

## SikaBlock® M990 Tooling board - high abrasion resistant

### Areas of Application

- Manufacture of core boxes, foundry models and match plates in Coldbox Processing

### Product Benefits

- Very high abrasion resistance
- Very high impact resistance
- Good heat resistance
- Excellent milling properties
- High-grade, dense surface

### Description

- Basis Polyurethane, orange
- Adhesive UR 3490, 2K-PUR-System, beige with comparable abrasion resistance to SikaBlock® M990 Biresin® Power Adhesive Thix, Two component EP system, colourless, thixotropic

### Physical Data (approx. values)

SikaBlock® M990			
Density	ISO 845	g/cm <sup>3</sup>	1.2
Shore hardness	ISO 868	-	D 80
Flexural strength	ISO 178	MPa	60
Flexural E-Modulus	ISO 178	MPa	1,500
Compressive strength	ISO 604	MPa	56
Impact resistance	ISO 179 Ue	kJ/m <sup>2</sup>	without break
Abrasion resistance	ISO 4649	mm <sup>3</sup>	170
Heat distortion temperature	ISO 75 B	°C	80
Coefficient of thermal expansion (CTE), $\alpha_T$	DIN 53 752	K <sup>-1</sup>	105 x 10 <sup>-6</sup>

### Processing Data

Adhesives	component A	UR 3490	Biresin® Power Adhesive Thix
	component B	UR 3490	Biresin® Power Adhesive
Mixing ratio in parts by weight		100 : 50	100 : 33
Potlife	min	14	30
Setting time (for milling)	h	< 16	16

### Packaging

Board materials	<b>SikaBlock® M990</b>	1000 mm x 500 mm x 30 mm, 30 pieces / pallet 1000 mm x 500 mm x 50 mm, 36 pieces / pallet 1000 mm x 500 mm x 75 mm, 24 pieces / pallet 1000 mm x 500 mm x 100 mm, 18 pieces / pallet
Adhesives	<b>UR 3490 (A)</b> <b>UR 3490 (B)</b> <b>Biresin® Power Adhesive Thix, (A)</b> <b>Biresin® Power Adhesive, (B)</b>	6 x 1.0 kg net in a box 6 x 0.5 kg net in a box 6 x 0.9 kg net in a box 6 x 0.3 kg net in a box

## 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 (cleaning e. g. with Sika® Reinigungsmittel 5). For bondings use e. g. UR 3490 with comparable abrasion resistance or Biresin® Power Adhesive Thix (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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