

TEMPORARY PRODUCT DATA SHEET

SikaBiresin® TD150 / TRANSLUX D150 Hardener

EPOXY CASTING RESIN WITH HIGH TRANSPARENCY FROM TRANSLUX RANGE

APPLICATIONS

- For applications in art and decoration; embeddings, river tables, mock-ups

MAIN PROPERTIES

- High transparency
- Low viscosity
- Self-degassing behaviour
- Good UV stability

DESCRIPTION

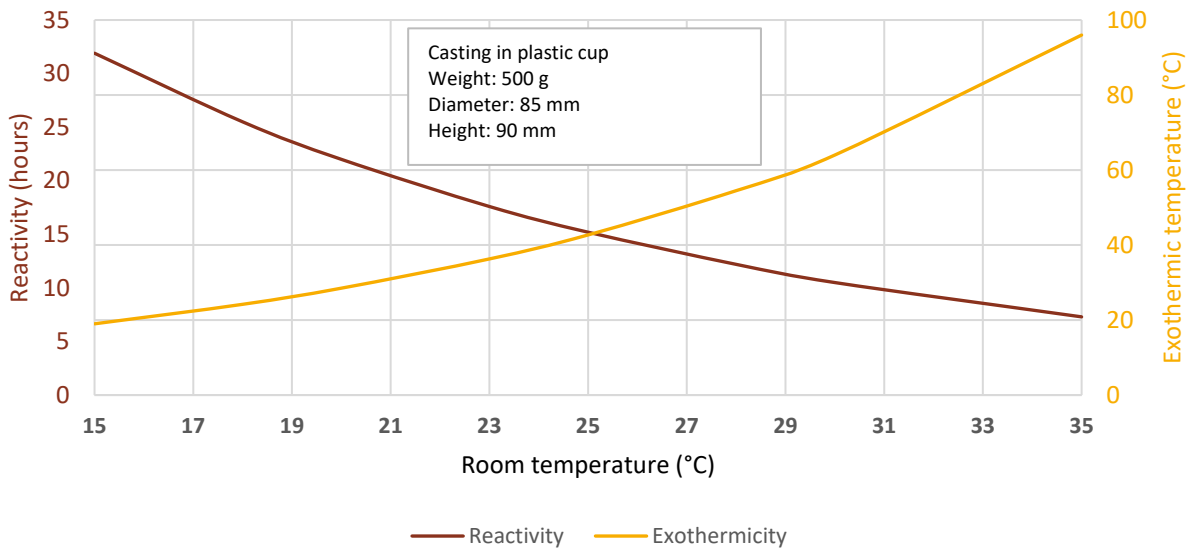
Basis	Two component epoxy system
Component A	SikaBiresin® TD150 , epoxy resin, unfilled, bluish-transparent
Component B	TRANSLUX D150 , amine, unfilled, transparent

PHYSICAL PROPERTIES

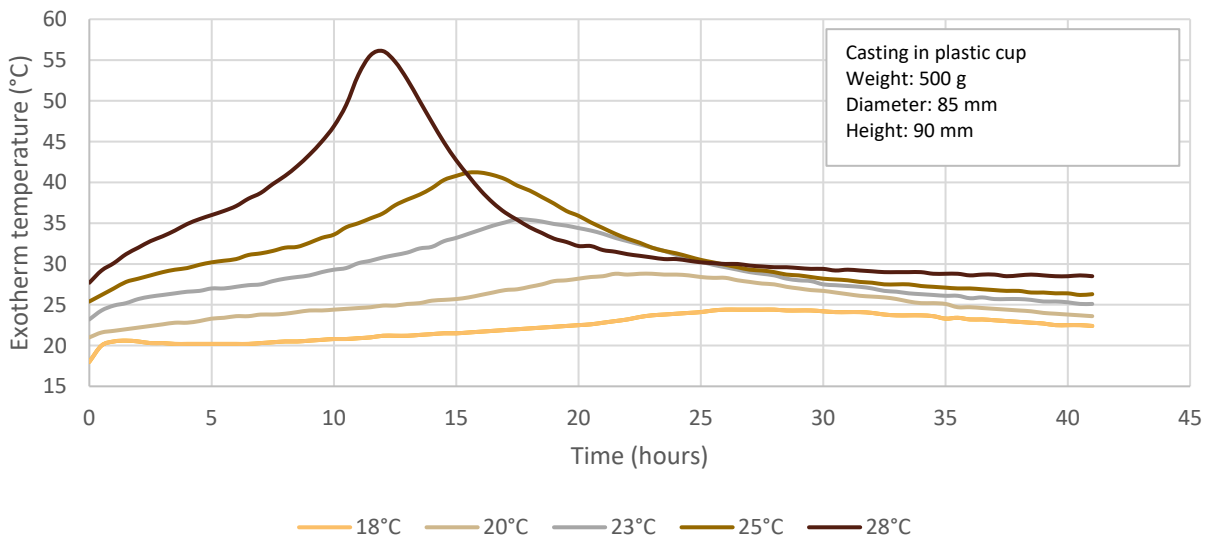
		Resin (A)	Hardener (B)
Components		SikaBiresin® TD150	TRANSLUX D150
Viscosity, 25 °C	mPa.s	ca. 600	ca. 100
Density		ca. 1.12	ca. 0.98
Mixing ratio	in parts by weight	100	45
	in parts by volume	100	50
		Mixture	
Colour		transparent	
Viscosity, 25 °C	mPa.s	ca. 300	
Reactivity on 500 g, 23 °C*	h	ca. 17	
(Max. exothermic temperature)	°C	ca. 35	

* refer to the graph below, influence of room temperature (RT) on exothermic reaction and curing time on 500 g casted in a plastic cup in thickness 90 mm

SikaBiresin® TD 150 Reactivity and exothermicity vs room temperature



SikaBiresin® TD 150 Reactivity vs time & temperature



MECHANICAL AND THERMAL PROPERTIES

approx. values on standard-sized specimen / after curing 7 days at room temperature

Shore hardness	ISO 868	Shore D1	ca. D 80
Elongation at maximum strength	ISO 527	%	ca. 4,5
Flexural modulus	ISO 178	MPa	ca. 2,100
Glass transition temperature (TG)	ISO 11359-2	°C	ca. 39
Glass transition temperature (TG) after 16H at 50°C	ISO 11359-2	°C	ca. 47

SPECIFIC PROPERTIES

Maximum casting thickness on plate 350 x 300 mm	Room temperature	Thickness (mm)	Weight (g)	Temperature of reaction
	< 18 °C	100	11,550	>45°C
	18 °C	70	8,085	45°C
	20 °C	50	5,575	30°C
	23 °C	25	2,890	27°C
	25 °C	15	1,730	27°C
	28 °C	10	1,155	30°C

PACKAGING UNITS

- | | |
|--|------------------------------|
| ■ Resin (A), SikaBiresin® TD150 | 1000 kg; 220 kg; 5.26 kg net |
| ■ Hardener (B), TRANSLUX D150 | 1000 kg; 200 kg; 4.74 kg net |

PROCESSING DATA

- Room temperature is the most important parameter to be successful in SikaBiresin® TD150 casting. There is a link in between room temperature (RT), volume of cast resin and curing speed. A speed curing caused by warm RT creates high exothermic reaction and cured resin could be yellow with streaks on top.
- Mixing should be done by hand or with an electric mixer. Be careful not to incorporate too much air while mixing. Emulsion must be avoided.
- After a primary mixing in a bucket pour the product in a second bucket and finish the mixing. Scrap well the walls of the mixing container. Leave the mixing for a self-degassing for at least 15 to 30 minutes prior to cast or use a vacuum chamber.
- According to long pot life and low viscosity the casting frame must be perfectly tight. Brown PE packing tape is self-releasing from the resin and could be used in corners of the box and anywhere resin should not bond on support.
- A liquid or pasty wax could be also used to prevent bonding on models and supports. The wood or porous surfaces of models must be sealed before casting the resin. Quick setting epoxy or a varnish could be used but sealer must be cured prior to casting of SikaBiresin® TD150.
- After casting and some relaxation time the remaining bubbles can easily be removed with a hot airstream gun (sweep the surface at 15-20 cm of distance).
- A thin sanding and polishing are almost always needed to get shiny and flat surface. Use appropriate tools in order to avoid heat on the resin when polishing. Water sandpaper is advised.
- Prolonged intensive UV exposure can lead to optical changes or changes in transparency.

STORAGE CONDITIONS

Shelf life	<ul style="list-style-type: none">Resin (A), SikaBiresin® TD150 12 monthsHardener (B), TRANSLUX D150 12 months
Storage temperature	<ul style="list-style-type: none">Resin (A), SikaBiresin® TD150 15 °C – 25 °CHardener (B), TRANSLUX D150 15 °C – 25 °C
Crystallization	<ul style="list-style-type: none">After prolonged storage at low temperature, crystallization of A (RESIN) component may occur.This is easily removed by warming up for a sufficient time to a maximum of 70 °C.Allow to cool to requested processing temperature before use.
Opened packagings	<ul style="list-style-type: none">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.

Contact

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'Equerre
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/Guardaagullés, 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
Fax: +52 55 5264 49 16
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. OKAZAKI Branch
2-5-12 Ohnishi Okazaki City, AICHI
444-0871 - JAPAN
Phone: +81 564 26 2591
Fax: +81 564 26 2583
E-Mail: advanced-resins@jp.sika.com
Website: www.sikaadvancedresins.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