



SikaBlock® M600

Technical Data Sheet

POLYURETHANE MACHINABLE BOARD

MASTERS - PATTERNS - MOCK-UPS - PROTOTYPES

DENSITY 37 lbs/ft³ (0.60g/cc) - HARDNESS 58 SHORE D

DESCRIPTION

Machinable board designed for production of patterns, mock-ups, prototypes and masters by milling or machining by hand. Additional applications manufacture of molds for low pressure reaction injection molding, vacuum forming molds for lower number of pieces

PROPERTIES

- 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

PHYSICAL PROPERTIES			
Color			brown
Density at 74°F (23°C)	ISO 845	lbs/ft ³ (g/cc)	37 (0.60)
MECHANICAL PROPERTIES at 23°C			
Hardness	ISO 868	Shore D1	58
Flexural strength	ISO 178	psi (MPa)	2,800 (19)
Flexural modulus	ISO 178	psi (MPa)	109,000 (750)
Compressive strength	ISO 604 :2002	psi (MPa)	2,500 (17)
Impact strength (CHARPY)	ISO 179 Ue	ft.Lbf/in ² (kJ/m ²)	4 (8)
Heat distortion temperature (Tg)	ISO 75 B	°F (°C)	176 (80)
Coefficient of thermal expansion (CTE)	DIN 53 752	ppm/°F (°C)	31 (55)

ASSEMBLY / FINISH

SikaAxson tooling boards can be bonded with TCC-230 and/or EA-001

Repair paste – P-34

HANDLING PRECAUTIONS

Normal health and safety precautions should be observed when handling these products:

- Ensure good ventilation to prevent dust or chip accumulation
- Wear gloves, and safety glasses.
- Do not smoke when machining.

For further information, please consult the material safety data sheet.

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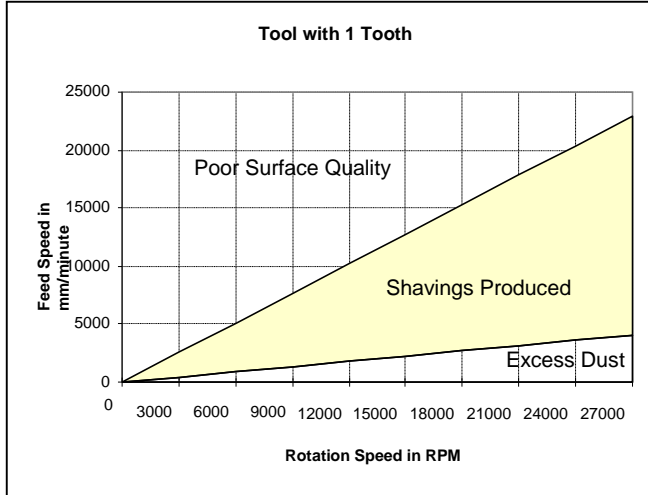
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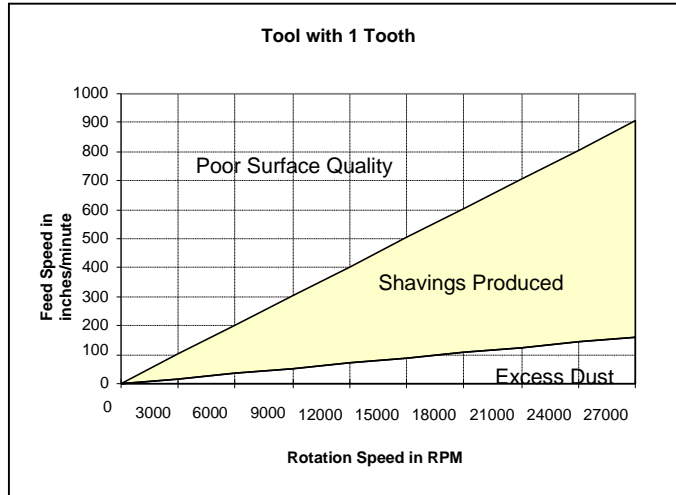
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Machining Recommendations



Metric Machining Envelope



English Machining Envelope

Machining Parameters

	Cutter edge velocity (Vc in ft/min (m/min))	Feed per tooth (fz in inches (mm)/revolution)
Rough shape	328 -1640 (100 to 500)	0.006 – 0.028 (0.15 to 0.70)
Finish	1312 – 2625 (400 to 800)	0.003 – 0.004 (0.07 to 0.10)

$n = (12 \text{ English or } 1000 \text{ metric}) \times Vc / (\pi \times Dc)$	$Vf = n \times fz \times Z$
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- Vc*: Cutter edge velocity in ft/min (m/minute)
- Dc*: Cutting diameter in inches (mm)
- n*: Spindle speed in revolution/minute
- fz*: Feed per tooth in inches (mm)/revolution
- Z*: Number of teeth
- Vf*: Feed speed in inches (mm)/minute

STORAGE CONDITIONS

- Store flat in a dry place. Allow time for material to come to ambient temperature prior to bonding or machining.

GUARANTEE

The information contained in this technical data sheet results from research and tests conducted in our laboratories under precise conditions. Seller cannot anticipate all conditions under which seller's products, or the products of other manufacturers in combination with seller's products, may be used. It is the responsibility of the user to determine the suitability of the SikaAxson's products, under their own conditions, before commencing with the proposed application. In no event shall SikaAxson US be liable for any direct, indirect, punitive, incidental, special, and/or consequential damages, to property or life, whatsoever arising out of or connected with the use or misuse of our products.