BUILDING TRUST

PRODUCT DATA SHEET

SikaBiresin® TD150 / SikaBiresin® TD165

EPOXY CASTING RESIN WITH HIGH TRANSPARENCY

APPLICATIONS

- For applications in art and decoration to make transparent objects from 1 mm up to 10 mm such as thin inclusions, embeddings, wood surface sealing and coatings

MAIN PROPERTIES

- High transparency
- Easy mixing ratio 2:1
- Self-degassing behaviour
- Quick setting in thin layers
- Good UV resistance

DESCRIPTION

Basis	Two component epoxy system
Component A	**SikaBiresin® TD150**, epoxy resin, unfilled, bluish-transparent
Component B	**SikaBiresin® TD165**, amine, unfilled, transparent

PHYSICAL PROPERTIES

		Resin (A)	Hardener (B)
Components		**SikaBiresin® TD150**	**SikaBiresin® TD165**
Viscosity, 25 °C	mPa.s	~ 500	~ 650
Density, 23 °C	g/cm³	~ 1.12	~ 1.00
Mixing ratio	in parts by weight	100	50
	in parts by volume	100	50
		Mixture	
Colour		transparent	
Viscosity, 25 °C	mPa.s	~ 500	
Reactivity on 150 g, 25 °C	min	~ 60	
Tack-free time in thin layer 1-3mm, 23°C	hours	~ 8 - 9	

MECHANICAL AND THERMAL PROPERTIES

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

Shore hardness	ISO 868	Shore D1	D 81
Elongation at maximum strength	ISO 527	%	5
Flexural modulus	ISO 178	MPa	1600
Glass transition temperature (TG)	ISO 11359-2	°C	53

SPECIFIC PROPERTIES

approx.. values at 23°C room temperature

Maximum casting thickness on plate 350 x 300 mm	mm	10
Maximum casting thickness small casted parts (<100g)	mm	25
Demolding time small casted parts (<100g) in 10mm thickness	hours	up to 48
Demolding time small casted parts (<100g) in 5mm thickness	hours	up to 72

PACKAGING UNITS

■ Resin (A), **SikaBiresin® TD150**	1000 kg / 220 kg / 5 kg net
■ Hardener (B), **SikaBiresin® TD165**	950 kg / 200 kg / 2.5 kg net

PROCESSING DATA

- Room temperature is the most important parameter to be successful in SikaBiresin® TD150/TD165 casting. There is a link in between room temperature (RT), thickness 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.
- In thin layers – coating (1 to 5 mm) a warm room (25 – 30 °C) is advised to speed up curing and get best properties.
- 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 bucked and finish the mixing. Scrap well the walls of the mixing container. Prior to casting the mixing can be left for self-degassing for maximum 10 minutes. Alternatively, the mixing can be evacuated in 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 the resin.
- 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.
- Polishing paste on a buffer is giving the best finishing. Do not heat up too much the casting layer when polishing in order to avoid marks.

STORAGE CONDITIONS

Shelf life	■ Resin (A), **SikaBiresin® TD150** ■ Hardener (B), **SikaBiresin® TD165**	12 months 12 months
Storage temperature	■ Resin (A), **SikaBiresin® TD150** ■ Hardener (B), **SikaBiresin® TD165**	15 – 25 °C 15 – 25 °C
Crystallization	■ 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	■ Containers must be closed tightly immediately after use to prevent moisture and dust 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

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