaque (unfilled, density = 1.2 g/cm³) or beige (density > 1,2 g/cm³), coloured if necessary

Physical Data (approx. values)

Biresin® M68, different filler content

	ISO 845	g/cm ³	1.20	1.60	1.73	1.85
Density	ISO 845	g/cm ³	1.20	1.60	1.73	1.85
Shore hardness	ISO 868	-	D 84	D 87	D 89	D 89
E-Modulus	ISO 178	MPa	2,600	5,900	7,700	9,200
Flexural strength	ISO 178	MPa	105	70	65	60
Compressive strength	ISO 604	MPa	81*	88*	88*	87*
Heat distortion temperature	ISO75B	°C	79	78	78	77
CTE value, α_T	DIN 53 752	K ⁻¹	80 x 10 ⁻⁶	55 x 10 ⁻⁶	45 x 10 ⁻⁶	40 x 10 ⁻⁶

* at 10% compressive strain

Delivery

Near net shape cast blanks or blocks

Biresin® M68

customer moulds or mould manufacture based on customer data, on request

Possibilities for changes

	Sticking in of Biresin® M68 blocks or Sikablock® M940 / M980	Filling
Processing	Sticking in of Biresin® M68 blocks or Sikablock® M940 / M980	Filling
Material	Biresin® Kraft Kleber thix or Biresin® Kleber grün	Biresin® Spachtel weiß
Potlife min	20	5
Curing time h	8 - 10	> 20 min

Processing

- The material temperature must be 18 - 25°C.
- Machining of the blanks is easily accomplished by sawing, milling or drilling with machines or by hand.
- For more information about milling please seek advice from cutting tool manufacturer or our separate leaflet (comparable SikaBlock® M940).

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

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

