

Biresin® Kleber braun Neu Adhesive for SikaBlock® model boards

Areas of Application

- For gluing of **SikaBlock®** model boards by manufacture of design-, styling- and master models, copy models, negatives in model, tool and mould making

Product Benefits

- Good adhesion
- Fast curing to a specific light-weight material
- Colour and mechanical properties (after curing) adjusted to **SikaBlock® M680**

Description

- Basis Two component PUR system
- Component A **Biresin® Kleber braun Neu**, polyol, orange
- Component B **Biresin® G53**, MDI-based isocyanate, amber

Processing Data		Component A	Component B
Individual components		Biresin® Kleber braun Neu	Biresin® G53
Viscosity, 25°C		pasty	~ 175 mPa.s
Mixing ratio A : B	in parts by weight	100	65
Mixture			
Consumption, average	kg/m ²	0.9	
Potlife, RT	min	20	
Setting time, RT (workable)	h	8 - 10	

Physical Data (approx.-values)

Biresin® Kleber braun Neu (A)	with component B	Biresin® G53
Density	ISO 1183 g/cm ³	0.8
Shore hardness	ISO 868 -	D 63
E-Modulus	ISO 178 MPa	1,100
Flexural strength	ISO 178 MPa	30
Impact resistance	ISO 179 MPa	8
Heat distortion temperature	ISO 75B °C	45
Flexural strength of bonding	internal MPa	18

Packaging

Individual components	Biresin® Kleber braun Neu (A)	15.4 kg; 1.5 kg net
	Biresin® G53 (B)	10 kg; 0.975 kg net

Processing

- The material, processing and substrate temperature must be from 18 to 25°C.
- The A component must be mixed thoroughly before use.
- The resin components must be mixed thoroughly before use and applied by brush or toothed spatula.
- Make sure, glued parts are clamped together with adequate force to ensure that the bonding-joint area has a thickness of approx. 0.2 up to 1 mm and is free of air bubbles.
- Before application of adhesive ensure surfaces are clean, dry, free of dust and grease. Abrasion of surfaces can increase adhesion.

Storage

- Minimum shelf life is 12 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

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