

PRODUCT DATA SHEET

SikaBiresin® F48 F55

Unfilled polyurethane casting resin with long pot life

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Properties	Comp. A SikaBiresin® F48	Comp. B SikaBiresin® F55	SikaBiresin® AX150	SikaBiresin® AX209
Chemical base	Polyol, unfilled	MDI-based isocyanate, unfilled	Aluminum hydroxide powder	Aluminum powder
Color	Beige	Colorless Opaque	White Beige	Grey Grey
Density	1.06 kg/l	1.22 kg/l 1.15 kg/l	2.4 kg/l 1.7 kg/l	2.7 kg/l 1.7 kg/l
Mixing ratio	by weight, AX150 0 to 350 parts by weight, AX209 0 to 250 parts 100 : 100 : (350) 100 : 100 : (250)			
Viscosity (CQP029-4)	3000 mPa·s	250 mPa·s 2000 mPa·s	Highly viscous Castable	Highly viscous Castable
Pot life (CQP021-4)	500 g at 23 °C			
Demolding time	depending on casting thickness			
Shore D hardness (CQP023-1 / ISO 868)				
Tensile strength (CQP036-2 / ISO 527)				
Elongation at break (CQP036-2 / ISO 527)				
Compressive strength (CQP028-5 / ISO 604)				
Flexural strength (CQP027-2 / ISO 178)				
Flexural modulus (CQP027-2 / ISO 178)				
Impact resistance (CQP038-2 / ISO 179)				
Linear shrinkage (CQP014-5)	500 x 40 x 40 mm			
Shelf life	12 months	12 months	24 months	24 months

CQP = Corporate Quality Procedure

A) curing condition: after demolding 7 days at 23 °C

C) mixing ratio 100 : 100 : 350

B) mixing ratio 100 : 100 : 0

D) mixing ratio 100 : 100 : 250

DESCRIPTION

SikaBiresin® F48 F55 is an unfilled fast curing 2-component polyurethane system with long pot life and high impact resistance.

PRODUCT BENEFITS

- Very good flow behavior for an unfilled resin
- High impact resistance
- Adjustable filler content
- Filled compounds thick castable with high compressive strength
- Cured moldings mechanically workable

AREAS OF APPLICATION

SikaBiresin® F48 F55 is used as a face casting layer for metal sheet forming tools and foundry patterns.

The filled version of the Product is suitable for manufacture of cores for face casting or back-fill casting.

This product is suitable for experienced professional users only.

METHOD OF APPLICATION

Surface preparation

The material, processing and mold or master-model temperature shall be between 18 °C and 25 °C.

Make sure the mold or master model is clean, dry, dust and grease free.

If mold or master-model surface is porous, it must be sealed prior applying the release agent.

It is recommended to use wax-based release agents. For further information regarding Sika release agent consult the corresponding Product Data Sheet.

Mixing process

Prior to use check the material for homogeneity and crystallization. After prolonged storage at low temperature, crystallization of components may occur. This process can be easily reversed by heating the affected component to a maximum of 70 °C until the crystals have disappeared. Allow to cool down to requested processing temperature before use.

Prior to mixing, component A must be stirred thoroughly.

Prior to mixing, component B must be shaken thoroughly.

To shake large containers, place them on a table and then carefully turn them over and move them back and forth.

If no fillers are needed, pour both components in the right mixing ratio together and mix homogeneously.

In case fillers are required, divide the filling quantity evenly and mix homogeneously into each of the two components respecting the defined mixing ratio. The mixing can be performed with a spatula or a machine stirrer at ≤ 300 rpm.

Then pour both components together and mix homogeneously. In both cases, to ensure homogeneous and complete mixing, pour the mixed product into another container and mix again shortly, considering the pot life.

Note: Both containers must be closed tightly immediately after use to prevent moisture ingress.

Once opened the product shall be used as soon as possible.

Application

Immediately after mixing pour the Product into the mold starting at the deepest point.

Demolding time may vary depending on casted thickness and room temperature.

STORAGE CONDITIONS

Both components must be stored at temperature between 15 °C and 25 °C in original unopened containers.

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 Industry.

Copies of the following publications are available on request:

- Safety Data Sheets

PACKAGING INFORMATION

SikaBiresin® F48 (A)

Pail	5 kg
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SikaBiresin® F55 (B)

Canister	5 kg
Hobbock	20 kg

SikaBiresin® AX150

Bag	25 kg
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SikaBiresin® AX209

Canister	5 kg
Drum	50 kg

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.

DISCLAIMER

The information, and, in particular, the recommendations relating to the application and end-use 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.

PRODUCT DATA SHEET

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