

PRODUCT DATA SHEET

SikaBiresin® L400 (Formerly EPOPAST 400 NA)

Epoxy Laminating Paste

TYPICAL PHYSICAL PROPERTIES (FOR FURTHER VALUES SEE SAFETY DATA SHEET)

Properties	SikaBiresin® L400 (A) Resin	SikaBiresin® L400 (B) Hardener
Composition	Epoxy	Amine
Mix ratio by weight	100	14
Aspect	Fibrous paste	Liquid
Color	Grey	Green
Color (mixed)	Green	
Density at 77°F (25°C) (mixed)	7.57 lbs/gal (.91 g/cc)	
Work life (570g) at 77°F (25°C)	2.0 hours	
Peak Exotherm (1 lb. mass)	105°F (41°C)	

DESCRIPTION

SikaBiresin® L400 is an epoxy-based, glass fiber-filled laminating paste primarily used as a structural backing material. SikaBiresin® L400 offers an alternative to standard laminating techniques due to its glass fiber-filled nature.

PRODUCT BENEFITS

- Low density
- Glass fiber reinforced
- Long pot life
- Low odor
- Very easy to mix and apply

AREAS OF APPLICATION

SikaBiresin® L400 is ideal for use as a supporting backup structure. It is used for tools, negatives, jigs, fixtures, models, fillets, reinforcements, and other application types. SikaBiresin® L400 can also be used for artistic formable models.

Tests with actual materials and conditions have to be performed to ensure satisfactory performance.

TYPICAL MECHANICAL AND THERMAL PROPERTIES

Properties, Test Method	SikaBiresin® L400 (A) Resin	SikaBiresin® L400 (B) Hardener
Hardness, Shore D ASTM D2240	81	
Flexural strength, ASTM D790	6,955 psi (48 MPa)	
Flexural modulus, ASTM D790	637,560 psi (4,400 MPa)	
Compressive Strength, ASTM D695	7,100 psi (48 Mpa)	
Glass transition temperature, ASTM E1545	158°F (70°C)	
Coefficient of thermal expansion (TMA), ASTM E1545	13.3 ppm/°F (24 ppm/°C)	
Maximal laminating thickness Inches (mm)	1.57 (40)	
Demolding time at 77°F (25°C) Hours	24	
Complete cure time at 77°F (25°C) Days	7	

Cure schedule: Cured 16 hours at 140°F (60°C)

PROCESSING

Normal health and safety precautions should be observed when handling these products:

- Ensure adequate ventilation
- Wear gloves, glasses, and protective clothes

For further information, please consult the Safety Data Sheets

STORAGE CONDITIONS

Shelf life of resin and hardener is 12 months when stored in original, unopened containers between 65-77°F (15 - 25°C). Any opened can must be tightly closed.

PACKAGING INFORMATION

Packaging information is available upon request. Please contact your local Sika sales representative.

FURTHER INFORMATION

Advice on specific applications will be given on request. To contact Sika Corporation's Industry Technical Services Department, send an email to tsmh@us.sika.com. Copies of Safety Data Sheets and Product Data Sheets are available upon request.

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.

ENVIRONMENTAL, HEALTH AND SAFETY

For further information and advice regarding transportation, handling, storage and disposal of chemical products, user should refer to the actual Safety Data Sheets containing physical, environmental, toxicological and other safety related data. User must read the current actual Safety Data Sheets before using any products. In case of an emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

LEGAL DISCLAIMER

Prior to each use of any product of Sika Corporation, its subsidiaries or affiliates ("SIKA"), the user must always read and follow the warnings and instructions on the product's most current product label, Product Data Sheet and Safety Data Sheet which are available at usa.sika.com or by contacting Sika's Technical Service Department via email at

tsmh@us.sika.com. Nothing contained in any SIKA literature or materials relieves the user of the obligation to read and follow the warnings and instructions for each SIKA product as set forth in the current product label, Product Data Sheet and Safety Data Sheet prior to use of the SIKA product. SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within the product's shelf life. User determines suitability of product for intended use and assumes all risks. User's and/or buyer's sole remedy shall be limited to the purchase price or replacement of this product exclusive of any labor costs. **NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS.** Sale of SIKA products are subject to the Terms and Conditions of Sale which are available at <https://usa.sika.com/en/group/SikaCorp/termsandconditions.html> or by calling +1 800-933-7452.