

Biresin® M67

Near net shape cast model resin with various densities

Areas of Application

- Variable blank density from 0.6 to 1.1 g/cm³
- Near net shape blanks with low wall thickness for design, styling or cubing models and light weight mould making
- Blocks of different dimensions

Product Benefits

- Micro-cellular material with low density
- Dense surface and easily workable
- Finished surfaces can be covered with layers of paints
- Changes possible with materials with similar mechanical properties

Description

- Basis PUR, light brown

Physical Data (approx.-values)

| Biresin® M67, different filler content | | | | | |
|--|------------|-----------------|-----------------------|-----------------------|-----------------------|
| Density | ISO 845 | g/cm³ | 1.10 | 0.86 | 0.61 |
| Shore hardness | ISO 868 | - | D 76 | D 67 | D 53 |
| E-Modulus | ISO 178 | MPa | 2,100 | 1,300 | 700 |
| Flexural strength | ISO 178 | MPa | 50 | 30 | 15 |
| Compressive strength | ISO 604 | MPa | 47* | 29* | 16* |
| Heat distortion temperature | ISO75B | °C | 65 | 58 | 57 |
| CTE value, α_T | DIN 53 752 | K ⁻¹ | 78 x 10 ⁻⁶ | 78 x 10 ⁻⁶ | 78 x 10 ⁻⁶ |

* at 10% compressive strain

Delivery

near net shape casted blanks or blocks **Biresin® M67** customer moulds or in manufactured moulds based on customer data, on request

Possibilities for changes

| Processing | Sticking in of Biresin® M67 blocks or Sikablock® M700 | Filling | Pasting on (by machine) | |
|---------------|---|---------------------------|-------------------------|-----------------------|
| Material | Biresin® Kleber braun or Biresin® Spachtel braun | Biresin® Modellspachtel M | Biresin® M72 PUR paste | Biresin® M82 EP paste |
| Potlife min | 20 | 40 - 50 | - | - |
| Curing time h | 8 - 10 | > 24 | > 8 | 24 - 36 |

Processing

- The material temperature must be 18 - 25°C.
- Machining of the blanks is easily accomplished by sawing, milling or drilling with machines or by hand.
- For more information about milling please seek advice from cutting tool manufacturer or our separate leaflet (SikaBlock® M700).

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.

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