

## SikaBlock® M600 MultiBlock

### Areas of Application

- Data control models and cubings
- Master models in tool and mould construction
- Manufacture of moulds for low pressure reaction injection moulding
- Vacuum forming moulds for lower number of pieces

### Product Benefits

- Dense fine surface
- Easy to seal and good to varnish
- Low dust formation when milled
- Easy machinability
- Very high dimensional stability
- Good compressive strength and edge stability
- Good heat distortion temperature

### Description

- Basis Polyurethane, light brown
- Adhesive **Biresin® Kleber braun Neu**, two component PUR system, brown
- Filler **Biresin® Spachtel braun Neu**, two component polyester system, brown

### Physical Data (approx. values)

#### SikaBlock® M600

Density	ISO 845	g/cm <sup>3</sup>	0.60
Shore hardness	ISO 868	-	D 58
Flexural strength	ISO 178	MPa	18 - 20
E-Modulus	ISO 604	MPa	750
Compressive strength	ISO 178	MPa	16 - 18
Impact resistance	ISO 179 Ue	kJ/m <sup>2</sup>	8
Heat distortion temperature	ISO 75 B	°C	75 - 80
Linear thermal expansion coefficient $\alpha_T$	DIN 53 752	K <sup>-1</sup>	55 x 10 <sup>-6</sup>

### Processing Data

Adhesive / Filler		<b>Biresin® Kleber braun Neu</b>	<b>Biresin® Spachtel braun Neu</b>
Mixing ratio A : B	in pbw	100 : 65	100 : 2
Potlife	min	20	5
Setting time	h	8 - 10	> 20 min

### Packaging

Board materials	<b>SikaBlock® M600</b>	1500 mm x 500 mm x 30 mm, 30 pieces / pallet 1500 mm x 500 mm x 50 mm, 36 pieces / pallet 1500 mm x 500 mm x 75 mm, 24 pieces / pallet 1500 mm x 500 mm x 100 mm, 18 pieces / pallet 1500 mm x 500 mm x 150 mm, 12 pieces / pallet 1500 mm x 500 mm x 200 mm, 8 pieces / pallet
Adhesive	<b>Biresin® Kleber braun Neu</b> , (A) <b>Biresin® G53</b> , (B)	1.5 kg net 4 kg; 0.975 kg net
Filler	<b>Biresin® Spachtel braun Neu</b> , (A)  <b>BPO-Paste</b> , (B)	2 x 8.34 kg net cartridges (A) 6 x 1.76 kg net resin tins (A) in a box 2 x 0.16 kg net sticks (B) (for cartridges - A) 6 x 0.04 kg net tubes (B) in a box (for tins - A)

## 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® Kleber braun Neu (for more information see Product Data Sheet).
- For more information about milling please seek advice from cutting tool manufacturer or our separate leaflet.
- For correction or finishing of surface use Biresin® Spachtel braun Neu (for more information see Product Data Sheet).

## 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 packaging 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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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)

