



SikaBiresin® CIM 80

SikaBiresin® CIM 80 is a cost-effective material co-developed with Sika for the Massivit 10000 series. It provides high-speed production for room-temperature tooling applications, as well as masters, jigs and fixtures.

Key Advantages:

- Room temperature curing - save time and costs
- Good vacuum retention
- High-dimensional accuracy
- Good workability

Applications

- Room temperature layups tools
- Masters
- Jigs and fixtures

Character	Method	Metric	Imperial
Mechanical Properties			
Izod Impact	ISO 179	6 [kJ/m ²]	2.8 [ft-lb/in ²]
Shore Hardness	ISO 868	87D	87D
Tensile Properties			
Flexural modulus	ISO 178	6500 [MPa]	942,000 psi
Flexural strength	ISO 178	65 [MPa]	9,420 psi
Tensile strength	ISO 527	25 [MPa]	
Elongation at break	ISO 527	2%	
Compressive strength	ISO 604	110 [MPa]	15,950 psi
Thermal Properties			
Linear shrinkage	Internal test	0.03 - 0.05%	
Heat Deflection Temperature	ISO 75B	80 [°C] *	176 [°F]

* Improvement of good mechanical properties after post curing 4 - 8 h at 70 °C or during heat influence at working

Physical properties

Character	Tested value
Component A viscosity	20,000 mPa.s
Component B viscosity	200 mPa.s
Mix Ratio by Weight	100A:25B
Mix Viscosity	3,000 cP
Specific Gravity	1.7 g/cm ³
Pot Life @RT (200gr)	40 min
Demoulding time@RT	~ 16 - 24 h
Mixture Color	Beige

All measurements were done on lab specimens of cured material, followed by post - cure process. The specifications stated above refer to the Beta aversion and results were derived from internal lab tests. The material above is under R&D development.

Post-Curing Process

To meet the specified properties, SikaBiresin® CIM 80 should be heat-cured in a dedicated industrial oven. Consult Application Note for detailed instructions. Post - cured SikaBiresin® CIM 80 specimens can be milled, polished, or coated with a suitable coating or paint. Let coating fully dry before putting part into service.

Storage

The material base -A and hardener -B should be stored in a dry place in the sealed original container at temperatures between +2°C and +40°C. Under these storage conditions, the shelf life is one year. The product should not be exposed to direct sunlight.

Precautionary Statement

Massivit maintains up-to-date Material Safety Data Sheets (MSDS) on all of its products. These sheets contain pertinent information that you may need to protect your employees and customers against any known health or safety hazards associated with our products. Users should review the latest MSDS to determine possible health hazards and appropriate precautions to implement prior to using this material.