

SikaBlock® M930 Tooling board of low density

Areas of Application

- Manufacture of foundry models and core boxes for test, trial and first prototypes

Product Benefits

- Very high dimensional stability
- Low weight for good handling
- Easily and fast milling with shavings not dust
- Good workable by hand with good surface quality
- Reduce bonding lines with large board dimensions

Description

- Basis Polyurethane, mint green
- Adhesive **Biresin® Power Adhesive Thix**, two component epoxy system
- Adhesive **Biresin® Kleber grün Neu**, two component PUR system (with accelerator **Biresin® HC586**)

Physical Data (approx. values)

SikaBlock® M930			
Density	ISO 845	g/cm ³	1.0
Shore hardness	ISO 868	-	D 78
Flexural strength	ISO 178	MPa	52
E-Modulus	ISO 604	MPa	1,900
Compressive strength	ISO 178	MPa	50
Impact resistance	ISO 179 Ue	kJ/m ²	12
Heat distortion temperature	ISO 75 B	°C	90
Coefficient of thermal expansion (CTE), α_T	DIN 53 752	K ⁻¹	55 x 10 ⁻⁶

Processing Data

Adhesives	Component A	Biresin® Power Adhesive Thix	Biresin® Kleber grün Neu
	Component B	Biresin® Power Adhesive	Biresin® Kleber grün Neu
Mixing ratio A : B	in parts by weight	100 : 33	100 : 50
Potlife	min	30	15 - 20
Setting time	h	16	8 - 10

Packaging

Board materials	SikaBlock® M930	1500 mm x 500 mm x 50 mm, 28 pieces / pallet 1500 mm x 500 mm x 75 mm, 18 pieces / pallet 1500 mm x 500 mm x 100 mm, 14 pieces / pallet
Adhesive	Biresin® Power Adhesive Thix , (A) Biresin® Power Adhesive , (B)	6 x 0.9 kg net in a box 6 x 0.3 kg net in a box
Filler	Biresin® Kleber grün Neu , AB pack Biresin® HC586 , accelerator	6 x 1 kg net component A + 6 x 0.5 kg net component B in a box 0,5 kg net

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 or Biresin® Kleber grün Neu (for more information see Product Data Sheet).
- For more information about milling please seek advice from cutting tool manufacturer or our separate leaflet.

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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