

## PRODUCT DATA SHEET

# SikaBiresin® F38 (F38)

UNFILLED FASTCAST RESIN FOR MANUFACTURING OF MODELS AND PROTOTYPES WITH GOOD IMPACT RESISTANCE – POT LIFE 20 – 25'

## APPLICATIONS

- Manufacturing of models and prototypes in the model building

## MAIN PROPERTIES

- Good impact resistance
- Short demoulding time
- Low viscosity
- Thermoplastic aspect
- Low shrinkage
- Easy mix ratio
- Good ability for being painted

## DESCRIPTION

Basis	Two component polyurethane system
Component A	<b>SikaBiresin® F38</b> , polyol, unfilled, transparent
Component B	<b>SikaBiresin® F38</b> , MDI-based isocyanate, unfilled, amber

## PHYSICAL PROPERTIES

		Polyol (A)	Isocyanate (B)
Components		<b>SikaBiresin® F38</b>	<b>SikaBiresin® F38</b>
Viscosity, 25 °C	mPa.s	~ 35	~ 40
Density, 25 °C	g/cm³	0.98	1.16
Mixing ratio A:B	in parts by weight	100	100
Mixing ratio A:B	in party by volume	100	85
		Mixture	
Colour		off-white	
Viscosity, 25 °C	mPa.s	~ 35	
Pot life, 25 °C, 200 g	min	~ 2	
Demoulding time, 23 °C	min	~ 20 – 25	
Curing time, 23 °C	d	~ 3	
Maximum casting thickness	mm	5 – 10	

## MECHANICAL PROPERTIES

approx. values; values after post curing 7 d / room temperature

Density, 23 °C	ISO 2781	g/cm <sup>3</sup>	1.07
Shore hardness	ISO 868	-	D 70
Flexural modulus	ISO 178	MPa	750
Flexural strength	ISO 178	MPa	32
Tensile strength	ISO 527	MPa	28
Elongation at break	ISO 527	%	10
Impact resistance	ISO 179	kJ/m <sup>2</sup>	30
Compressive strength at yield	ISO 604	MPa	20
Linear shrinkage, 3 mm thickness	Internal test	mm/m	1.5

## THERMAL AND SPECIFIC PROPERTIES

approx. values; values after post curing 7 d / room temperature

Working temperature	Internal	°C	20 – 60
Heat deflection temperature	ISO 75	°C	55

## PACKAGING UNITS

- |   |      |
|---|------|
| ■ Polyol (A), <b>SikaBiresin® F38</b>     | 5 kg |
| ■ Isocyanate (B), <b>SikaBiresin® F38</b> | 5 kg |

## PROCESSING DATA

- The material, processing and mould temperature should be at least 18 – 25 °C.
- Both components must be shaken well before use.
- Recommended release agents are Sika® Liquid Wax-815 or Sika® Pasty Wax-818. For more information, see Product Data Sheets of the release agents.
- Pay attention to dry conditions and dry mould surfaces while processing.
- Porous surfaces have to be well sealed before.
- Both components have to be mixed thoroughly according to mixing ratio and poured immediately into the released mould with beginning at the lowest point.
- Further post curing of the demoulded part can improve the final mechanical properties.
- Depending on the geometry and weight of the part, it is recommended to use a conformer while post curing.
- For cleaning the final part from release agent residues, we recommend Sika® Reinigungsmittel-5. Before use of other cleaners, compatibility must be tested.
- Before overpainting, the parts have to be grinded or sandblasted. A polyurethane paint is recommended.
- Silicone elastomer ESSIL 125 for mould making is recommended for SIKABIRESIN® F38.

## STORAGE CONDITIONS

Shelf life	■ Polyol (A), <b>SikaBiresin® F38</b>	6 months
	■ Isocyanate (B), <b>SikaBiresin® F38</b>	12 months
Storage temperature	■ Polyol (A), <b>SikaBiresin® F38</b>	15 – 25 °C
	■ Isocyanate (B), <b>SikaBiresin® F38</b>	15 – 25 °C
Opened packagings	■ Containers must be closed tightly immediately after use to prevent moisture ingress. ■ The residual material needs to be used up as soon as possible.	

## 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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## Contact

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### SIKA DEUTSCHLAND GMBH

Stuttgarter Straße 139  
72574 Bad Urach - GERMANY  
Phone: +49 7125 940 492  
Fax: +49 7125 940 401  
E-Mail: tooling@de.sika.com  
Website: www.sikaadvancedresins.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

### AXSON TECHNOLOGIES SPAIN, S.L.

C/Guardaagullies, 8 – P.I. Congost - 08520  
Les Franqueses del Valles (Barcelona) - SPAIN  
Phone: +34 93 225 16 20  
Fax: +34 93 225 03 05  
E-Mail: spain@axson.com  
Website: www.sikaadvancedresins.es

### AXSON ITALIA S.R.L.

Via Morandi 15  
21047 Saronno (Va) – ITALY  
Phone: +39 02 96 70 23 36  
Fax: +39 02 96 70 23 69  
E-Mail: axson@axson.it  
Website: www.sikaadvancedresins.it

### AXSON UK LTD

Unit 15 Studlands Park Ind. Estate  
Newmarket Suffolk, CB8 7AU - UNITED KINGDOM  
Phone: +44 1638 660 062  
Fax: +44 1638 665 078  
E-Mail: sales.uk@axson.com  
Website: www.sikaadvancedresins.uk

### 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 ADVANCED RESINS US

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.sikaadvancedresins.us

### 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 AUTOMOTIVE MEXICO S.A. DE C.V.

Ignacio Ramirez #20 Despacho 202 Col.  
Tabacalera C.P. 06030 CDMX - MEXICO  
Phone: +52 55 5264 49 22  
E-Mail: marketing@axson.com.mx  
Website: www.sikaadvancedresins.mx

### 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: marketing.china@axson.com  
Website: www.sikaaxson.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

### AXSON INDIA PVT. LTD.

Office n°8, Building Symphony C - 3rd Floor  
Range Hills Road  
Bhosale Nagar  
Pune 411 020 - INDIA  
Phone: +91 20 25560 710  
Fax: +91 20 25560 712  
E-Mail: info.india@axson.com  
Website: www.sikaadvancedresins.in