

PRODUCT DATA SHEET

SikaBlock[®] M80

DESIGN BOARD WITH DENSITY 0.08

APPLICATIONS

- Manufacture of substructure for design, styling and clay models
- Manufacture of styling models and design studies
- For test milling path proofing

MAIN PROPERTIES

- Easy workable
- Very low thermal expansion
- Good adhesion of putties

DESCRIPTION

Basis	Hard polyurethane foam, beige
Adhesive	Labelite Glue , 1K-PUR-System
Adhesive	Biresin[®] Kleber Orange , 2K-PUR-System
Putty	Biresin[®] Spachtel Orange , 2K-Polyester-System

PHYSICAL PROPERTIES

approx. values

Components	SikaBlock [®] M80		
Density	ISO 845	g/cm ³	0.08
Shore hardness	ISO 868	-	-
Flexural strength	ISO 178	MPa	1.1
E-Modulus	ISO 178	MPa	24
Compressive strength	ISO 844	MPa	0.8
Temperature use		°C	-60 / +120
Linear thermal expansion coefficient α_T	DIN 53 752	K ⁻¹	60 x 10 ⁻⁶
Thermal Conductivity	ASTM C518	W/(m.K)	0.024

PROCESSING DATA

Adhesive/Filler		Labelite Glue	Biresin® Kleber Orange / G53	Biresin® Spachtel Orange / BPO
Mixing ratio	by weight	1-component PU	100 : 65	100 : 2
Pot life	min	<60	20	5
Setting time	h	2	6	20 min

- The material must be acclimatized to 18 – 25 °C prior to machining.
- Bonding areas must be clean, dry and free of dust or grease or oil (cleaning with Sika Reinigungsmittel 5).
- To bond boards together we recommend Labelite Glue or Biresin® Kleber Orange (more information see PDS).
- Machining of the block is easily accomplished by sawing, milling and so on with high performance tools or by hand.
- For more information about milling please ask for advice from cutting tool manufacturer or refer to our separate leaflet for milling parameters.
- For correction and repair we recommend Biresin® Spachtel Orange (more information see PDS).

PACKAGING UNITS

- Board: **SikaBlock® M80**
 - 2000 mm x 1000 mm x 100 mm, 12 pieces / pallet
 - 2000 mm x 1000 mm x 200 mm, 6 pieces / pallet
 - 2000 mm x 1000 mm x 300 mm, 4 pieces / pallet
 - 2000 mm x 1000 mm x 400 mm, 3 pieces / pallet
 - 2000 mm x 1000 mm x 450 mm, 2 pieces / pallet
 - 2400 mm x 1300 mm x 100 mm, 12 pieces / pallet
 - 2400 mm x 1300 mm x 200 mm, 6 pieces / pallet
 - 2400 mm x 1300 mm x 400 mm, 3 pieces / pallet
- Adhesive: **Labelite Glue** 6 x 1 kg
- Adhesive: **Biresin® Kleber Orange, (A)** 1.5 kg
Biresin® G53, (B) 0.975 kg
- Filler: **Biresin® Spachtel Orange, (A)** 6 x 1.26 kg in a box
BPO-Paste, (B) 6 x 0.04 kg tubes

STORAGE CONDITIONS

- Product has unlimited shelf life when stored on flat base in dry conditions.
- During storage and transport of finished models and tools temperature should be between 18-25°C and variations should be kept as moderate as could be.

FURTHER INFORMATION

The information herein is offered for general guidance only. Advice on specific applications is available on request from the Technical Department of Sika Advanced Resins. Copies of the following publications are available on request: Safety Data Sheets

BASIS OF PRODUCT DATA

All technical data stated in this document are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

HEALTH AND SAFETY INFORMATION

For information and advice regarding transportation, handling, storage and disposal of chemical products, users shall refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

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.

Contact

SIKA DEUTSCHLAND GMBH

Business Unit Industry
Stuttgarter Straße 139
72574 Bad Urach
Phone: +49 7125 940-7692
E-Mail: industry@de.sika.com
Website: www.sika.de

SIKA AUTOMOTIVE FRANCE S.A.S.

ZI des Béthunes - 15, Rue de l'Équerre
95310 Saint-Ouen-l'Aumône
CS 40444
95005 Cergy Pontoise Cedex - FRANCE
Phone: +33 1 34 40 34 60
Fax: +33 1 34 21 97 87
E-Mail: advanced.resins@fr.sika.com
Website: www.sikaadvancedresins.fr

Sika S.A.U.

Carretera de Madrid a Irún – km 14.5
P.I. Congost 28108 Alcobendas (Madrid) - SPAIN
Phone: +34 93 225 16 20
E-Mail: sar-sales@es.sika.com
Website: www.sikaadvancedresins.es

Sika Italia S.p.A.

Via Luigi Einaudi 6
20068 Peschiera Borromeo (MI) - Italy
Phone: +39 02 54778111
Fax: +39 02 54778 119
E-Mail: info@sika.it
Website: www.sika.it

Sika Limited

Head Office, Watchmead – Welwyn
Garden City – AL7 1BQ – United Kingdom
Phone: +44 1707 394444
E-Mail: industry-sales@uk.sika.com
Website: www.gbr.sika.com

SIKA AUTOMOTIVE SLOVAKIA S.R.O.

Tovarenska 49
953 01 Zlate Moravce - SLOVAKIA
Phone: +421 2 5727 29 33
Fax: +421 37 3000 087
E-Mail: SikaAdvancedResins@sk.sika.com
Website: www.sikaadvancedresins.com

Sika Industry – Tooling, Resins and Marine

30800 Stephenson Highway
Madison Heights, Michigan 48071 - USA
Phone: +1 248 588 2270
Fax: +1 248 616 7452
E-Mail: advanced.resins@us.sika.com
Website: www.sikaindustry.com

SIKA AUTOMOTIVE EATON RAPIDS, INC.

1611 Hults Drive
Eaton Rapids, Michigan 48827 - USA
Phone: +1 517 663 81 91
Fax: +1 517 663 05 23
E-Mail: advanced.resins@us.sika.com
Website: www.sikaadvancedresins.us

SIKA MEXICANA SA de CV

Av. Gustavo Baz #309 Centrum Park
54060 Tlanepantla Estado de MEXICO
Phone: +52 442 238 5800
E-Mail: roman.octavio@mx.sika.com

SIKA AUTOMOTIVE SHANGHAI CO. LTD.

N°53 Tai Gu Road
Wai Gao Qiao
Free Trade Zone, Pudong
200131 Shanghai - CHINA
Phone: +86 21 58 68 30 37
Fax: +86 21 58 68 26 01
E-Mail: industry@cn.sika.com
Website: www.sika.cn

Sika Ltd.

10 F, Shinagawa Intercity Tower B.
2-15-2 Konan, Minato-ku
Tokyo 108-6110 - JAPAN
Phone: +81 3 6433 2314
Fax: +81 3 6433 2102
E-Mail: advanced-resins@jp.sika.com
Website: www.jpn.sika.com

SIKA INDIA PVT LTD,

Plot No. Pap-V-90/1,
Chakan Industrial Area,
Phase-II, Vasuli, Khed, PUNE,
Maharashtra – 410501
E-Mail: info.india@in.sika.com