

## Biresin® Power Adhesive Thix Thixotropic Adhesive for SikaBlock® tooling boards

### Areas of Application

- For mechanically high-tensile bonding of **SikaBlock®** tooling boards for manufacture of foundry models, metal sheet forming tools and other models
- For bonding especially of **SikaBlock® M940, M960, M970, M1000** und **M1050**

### Product Benefits

- Thixotropic consistency, optimal wetting properties
- Very high adhesive strength and mechanical data
- High heat distortion temperature
- Favourable physiological characteristics
- Glued joints hardly visible (semi-transparent)
- Good chemical resistance, against water, mineral oils and grease

### Description

- Basis Two-component-epoxy-adhesive
- Resin **Biresin® Power Adhesive Thix**, epoxy resin, colourless, thixotropic, unfilled
- Hardener **Biresin® Power Adhesive**, amine, amber, unfilled

### Processing Data

Processing Data		Resin	Hardener
<b>Individual components</b>		<b>Biresin® Power Adhesive Thix</b>	<b>Biresin® Power Adhesive</b>
Density, 25°C	g/ml	1.16	0.97
Mixing ratio resin to hardener	in parts by weight	100	33
		<b>Mixture</b>	
Mixed viscosity, RT	mPas	thixotropic	
Consumption, average	kg/m <sup>2</sup>	approx. 0,7	
Potlife, RT	min	30	
Setting time, RT (workable)	h	16	

### Physical Data (approx.-values)

Biresin® Power Adhesive Thix Resin		with hardener	Biresin® Power Adhesive	
Density	ISO 1183	g/cm <sup>3</sup>	1.16	
Härtungsbedingungen	time / temperature		14 d / RT	2 h / 80°C
Shore hardness	ISO 868	-	D 80	D 82
E-Modulus	ISO 178	MPa	2.630	2.400
Flexural strength	ISO 178	MPa	95	102
Impact resistance	ISO 179	kJ/m <sup>2</sup>	45	20
Heat distortion temperature	ISO 75B	°C	58	100

### Packaging

Working packages      **Biresin® Power Adhesive Thix A+B Pack**      6 x 0,9 kg net resin +  
6 x 0.3 kg net hardner in a box



## Processing

- The material and processing temperature must be 20 - 25°C. Lower temperatures result in longer setting times.
- The resin and hardener component must be mixed thoroughly and applied by brush or toothed spatula.
- Make sure, glued parts are clamped together with adequate force to ensure that the bonding-joint area has a thickness of approx. 0.2 up to 1 mm and is free of air bubbles.
- Before application of adhesive ensure surfaces are clean, dry, free of dust and grease (cleaning e. g. with Sika® Reinigungsmittel 5). Abrasion of surfaces can increase adhesion.

## Storage

- Minimum shelf life of Biresin® Power Adhesive Thix resin is 24 month and of Biresin® Power Adhesive hardener 12 month under room condition (18 - 25°C), when stored in original un-opened containers.
- Containers must be closed tightly immediately after use to prevent moisture ingress. The residual material needs to be used up as soon as possible.

## Health and Safety Information

For information and advice on the safe handling and storage of products, users should refer to the current Safety Data Sheet 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

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