

PRODUCT DATA SHEET

SikaBlock® M935

POLYURETHANE TOOLING BOARD

APPLICATIONS

- Foundry patterns, match plates
- Prototype core boxes for cold box process
- True-size gauges, high grade master models, diverse molds and tools

MAIN PROPERTIES

- Very high dimensional stability
- Good strength and abrasion resistance
- Easy and fast milling
- Easy workability with good surface quality
- Large board dimension of 1490 mm can result in less bonding lines

DESCRIPTION

Basis	Polyurethane, light green
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PHYSICAL PROPERTIES

(approx. values)

Density	ISO 2781	g/cm ³	1.2
Shore hardness	ISO 868	D	82
Flexural strength	ISO 178	MPa	74
Flexural modulus	ISO 178	MPa	2,900
Compressive strength	ISO 604	MPa	74
Impact resistance	ISO 179eU	kJ/m ²	18
Heat distortion temperature	ISO 75 B	°C	89
Glass transition temperature	ISO 11359	°C	92
Coefficient of thermal expansion (CTE) α_T	ISO 11359	10 ⁻⁶ K ⁻¹	56

PROCESSING DATA

- The material and processing temperature shall be between 18 °C and 25 °C.
- If the boards need to be bonded, make sure that the surfaces are clean, dry and free of grease or oil.
- For cleaning Sika® Cleaner G+M or another suitable cleaner or solvent can be used.
- For bonding SikaBlock® M935 boards together use SikaBiresin® B180 or another suitable adhesive.
- For further information regarding the adhesive and bonding process consult the corresponding Product Data Sheet.
- SikaBlock® M935 can be easily machined by milling, drilling, sawing or modified manually. It is recommended to use high performance tools to machine these boards.
- For milling parameters check information from cutting tool manufacturers or get the General Guideline "Milling parameters for SikaBlock®" for more general information.

PACKAGING UNITS

■ Board:	SikaBlock® M935	1490 mm x 495 mm x 30 mm, 30 pieces/pallet
		1490 mm x 495 mm x 50 mm, 28 pieces/pallet
		1490 mm x 495 mm x 75 mm, 18 pieces/pallet
		1490 mm x 495 mm x 100 mm, 14 pieces/pallet

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 enduse 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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