



SikaBlock[®] M600

Ready for every application

The brown model board SikaBlock[®] M600 offers as an allrounder manifold application options – for optimum results for your daily standard applications.

- density: 0.60 kg/ltr.
- excellent price/performance ratio
- simple machining with low dust formation
- high surface quality
- low coefficient of thermal expansion (CTE value)
- good compressive strength and edge stability
- adapted bonding solution Biresin[®] Kleber braun



BUILDING TRUST



SikaBlock[®] M600

AREAS OF APPLICATION

- Data control models and cubings
- Master models
- Mould for low pressure casting (RIM)
- Vacuum forming moulds for few pieces

PRODUCT BENEFITS

- Dense, fine surface
- Easy to seal and good to varnish
- Low dust formation when milled
- Easy machinability
- Very high dimensional stability
- Good compressive strength and edge stability
- Good heat distortion temperature

DESCRIPTION

- **Basis:** Polyurethan, light brown
- **Adhesive:** Biresin[®] Kleber braun Neu, 2K-PUR-System
- **Filler:** Biresin[®] Spachtel braun Neu, 2K-Polyester-System
- **Dimensions in mm:** 1500 x 500 x Dicke 30/50/75/100/150/200

PHYSICAL DATA (APPROX. VALUES)

Density	ISO 845	kg/ltr.	0.60
Shore hardness	ISO 868	-	D 58
Flexural strength	ISO 178	MPa	18 - 20
E-Modulus	ISO 178	MPa	750
Compressive strength	ISO 604	MPa	16 - 18
Impact resistance	ISO 179 Ue	kJ/m ²	8
Heat distortion temperature	ISO 75 B	°C	75 - 80
Linear thermal expansion coefficient α_T	DIN 53 752	K ⁻¹	55 x 10 ⁻⁶

MILLING PARAMETERS

Milling steps	1.	2.	3.	4.	5.	6.	7.
Strategy	Roughing Z - constant	Rest material Z - constant	Rest material Z - constant	Rest material Z - constant	Finishing flat areas	Finishing Z - constant	Finishing rest material shapes
Milling tool	Torus cutter	Torus copying cutter	Ball nose copying cutter	Ball nose copying cutter	Torus copying cutter	Ball nose copying cutter	Airline end mill cutter
Diameter [mm]	42	20	12	6	8	8	4
Number of teeth	3	2	2	2	2	2	2
Radius [mm]	3	4	6	3	1	4	2
Cutting speed (Vc) [m/min]	500	500	600	300	400	400	200
Revolutions [1/min]	3,800	8,000	15,900	16,000	16,000	16,000	16,000
Feedrate per tooth [mm]	0.74	0.62	0.2	0.2	0.15	0.15	0.15
Feed rate (Vf) [mm/min]	8,400	10,000	6,400	6,400	4,800	4,800	4,800
Cutting depth (ap) [mm]	5	2.5	2	0.5	0.3	0.15	0.1
Cutting width/Line spacing (ae) [mm]	30	10	2	0.5	4	0.3	0.1