



MACHINABLE MEDIA

MACHINING PARAMETER GUIDE

BUILDING TRUST



MODELING BOARDS - POLYURETHANE

Product	Density (lbs/ft ³)	Color	Roughing Spindle Speed (RPM)	Roughing Feed (IPM)	Finishing Spindle Speed (RPM)	Finishing Feed (IPM)
Labelite 8GY	5	Gray	2,500	200	15,000	200
Labelite 25YW	16	Peach Yellow				
Labelite 350E	22	Orange				
SikaBlock® M600	37	Brown		100		
Prolab 65	42	Lt. Brown				

TOOLING BOARDS - EPOXY

SikaBlock® M974	45	Blue	1,600	40	10,000	100
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TOOLING BOARDS - POLYURETHANE

DP-1051 (Die Plank®)	52	Gray	1,600	40	10,000	100
PP-1052 (Pattern Plank®)	71	Red	1,500			
Lab 850	74	Red	1,500			
Lab 1000* (*Special Order Only)	104	Gray	1,600			

CUTTERS

ROUGHING	1" Ball End Mill 4-Flute Carbide
FINISHING	5/8" Ball End Mill 2-Flute Carbide

DEPTH

ROUGHING	Varies from ¼" to 2" deep with 40% step-over
FINISHING	Varies from 1/8" deep leaving 0.002 scallop height

TIPS

- Pressured air can be used for quick chip removal to prevent cutter heat build-up
- Eliminate burning by using sharp cutters and slower spindle speeds
- Coolant/machining fluid can be used for higher density tooling and high temperature boards. Wipe off immediately after use.
- To band saw cut dense boards (tooling boards) use a saw with offset carbide teeth to reduce binding

NOTE: These machining parameters are represented as starting points. Cutter type and material, spindle speed, feed rate, machine power and rigidity all affect results. User must determine the best parameters for specific situations.

Our most current General Sales Conditions shall apply.
Please consult the Data Sheet prior to any use and processing.

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