

**Smooth** into  
the last corner.



## Laminating paste Biresin® L90 – Excellent in processing!

The fibre reinforced epoxy paste is very easy to apply and most suited to reinforce large areas. This enables the production of lightweight negatives, foundry patterns and various moulds with high dimensional stability and strength.

### Your advantages:

- **Simple mixing** (by hand or machine) with colour mixing control
- **Odourless** in use
- **Good adhesion** to vertical surfaces and **excellent non-sagging properties**
- **Very smooth plasticity** during the complete pot life (approx. 1h)
- **Very good dimensional stability** due to low shrinkage and CTE



Sika Deutschland GmbH, Niederlassung Bad Urach,  
Stuttgarter Str. 139, D-72574 Bad Urach, Deutschland,  
Tel: +49(0)7125 940 492, Fax: +49(0)7125 940 401,  
e-mail: [tooling@de.sika.com](mailto:tooling@de.sika.com),  
[www.sika.de](http://www.sika.de), <http://toolingandcomposites.sika.com>

**Innovation & Consistency** | since 1910

## Biresin® L90 Laminating paste



The liquid hardener component Biresin® L90 (B) is coloured blue for safe mixing control.



Biresin® L90 can be also applied easily in complex shapes. Very smooth plasticity and homogeneous texture during the complete pot life.

### Description

- Basis Two-component-epoxy-system
- Resin (A) **Biresin® L90**, epoxy resin, grey
- Hardener (B) **Biresin® L90**, amine, blue

Processing Data		Resin (A)	Hardener (B)
Individual components		<b>Biresin® L90</b>	<b>Biresin® L90</b>
Viscosity, 23°C	mPas	can't be measured	~ 140
Density	g/ml	1.0	0.96
Mixing ratio resin (A) to hardener (B)	in parts by weight	100	14
<b>Mixture</b>			
Mixed viscosity, 23°C	mPas	pasty	
Potlife, 500 g, RT	min	60	
Demoulding time, RT	h	24	

### Physical Data (approx. values)

Biresin® L90 resin (A)	with hardener (B)	<b>Biresin® L90</b>
Density	ISO 1183 g/cm³	1.0
Shore hardness	ISO 868 -	D 73
E-Modulus	ISO 178 MPa	3,800
Compressive strength	ISO 604 MPa	50
Heat distortion temperature	ISO 75B °C	60
Linear shrinkage	internal %	0.02

### Packaging

Individual components	<b>Biresin® L90</b> resin (A)	12 kg net
	<b>Biresin® L90</b> hardener (B)	1.68 kg net