

## Biresin® Kleber orange 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® M440**
- Additional suitable for **SikaBlock® M450, M330, M150 and M80**

### Description

- Basis Two component PUR adhesive
- Component A **Biresin® Kleber orange**, polyol, orange, filled
- Component B **Biresin® G53**, MDI-based isocyanate, amber, unfilled

Processing Data	Component A	Component B
<b>Individual components</b>	<b>Biresin® Kleber orange</b>	<b>Biresin® G53</b>
Viscosity, 25°C	pasty	~ 175 mPa.s
Mixing ratio A : B	100	65
	<b>Mixture</b>	
Consumption, average	kg/m <sup>2</sup>	0.9
Potlife, RT	min	20
Setting time, RT (workable)	h	6 - 8

Physical Data (approx.-values)			Biresin® G53
<b>Biresin® Kleber orange (A)</b>	with component B		
Density	ISO 1183	g/cm <sup>3</sup>	0.8
Shore hardness	ISO 868	-	D 61
E-Modulus	ISO 178	MPa	1,100
Flexural strength	ISO 178	MPa	28
Impact resistance	ISO 179	MPa	8
Heat distortion temperature	ISO 75B	°C	45
Flexural strength of bonding	internal	MPa	14

### Packaging

Individual components	<b>Biresin® Kleber orange (A)</b> <b>Biresin® G53 (B)</b>	1.5 kg net 4 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 two 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

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](mailto:tooling@de.sika.com)

Internet: [www.sika.com](http://www.sika.com)

