

ADDITIONAL TECHNICAL INFORMATION

REPAIR SOLUTIONS FOR SIKABIRESIN® EPOXY PASTES

TECHNICAL SPECIFICATIONS AND PERFORMANCE DATA

1 INTRODUCTION

This Additional Technical Information (ATI) provides recommended repair solutions for surface defects on milled parts made from SikaBiresin® epoxy model and tooling pastes. It outlines suitable combinations of A-components with SikaBiresin® GC11 (B-component), including mixing ratios, pot life, and setting times depending on layer thickness. These guidelines support fast and effective manual repairs, ensuring compatibility and optimal performance. For detailed product properties, users must refer to the respective Product Data Sheets.

2 REPAIR SOLUTIONS

REPAIR SOLUTION FOR SIKABIRESIN® SC175 (A) WITH SIKABIRESIN® GC11 (B)		
Color		Grey
Mixing ratio A:B	by weight	100 : 20
Pot life at 23 °C	60 g	10 – 15 minutes
Setting time at 23 °C (workable)	3 mm thickness	270 minutes
Setting time at 23 °C (workable)	10 mm thickness	90 minutes

REPAIR SOLUTION FOR SIKABIRESIN® SC180 (A) WITH SIKABIRESIN® GC11 (B)		
Color		Brown
Mixing ratio A:B	by weight	100 : 13
Pot life at 23 °C	60 g	10 – 15 minutes
Setting time at 23 °C (workable)	3 mm thickness	270 minutes
Setting time at 23 °C (workable)	10 mm thickness	90 minutes

REPAIR SOLUTION FOR SIKABIRESIN® SC380 (A) WITH SIKABIRESIN® GC11 (B)		
Color		Grey
Mixing ratio A:B	by weight	100 : 17
Pot life at 23 °C	60 g	10 – 15 minutes
Setting time at 23 °C (workable)	3 mm thickness	270 minutes
Setting time at 23 °C (workable)	10 mm thickness	90 minutes

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Repair solutions for SikaBiresin® Epoxy Pastes

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REPAIR SOLUTION FOR SIKABIRESIN® SC390 (A) WITH SIKABIRESIN® GC11 (B)		
Color		Grey
Mixing ratio A:B	by weight	100 : 15
Pot life at 23 °C	60 g	10 – 15 minutes
Setting time at 23 °C (workable)	3 mm thickness	270 minutes
Setting time at 23 °C (workable)	10 mm thickness	90 minutes

3 PROCESSING

- For fast repair solution of surface defects on milled surfaces out of SikaBiresin® epoxy model and tooling pastes it is recommended to use A-component in mixture with SikaBiresin® GC11 (B). Pot life and setting time depend on mixture volume and applied layer thickness (see information above).
- For more information on each of the pastes mentioned above, refer to the corresponding Product Data Sheet.

Disclaimer

The information contained herein and any other advice 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. The information only applies to the application(s) and product(s) expressly referred to herein. In case of changes in the parameters of the application, such as changes in substrates etc., or in case of a different application, consult Sika's Technical Service prior to using Sika products. The information contained herein does not relieve the user of the products from testing them for the intended application and purpose. 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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