

SikaBlock® M680

MasterBlock

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

- Very 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® M680			
Density	ISO 845	g/cm³	0.68
Shore hardness	ISO 868	-	D 63
Flexural strength	ISO 178	MPa	22 - 24
E-Modulus	ISO 604	MPa	900
Compressive strength	ISO 178	MPa	20 - 22
Impact resistance	ISO 179 Ue	kJ/m²	8
Heat distortion temperature	ISO 75 B	°C	75 - 80
Linear thermal expansion coefficient α_T	DIN 53 752	K⁻¹	55 x 10⁻⁶

Processing Data

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

Packaging

Board materials	SikaBlock® M680	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	Biresin® Kleber braun Neu , (A) Biresin® G53 , (B)	1.5 kg net 4 kg; 0.975 kg net
Filler	Biresin® Spachtel braun Neu , (A) BPO-Paste , (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 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.

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