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## Board Material

### Cibatool® BM 5185

### Medium density styling and modelling board

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**Key properties**

- Low coefficient of thermal expansion
- Very good surface structure
- Good machinability

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**Applications**

- Master models
- Styling

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**Typical product data**

Property	Test method	Test value
Colour	visual	apricot
Density g/cm <sup>3</sup>	-	0.4 - 0.5
Hardness (shore D)	-	-
Flexural strength, N/mm <sup>2</sup>	ISO 178	10 - 15
Deflection temperature °C	ISO 75	60 - 70
Compressive strength, N/mm <sup>2</sup>	ISO 604	10 - 15
Coefficient of thermal expansion, 10 <sup>-6</sup> .K <sup>-1</sup> Linear to °C	DIN 53752	45 - 50 50

Dimensions (mm)	1500 x 500 x 50	1500 x 400 x 100	1500 x 500 x 100
Volume (l)	37.5	60	75
Weight (kg)	15 - 18.75	24 - 30	30 - 37.5
Number of boards per	2	1	1
Number of boards per pallet	40	18	20

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**Bonding and  
repair**

System Resin Hardener	Araldite® SV 427-2 HY 5162	Araldite® CY 219 HV 2419	Ureol® 5202-1 A 5202-1 B
Mixing ratio (pbw)	100 : 35	100 : 45	100 : 100
Mixture appearance and characteristics	brown thin	*transparent slightly thixotropic	light beige, thin
Pot life (mins)	20	35	4 - 5
Minimum clamping time (hours)	12	12	3 - 5
Notes	*For a mixture of matching colour: to 100 g CY 219: 3g DW0131 white 0.3g DW0132 yellow 0.3g DW0133 red		

Repair System options	XW 5129 XW 5130	XW 5184 XW 5130
Mixing ratio (pbw)	100 : 1 - 3	100 : 1 - 3
Mixture appearance and characteristics	brown	brown, very fine
Pot life (mins)	4 - 6	4 - 6
Minimum curing time (mins)	25 - 30	25 - 30
Notes	Used mainly as a repair filler	Used mainly as a fine filler to achieve an extra smooth surface finish

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**Storage**

Cibatool BM 5185 may be stored flat in original cartons at 15° to 38°C.

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**Handling  
precautions****Caution**

Ciba Specialty Chemicals' products are generally quite harmless to handle provided that certain precautions normally taken when handling chemicals are observed. The uncured materials must not, for instance, be allowed to come into contact with foodstuffs or food utensils, and measures should be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected. The wearing of impervious rubber or plastic gloves will normally be necessary; likewise the use of eye protection. The skin should be thoroughly cleansed at the end of each working period by washing with soap and warm water. The use of solvents is to be avoided. Disposable paper - not cloth towels - should be used to dry the skin. Adequate ventilation of the working area is recommended. These precautions are described in greater detail in Ciba Specialty Chemicals publication No. 24264/3/e Hygienic precautions for handling plastics products of Ciba Specialty Chemicals and in the Ciba Specialty Chemicals Material Safety Data sheets for the individual products. These publications are available on request and should be referred to for fuller information.

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Duxford, Cambridge  
England CB2 4QA

Tel: +44 (0) 1223 832121  
Fax: +44 (0) 1223 493322

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