



Prolab 65

Highest Surface Quality

Prolab 65 is especially suitable for high-class styling-, cubing- and master models with a very dense surface structure.

- Density 0.65 kg/ltr.
- Low effort for finishing
- Very good and dense surface - not foamed
- Directly paintable after grinding
- Low dust formation during milling
- Easy workable by hand
- High compressive strength and edge stability
- Good heat resistance
- High dimensional stability



BUILDING TRUST



Prolab 65

AREAS OF APPLICATION

- Manufacture of Design and Prototype Models
- Manufacture of Styling, Cubing and Master Models
- Manufacture of simple moulds for small series

PRODUCT BENEFITS

- Density 0.65 kg/ltr.
- Low effort for finishing
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DESCRIPTION

- **Basis:** Polyurethane, brown
- **Adhesive:** Biresin® Kleber braun / Prolab Glue
- **Filler:** Spachtel braun Neu
- **Dimensions for Prolab 65 in mm:**
1500 x 500 x
Thickness 30/50/75/100
- **Dimensions for Prolab 65 XL in mm:**
1500 x 500 x
Thickness 150/200

PHYSICAL DATA (APPROX. VALUES)

Density	ISO 2781	kg/ltr.	0.65
Shore hardness, 23° C	ISO 868	-	D 63
Flexural E-Modulus	ISO 178	MPa	1,000
Flexural strength	ISO 178	MPa	34
Compressive strength	ISO 604	MPa	28
Impact resistance (Charpy)	ISO 179/1eU	kJ/m ²	11
Glass transition temperature (Tg)	ISO 11359	°C	85
Linear thermal expansion coefficient α_T	ISO 11359	K ⁻¹	75 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	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]	540	500	600	300	400	400	200
Revolutions [1/min]	4,100	7,957	16,000	16,000	16,000	16,000	16,000
Feedrate per tooth [mm]	0.6	0.5	0.2	0.18	0.13	0.13	0.13
Feed rate (Vf) [mm/min]	7,380	7,957	6,366	5,760	4,160	4,160	4,160
Cutting depth (ap) [mm]	3	2	1	0.3	0.3	0.15	0.1
Cutting width/Line spacing (ae) [mm]	30	10	2	0.5	4	0.3	0.1