

## SikaBlock® M330 Model board

### Areas of Application

- Manufacture of design and styling models
- Manufacture of substructure for cubing and data control models
- Simple laminating moulds

### Product Benefits

- Very fine, dense surface
- Easily workable
- Very low dust formation
- Big dimensions

### Description

- Basis Hard polyurethane foam, siena
- Adhesive **Biresin® Foam Adhesive**, one component PUR system
- Adhesive **Biresin® Kleber orange**, two component PUR system
- Filler **Biresin® Spachtel orange**, two component polyester system

### Physical Data (approx. values)

SikaBlock® M330			
Density	ISO 845	g/cm <sup>3</sup>	0.24
Shore hardness	ISO 868	-	D 25
Flexural strength	ISO 178	MPa	5
E-Modulus	ISO 178	MPa	150
Compressive strength	ISO 844	MPa	4
Heat distortion temperature	ISO 75B	°C	55 - 60
Linear thermal expansion coefficient $\alpha_T$	DIN 53 752	K <sup>-1</sup>	65 x 10 <sup>-6</sup>

### Processing Data

Adhesive / Filler	Biresin® Foam Adhesive	Biresin® Kleber orange	Biresin® Spachtel orange
Mixing ratio A : B in parts by weight	1-component system	100 : 65	100 : 2
Potlife min	10 - 15	20	5
Setting time h	6 - 8	6	> 20 min

### Packaging

Board materials	<b>SikaBlock® M330</b>	1500 mm x 500 mm x 50 mm, 36 pieces / pallet 1500 mm x 500 mm x 100 mm, 18 pieces / pallet 1500 mm x 500 mm x 200 mm, 8 pieces / pallet 2000 mm x 1000 mm x 50 mm, 25 pieces / pallet 2000 mm x 1000 mm x 100 mm, 12 pieces / pallet 2000 mm x 1000 mm x 150 mm, 8 pieces / pallet 2000 mm x 1000 mm x 200 mm, 6 pieces / pallet 2000 mm x 1000 mm x 250 mm, 4 pieces / pallet other dimensions on request
Adhesives	<b>Biresin® Foam Adhesive</b> <b>Biresin® Kleber orange, (A)</b> <b>Biresin® G53, (B)</b>	0,75 l, 12 pieces / box 1.5 kg net 4 kg; 0,975 kg net
Filler	<b>Biresin® Spachtel orange, (A)</b> <b>BPO-Paste, (B)</b>	6 x 1.26 kg net resin tins in a box 6 x 0.04 kg net tubes 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 or drilling with machines or by hand.
- For bondings use e. g. Biresin® Foam Adhesive or Biresin® Kleber orange (for more information see Product Data Sheet). Bonding areas must be clean, dry and free of dust and grease or oil.
- 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 orange (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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