

One of both  
always fits!



## SikaBlock® M600 N / M700 N

### A POWERFUL PAIR

You have the choice. In addition to our Premium Model board SikaBlock® M700 N, which fulfills the highest quality needs, you can now obtain the new SikaBlock® M600 N, the Allrounder for the best results in standard daily applications. Both boards are identical in colour and one of them will fit in any case.

#### Top aesthetics for models

- Very fine surface
- Easy to seal and good paintability
- Good dimensional stability

#### Best resistance for mould making

- Good compressive and edge strength
- Good heat distortion temperature
- Good resistance to solvents

# SikaBlock® M600 N / M700 N

## AREAS OF APPLICATION

- Data control models and cubings
- Master models and negatives
- Moulds for Low pressure (RIM) casting
- Vacuum forming moulds for lower number of pieces

## MAIN PROPERTIES

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

## DESCRIPTION

- Basis: Polyurethane, light brown
- Adhesive: Biresin® Kleber braun Neu, 2K-PUR-System
- Filler: Biresin® Spachtel braun Neu, 2K-Polyester-System

### PHYSICAL DATA (APPROX. VALUES)

			SikaBlock® M600 N	SikaBlock® M700 N
Density	ISO 845	g/cm <sup>3</sup>	0.60	0.70
Shore hardness	ISO 868	-	D 58	D 64
Flexural strength	ISO 178	MPa	19	25
E-Modulus	ISO 178	MPa	850	1,100
Heat distortion temperature	ISO 75 B	°C	77	78
Glass transition temperature (Tg)	ISO 11359	°C	85	86
Linear thermal expansion coefficient $\alpha_T$	DIN 53 752	K <sup>-1</sup>	55 x 10 <sup>-6</sup>	55 x 10 <sup>-6</sup>

### 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]	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

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.sika.com/advanced-resins](http://www.sika.com/advanced-resins)



### Sika Deutschland GmbH

#### Business Unit Industry

Stuttgarter Strasse 139

72574 Bad Urach

Germany

Phone: + 49 (0) 7125 940-492

Fax: + 49 (0) 7125 940-401

E-Mail: [industry@de.sika.com](mailto:industry@de.sika.com)

[www.sika.com/advanced-resins](http://www.sika.com/advanced-resins)

### Sika Automotive France SAS

#### Business Unit Industry

Z.I. des Béthunes – 15 rue de l'Équerre

CS 40444 Saint Ouen l'Aumône

95005 Cergy pontoise Cedex – France

Phone: +33 (0) 134 40 34 60

Fax: +33 (0) 134 21 97 87

E-Mail: [advanced.resins@fr.sika.com](mailto:advanced.resins@fr.sika.com)

[www.sika.com/advanced-resins](http://www.sika.com/advanced-resins)

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