

PRODUCT DATA SHEET

SikaBiresin[®] SC258

LIGHT WEIGHT EPOXY MODELING PASTE - DENSITY < 0.60

APPLICATIONS

- Direct hand modeling of small volumes
- Application on approximate core up to 40 mm for large volumes
- Large light weigh models for all Industry
- Light weight checking fixture, machining supports

MAIN PROPERTIES

- 1:1 mix ratio by weight or volume
- Friendly use with tinted components
- Mix by hand or planetary mixing machine
- Stick on itself for thick applications

DESCRIPTION

Basis	Two-component-epoxy-system
Component A	SikaBiresin[®] SC258 , pasty epoxy resin, white
Component B	SikaBiresin[®] SC258 , pasty hardener, light brown

PHYSICAL PROPERTIES

Components		Resin (A)	Hardener (B)
		SikaBiresin[®] SC258	SikaBiresin[®] SC258
Viscosity, 25 °C	mPa.s	paste	paste
Density 25 °C	ISO 1675-75	0.48	0.55
Mixing ratio	in parts by weight	100	100
	in parts by volume at 25 °C	100	100
		Mixture	
Colour		Light brown	
Viscosity, 25 °C	mPa.s	paste	
Potlife, 25 °C, 250 g	min	65	
Maximum advised thickness	mm	40	

MECHANICAL PROPERTIES

(approx. values at 23 °C, obtained on standard specimens after curing 16 h at 40 °C)

Density, 23 °C	ISO 2781		0.57
Shore hardness	ISO 868	Shore D1 at 23°C	60
		Shore D15 at 23°C	58
Compressive yield strength	ISO 604	MPa	23

THERMAL AND SPECIFIC PROPERTIES

(approx. values at 23 °C, obtained on standard specimens after curing 16 h at 40 °C)

Glass transition temperature	ISO 11359-2	°C	51
Coefficient of thermal expansion (CTE) [+10 °C to +50 °C]	ISO 11359-2	10 ⁻⁶ K ⁻¹	48
Hardening time before machining		h	12 - 18
Complete curing at 23°C		d	2

PACKAGING UNITS

- Resin (A), **SikaBiresin® SC258** 5,0 kg; 10 kg net
- Hardener (B), **SikaBiresin® SC258** 5,0 kg; 10 kg net

PROCESSING DATA

- The material, processing and mould temperature must be at least 18 – 25 °C.
- Mix resin + hardener by hand up to 500 gr mixing. For bigger use a mixer
- As soon as the colour is uniform you can apply the resin.
- On smooth cores apply first a thin layer by spatula (bonding layer)
- Slick the surface with alcohol or water to get it smooth.

STORAGE CONDITIONS

Shelf life	■ Resin (A), SikaBiresin® SC258	12 months
	■ Hardener (B), SikaBiresin® SC258	12 months
Storage temperature	■ Resin (A), SikaBiresin® SC258	18 – 25 °C
	■ Hardener (B), SikaBiresin® SC258	18 – 25 °C
Opened packagings	■ Containers must be closed tightly immediately after use.	
	■ 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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