

PRODUCT DATA SHEET

SikaBlock[®] M976 EP

EPOXY TOOLING BOARD – COMPACT SURFACE AND HIGH THERMAL STABILITY

APPLICATIONS

- Master-models for composite molds made with prepregs in autoclave
- Direct molds for composite prepreg parts in short series production
- Molds for thermoforming of plastic parts in short series production
- High accuracy composite parts or molds by wet lay-up or infusion processes

MAIN PROPERTIES

- Premium smooth and fine surface aspect
- Extremely low surface porosity minimizing surface finish/sealing
- High temperature resistance and dimensional stability
- Lightweight density 0.73
- Lower dust formation when milled
- Good mechanical strength and edge stability

DESCRIPTION

Basis	Epoxy, light blue
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PHYSICAL PROPERTIES

(approx. values)

Density	ISO 845	g/cm ³	0.73
Shore hardness	ISO 868	D1	74
Flexural strength	ISO 178	MPa	42
E-Modulus	ISO 178	MPa	2,500
Compressive strength	ISO 604	MPa	67
Heat distortion temperature	ISO 75 B	°C	120
Linear coefficient of thermal expansion	ISO 11359	10 ⁻⁶ K ⁻¹	38 x 10 ⁻⁶

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 bonding SikaBlock® M976 EP boards together use SikaBiresin® B176 or H 8973.
- For further information regarding the adhesive and bonding process consult the corresponding Product Data Sheet.
- SikaBlock® M976 EP can be easily machined by milling, drilling, sawing or modified manually. It is recommended to use high performance tools to machine these boards.
- For prepregs application please refer to separate guide "Working Instructions for epoxy boards".

PACKAGING UNITS

■ Board:	SikaBlock® M976 EP	1500 mm x 500 mm x 50 mm, 20 pieces/pallet
		1500 mm x 500 mm x 75 mm, 15 pieces/pallet
		1500 mm x 500 mm x 100 mm, 10 pieces/pallet
		1500 mm x 500 mm x 150 mm, 7 pieces/pallet
		1500 mm x 500 mm x 200 mm, 5 pieces/pallet
		Also existing upon demand in 1524 x 610 mm with same thicknesses and number of pieces per 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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