



SikaBlock® M935 –
REALLY DOES MORE!

- More dimensional stability
- More price performance
- More length

SikaBlock® M935

THE ALLROUNDER TOOLING BOARD IN XXL-SIZE

The tooling board offers best price performance ratio with good mechanical properties and highest dimensional stability.

- Easy and fast milling
- Very high dimensional stability due to low CTE value
- Good edge stability
- Good abrasion resistance and swelling resistance
- Large length of 1500 mm for less bonding joints

SikaBlock[®] M935

AREAS OF APPLICATION

- Manufacture of foundry models, match plates and prototype core boxes
- Manufacture of accurate gauges, high-quality master models and various forms and tools.

PRODUCT BENEFITS

- Very high dimensional stability
- Good strength and abrasion resistance
- Easy and fast milling
- Easy workability with good surface aspect
- Reduce bonding joints by large plate dimension of 1500 mm x 500 mm

DESCRIPTION

- **Basis:** Polyurethan, green
- **Adhesive:** Biresin[®] Kleber Thix, 2K-EP-System, colourless, thixotropic
- **Adhesive:** Biresin[®] Kleber grün Neu, 2K-PUR-System (possible with accelerator Biresin[®]HC586)
- **Size in mm:** 1500 x 500 x thickness 30/50/75/100

PHYSICAL DATAS (APPROX. VALUES)

Density	ISO 845	g/cm ³	1.2
Shore hardness	ISO 868	-	D 83
Flexural strength	ISO 178	MPa	75
E-Modulus	ISO 178	MPa	2,900
Compressive strength	ISO 604	MPa	75
Heat distortion temperature	ISO 75 B	°C	90
Coefficient of thermal expansion (CTE), 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	Finsihing flat areas	Finishing Z-constant	Finsihing 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	Solid carbide ball nose 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	16,000	16,000	16,000	16,000	16,000
Feedrate per tooth [mm]	0.5	0.5	0.2	0.15	0.12	0.12	0.12
Feed rate (Vf) [mm/min]	5,700	8,000	6,400	4,800	3,800	3,800	3,800
Cutting depth (ap) [mm]	3	2	1	0.3	0.3	0.3	0.1
Cutting Width/ Line spacing (ae) [mm]	30	10	2	0.5	4	0.3	0.1

Our most current General Sales Conditions shall apply.

Please consult the Product Data Sheet prior to any use and processing.

Actual Product Data Sheets and information about additional products please find in:

www.sikaadvancedresins.com



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