

Biresin® Kleber grün Adhesive for SikaBlock® tooling boards

Areas of Application

- For rapid mechanically high-tensile bonding of **SikaBlock® M930, M940, M945, M970**
- Suitable for the bonding of whole boards, or the fast bonding of smaller parts e.g. directly on the milling machine

Product Benefits

- Odourless and thus preferable to acrylate adhesives
- Good physiological characteristics
- Very high bonding and mechanical strength
- Abrasion resistant
- Can be accelerated with **Biresin® HC586**
- Colour: green (similar **SikaBlock® M940**)

Description

- Basis Two component PUR system
- Component A **Biresin® Kleber grün**, polyole, green
- Component B **Biresin® Kleber grün**, MDI-based isocyanate, brown
- Accelerator (C) **Biresin® HC586**, amine based catalyst, low viscosity

Processing Data	Component A	Component B
Individual components	Biresin® Kleber grün	Biresin® Kleber grün
Viscosity, 25°C	pasty	~ 120 mPa.s
Mixing ratio A : B	in parts by weight	
	100	50
	Mixture	
Consumption, average	kg/m ²	
	0.7	
Potlife, RT	min	
	15 - 20	
Setting time, RT (workable)	h	
	8 - 10	

Physical Data (approx.-values)

Density	ISO 1183	g/cm ³	1.3
Shore hardness	ISO 868	-	D 86

Packaging

Working packages	Biresin® Kleber grün AB Pack	6 x 1 kg net component A + 6 x 0,5 kg net component B in a box
Individual components	Biresin® HC586 accelerator (C)	0.5 kg net

Processing

- The material, processing and substrate temperature must be from 18 to 25°C.
- Before application of adhesive ensure surfaces are clean, dry, free of dust and grease (cleaning e. g. with Sika® Reinigungsmittel 5).
- Ensure that both surfaces are properly sanded (80 grain).
- The A component must be mixed thoroughly before use.
- By adding the accelerator (C) Biresin® HC586 to the A component, the adhesive can be accelerated. 12 drops of accelerator (C) (with the Sika pipette) added to 100 g of component A, gives a potlife of 3,5 min and a setting time of 1.5 hr.
- The components must be mixed thoroughly before use and applied by brush or toothed spatula. Ensure that the glued parts are clamped together with adequate force to ensure that the bonding-joint area has a thickness of between 0.2 - 1 mm and is free of air bubbles.

Storage

- Minimum shelf life is 18 month under room conditions (18 - 25°C), when stored in original un-opened containers.
- 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

