

## Biresin® Spachtel orange, braun Neu, weiß Pattern filler for SikaBlock® board materials

### Areas of Application

- For modelling, equalising and repair of master models, copy models, negatives in model, tool and mould making

### Product Benefits

- Good adhesion
- Fast curing with non sticky surface
- Good grindable
- Colour and mechanical properties (after curing and abrasion) adjusted to **SikaBlock®** board materials

### Description

- Basis** Two component polyester filler
- Component A** **Biresin® Spachtel orange, braun Neu** (brown New), **weiß** (white), paste
- Component B** **BPO-Paste**, white / red, paste

### Processing Data

Mixing ratio	Biresin® Spachtel (A) to component B parts by weight	orange	braun Neu (brown New)	weiß (white)
		BPO-Paste		
		100 : 2	100 : 2	100 : 2
Potlife, 100 g / RT	min	5	5	5
Setting time, RT (grindable)	min	> 20	> 20	> 20
Application for board material	<b>SikaBlock®</b>	M330, M440, M445, M450	M600, M650, M680, M700	M1000

### Physical Data (approx.-values)

Biresin® Spachtel			orange	braun Neu (brown New)	weiß (white)
Density	ISO 1183	g/cm³	1.3	1.6	1.9
Shore hardness	ISO 868	-	D 58	D 70	D 75

### Packaging

Component A in tins	<b>Biresin® Spachtel (A) orange</b> <b>Biresin® Spachtel (A) braun Neu</b> <b>Biresin® Spachtel (A) weiß</b>	6 x 1.26 kg net tins (A) in a box 6 x 1.76 kg net tins (A) in a box 6 x 1.96 kg net tins (A) in a box
Component A in cartridges	<b>Biresin® Spachtel (A) braun Neu KT</b> <b>Biresin® Spachtel (A) weiß KT</b>	2 x 8.34 kg net cartridges 2 x 9.84 kg net cartridges
Component B in tubes	<b>BPO-Paste (B)</b>	6 x 0.04 kg net in a box (for tins)
Component B in sticks	<b>BPO-Paste (B)</b>	2 x 0.16 kg net (for cartridges)

## Processing

- The material, processing and substrate temperature must be from 18 to 25°C.
- Before processing of the pattern filler, mix in 2 - 3 % (max) by weight of hardener (B) BPO-Paste.
- Higher percentages of hardener can result in changes of colour.
- Before application of filler ensure surfaces are clean, dry, free of dust and grease.
- Dosage of components A and B by cartridges and Spachtelspender (filler dispenser) is more exact and clean than by hand. Filler dispenser works pneumatically with dry compressed air of 10 bar. Two pistons empty the components A and B parallel from of cartridge openings with a two canal discharge valve in constant mixing ratio, ready to mix by hand. The advantages of filler dispenser are precision of dosage, decreases waste of packages and useless material.

## Storage

- Minimum shelf life is 12 month under room condition (18 - 25°C), when stored in original un-opened containers.
- Containers must be closed water tight immediately after use and prevented from moisture. The residual material has to be used up as soon as possible.

## Health and Safety Information

For information and advice on the safe handling, storage and disposal of chemical products, users shall refer to the most recent Safety Data Sheet (SDS) containing physical, ecological, toxicological and other safety related data.

## Disposal considerations

Product Recommendations: Must be disposed of in a special waste disposal unit in accordance with the corresponding regulations.

Packaging Recommendations: Completely emptied packagings can be given for recycling. Packaging that cannot be cleaned should be disposed of as product waste.

## Value Bases

All technical data stated in this Product Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

## Legal Notice

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.

Further information available at:

Sika Deutschland GmbH

Subsidiary Bad Urach

Stuttgarter Str. 139

D - 72574 Bad Urach

Germany

Tel: +49 (0) 7125 940 492

Fax: +49 (0) 7125 940 401

Email: [tooling@de.sika.com](mailto:tooling@de.sika.com)

Internet: [www.sika.com](http://www.sika.com)



**BUILDING TRUST**

