



GENERAL GUIDELINE

Milling Parameters for SikaBlock®

JANUARY 2026 / VERSION 03 / SIKA SERVICES AG

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1 PURPOSE AND SCOPE

This general guide contains information, rules and recommendations for milling applications of SikaBlock® materials. These materials are designed for tooling and modeling purposes and include polyurethane- and epoxy-based boards with varying densities and mechanical properties. The guide focuses on milling parameters and best practices to ensure optimal performance, surface quality, and tool longevity during machining processes.

Due to the diversity of milling equipment, cutting tools, and application requirements, the document does not aim to be exhaustive or complete. Its goal is to provide practical guidelines and easy-to-access references to designers, engineers and applicators working with SikaBlock® boards in prototyping, mold making, etc. It is assumed that readers have starting knowledge of mechanics and material properties.

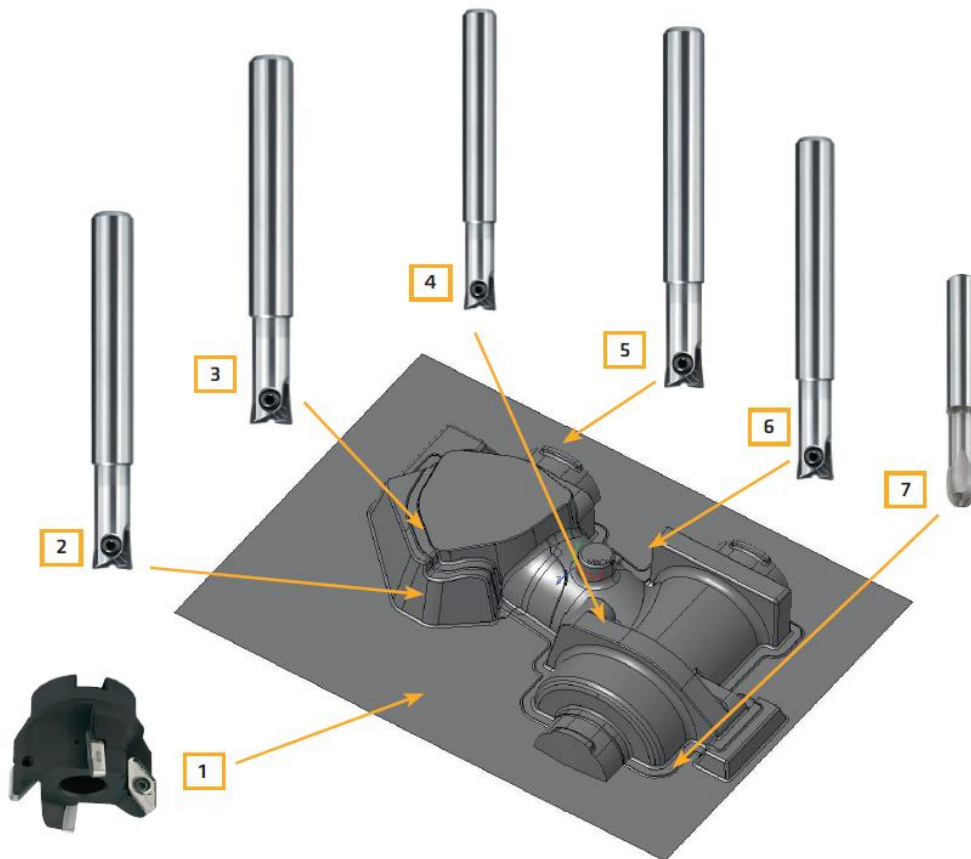
The following chapters cover key aspects of milling SikaBlock® materials, including: recommended cutting parameters and tool types, material-specific considerations and general handling guidelines.

The information herein is offered for general guidance only. The document is valid until the date stated on the front page or until a new version is issued. For more detailed information related to applications or products mentioned in this document, contact the Technical Department of Sika Industry.

2 SAFETY INSTRUCTIONS

Before starting the application or handling the product refer to the most recent Safety Data Sheets and Product Data Sheets.

3 MILLING PARAMETERS



The milling parameters for the specific machinable boards types were determined by LMT Tools GmbH & Co. KG using the model shown above.

Further information concerning the recommended milling tools can be obtained from the following address:

LMT Tools GmbH & Co. KG Tel: +49 (0)7821 943-0
 Vogesenstrasse 23 Fax: +49 (0)7821 943-213
 77933 Lahr info@lmt-tools.com
 Germany www.lmt-tools.com

CALCULATION BASIS

1. FORM SYMBOLS	2. CONVERSION FORMS
ae Cutting Width/Line spacing	$Vc = \frac{n \cdot \pi \cdot d}{1000} \text{ [m/min]}$
D Diameter	$n = \frac{Vc \cdot 1000}{d \cdot \pi} \text{ [1/min]}$
z Feedrate per tooth	$fz = \frac{vf}{z \cdot n} \text{ [mm]}$
Vc Cutting speed	$Vf = n \cdot fz \cdot z \text{ [mm/min]}$
ap Cutting depth	
n Revolutions	
Vf Feed rate	
z Number of teeth	



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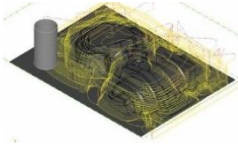
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4 MILLING STEPS

STEP 1

Roughing Z-constant
cutter head Ø 42 r3



Vc	500 m/min.
fz	0.5 mm
ap	5.0 mm
ae	30 mm

STEP 5

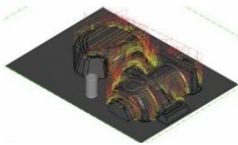
Finishing flat areas
WPB Ø 8 r1



Vc	400 m/min.
fz	0.1 mm
ap	0.3 mm
ae	4.0 mm

STEP 2

Roughing Z-constant
rest material WPB Ø 20 r4



Vc	500 m/min.
fz	0.5 mm
ap	2.5 mm
ae	10 mm

STEP 6

Roughing Z-constant
and optimizing WPR Ø 8 r4



Vc	400 m/min.
fz	0.1 mm
ap	0.15 mm
ae	0.3 mm

STEP 3

Roughing Z-constant
rest material WPR Ø 12 r6



Vc	600 m/min.
fz	0.2 mm
ap	2.0 mm
ae	2.0 mm



STEP 4

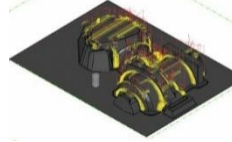
Roughing Z-constant
rest material WPR Ø 6 r3



Vc	300 m/min.
fz	0.15 mm
ap	0.5 mm
ae	0.5 mm

STEP 7

Roughing material shapes
5-axis VHM Ø 4 r2



Vc	200 m/min.
fz	0.1 mm
ap	0.1 mm
ae	0.1 mm

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5 DESIGN AND STYLING BOARDS

5.1 SIKABLOCK® M80/ML8 GY



Figure 1: SikaBlock® M80

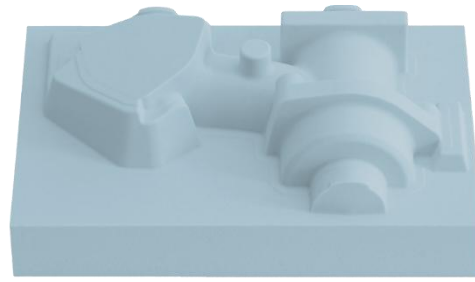


Figure 2: SikaBlock® ML8 GY

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	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]	593	500	600	300	400	400	200
Revolutions [1/min]	4 500	8 000	15 900	16 000	16 000	16 000	16 000
Feedrate per tooth [mm]	1	0.8	0.2	0.2	0.15	0.15	0.15
Feed rate (Vf) [mm/min]	13 500	12 800	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

PROCESSING

- SikaBlock® must be conditioned to 18 °C – 25 °C prior to be machined.
- SikaBlock® can be easily machined using conventional methods such as sawing, drilling, milling, etc.
- Bonding areas must be clean, dry and free of dust and grease or oil.
- For bonding SikaBlock® boards together, use SikaBiresin® B200 (for more information see Product Data Sheet).
- SikaBiresin® B370 shall be applied for leveling, repairing, and modeling tasks (for more information see Product Data Sheet).

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5.2 SIKABLOCK® M150/ML15 IY

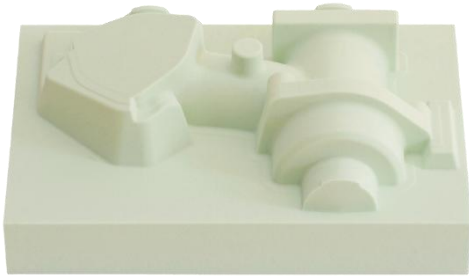


Figure 3: SikaBlock® M150



Figure 4: SikaBlock® ML15 IY

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	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]	593	500	600	300	400	400	200
Revolutions [1/min]	4 500	8 000	15 900	16 000	16 000	16 000	16 000
Feedrate per tooth [mm]	0.74	0.5	0.2	0.2	0.15	0.15	0.15
Feed rate (Vf) [mm/min]	10 000	8 000	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

PROCESSING

- SikaBlock® must be conditioned to 18 °C – 25 °C prior to be machined.
- SikaBlock® can be easily machined using conventional methods such as sawing, drilling, milling, etc.
- Bonding areas must be clean, dry and free of dust and grease or oil.
- For bonding SikaBlock® boards together, use SikaBiresin® B200 (for more information see Product Data Sheet).
- SikaBiresin® B370 shall be applied for leveling, repairing, and modeling tasks (for more information see Product Data Sheet).

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5.3 SIKABLOCK® M330/ML25 YW

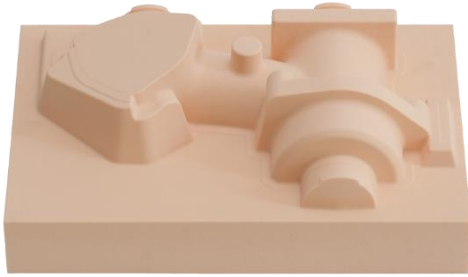


Figure 5: SikaBlock® M330/ML25 YW

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	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]	593	500	600	300	400	400	200
Revolutions [1/min]	4 500	8 000	15 900	16 000	16 000	16 000	16 000
Feedrate per tooth [mm]	0.74	0.5	0.2	0.2	0.15	0.15	0.15
Feed rate (Vf) [mm/min]	10 000	8 000	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

PROCESSING

- SikaBlock® must be conditioned to 18 °C – 25 °C prior to be machined.
- SikaBlock® can be easily machined using conventional methods such as sawing, drilling, milling, etc.
- Bonding areas must be clean, dry and free of dust and grease or oil.
- For bonding SikaBlock® boards together, use SikaBiresin® B200 (for more information see Product Data Sheet).
- SikaBiresin® B370 shall be applied for leveling, repairing, and modeling tasks (for more information see Product Data Sheet).

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5.4 SIKABLOCK® M440/ML35 OE

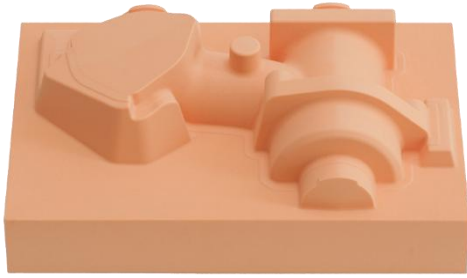


Figure 6: SikaBlock® M440/ML35 OE

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	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]	593	500	600	300	400	400	200
Revolutions [1/min]	4 500	8 000	15 900	16 000	16 000	16 000	16 000
Feedrate per tooth [mm]	0.74	0.5	0.2	0.2	0.15	0.15	0.15
Feed rate (Vf) [mm/min]	10 000	8 000	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

PROCESSING

- SikaBlock® must be conditioned to 18 °C – 25 °C prior to be machined.
- SikaBlock® can be easily machined using conventional methods such as sawing, drilling, milling, etc.
- Bonding areas must be clean, dry and free of dust and grease or oil.
- For bonding SikaBlock® boards together, use SikaBiresin® B200 or SikaBiresin® B260 (for more information see Product Data Sheet).
- SikaBiresin® B370 shall be applied for leveling, repairing, and modeling tasks (for more information see Product Data Sheet).

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5.5 SIKABLOCK® M450 N/ML45 PK

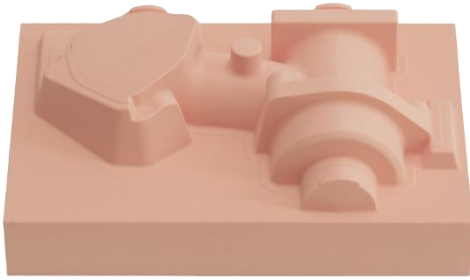


Figure 7: SikaBlock® M450 N



Figure 8: SikaBlock® ML45 PK

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	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]	593	500	600	300	400	400	200
Revolutions [1/min]	4 500	8 000	15 900	16 000	16 000	16 000	16 000
Feedrate per tooth [mm]	0.74	0.5	0.2	0.2	0.15	0.15	0.15
Feed rate (Vf) [mm/min]	10 000	8 000	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

PROCESSING

- SikaBlock® must be conditioned to 18 °C – 25 °C prior to be machined.
- SikaBlock® can be easily machined using conventional methods such as sawing, drilling, milling, etc.
- Bonding areas must be clean, dry and free of dust and grease or oil.
- For bonding SikaBlock® boards together, use SikaBiresin® B200 or SikaBiresin® B260 (for more information see Product Data Sheet).
- SikaBiresin® B370 shall be applied for leveling, repairing, and modeling tasks (for more information see Product Data Sheet).

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6 MODEL BOARDS

6.1 SIKABLOCK® M600 N/M700 N



Figure 9: SikaBlock® M600 N/M700 N

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	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	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

PROCESSING

- SikaBlock® must be conditioned to 18 °C – 25 °C prior to be machined.
- SikaBlock® can be easily machined using conventional methods such as sawing, drilling, milling, etc.
- Bonding areas must be clean, dry and free of dust and grease or oil.
- For bonding SikaBlock® boards together, use SikaBiresin® B260 (for more information see Product Data Sheet).
- SikaBiresin® B370 shall be applied for leveling, repairing, and modeling tasks (for more information see Product Data Sheet).

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6.2 SIKABLOCK® PROLAB 65 N/PROLAB 650 N



Figure 10: SikaBlock® PROLAB 65 N/PROLAB 650 N

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	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]	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

PROCESSING

- SikaBlock® must be conditioned to 18 °C – 25 °C prior to be machined.
- SikaBlock® can be easily machined using conventional methods such as sawing, drilling, milling, etc.
- Bonding areas must be clean, dry and free of dust and grease or oil.
- For bonding SikaBlock® boards together, use SikaBiresin® B260 (for more information see Product Data Sheet).
- SikaBiresin® B370 shall be applied for leveling, repairing, and modeling tasks (for more information see Product Data Sheet).

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7 TOOLING BOARDS

7.1 SIKABLOCK® M930

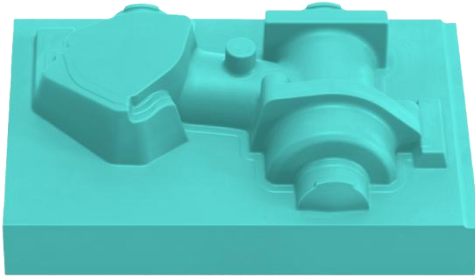


Figure 11: SikaBlock® M930

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	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]	650	650	600	250	400	400	200
Revolutions [1/min]	5 000	10 400	15 900	13 300	16 000	16 000	16 000
Feedrate per tooth [mm]	0.42	0.42	0.2	0.2	0.15	0.15	0.15
Feed rate (Vf) [mm/min]	6 300	8 800	6 400	5 300	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

PROCESSING

- SikaBlock® must be conditioned to 18 °C – 25 °C prior to be machined.
- SikaBlock® can be easily machined using conventional methods such as sawing, drilling, milling, etc.
- Bonding areas must be clean, dry and free of dust and grease or oil (cleaning e.g. with Sika® Cleaner G+M).
- For bonding SikaBlock® boards together, use SikaBiresin® B181 (for more information see Product Data Sheet).

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7.2 SIKABLOCK® M935

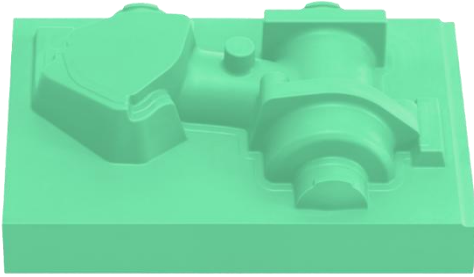


Figure 12: SikaBlock® M935

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	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

PROCESSING

- SikaBlock® must be conditioned to 18 °C – 25 °C prior to be machined.
- SikaBlock® can be easily machined using conventional methods such as sawing, drilling, milling, etc.
- Bonding areas must be clean, dry and free of dust and grease or oil (cleaning e.g. with Sika® Cleaner G+M).
- For bonding SikaBlock® boards together, use SikaBiresin® B181 (for more information see Product Data Sheet).

7.3 SIKABLOCK® M945

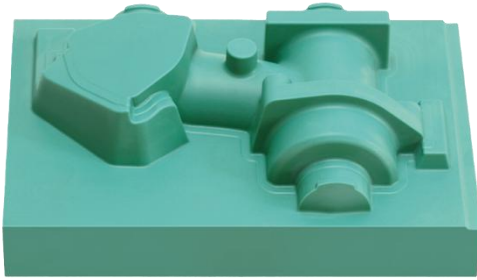


Figure 13: SikaBlock® M945

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	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	0.15	0.1
Cutting Width / Line spacing (ae) [mm]	30	10	2	0.5	4	0.3	0.1

PROCESSING

- SikaBlock® must be conditioned to 18 °C – 25 °C prior to be machined.
- SikaBlock® can be easily machined using conventional methods such as sawing, drilling, milling, etc.
- Bonding areas must be clean, dry and free of dust and grease or oil (cleaning e.g. with Sika® Cleaner G+M).
- For bonding SikaBlock® boards together, use SikaBiresin® B181 (for more information see Product Data Sheet).

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Corporate / English

7.4 SIKABLOCK® LAB 925



Figure 14: SikaBlock® LAB 925

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	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	0.15	0.1
Cutting Width / Line spacing (ae) [mm]	30	10	2	0.5	4	0.3	0.1

PROCESSING

- SikaBlock® must be conditioned to 18 °C – 25 °C prior to be machined.
- SikaBlock® can be easily machined using conventional methods such as sawing, drilling, milling, etc.
- Bonding areas must be clean, dry and free of dust and grease or oil (cleaning e.g. with Sika® Cleaner G+M).
- For bonding SikaBlock® boards together, use SikaBiresin® B181 (for more information see Product Data Sheet).

GENERAL GUIDELINE

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Corporate / English

7.5 SIKABLOCK® M960

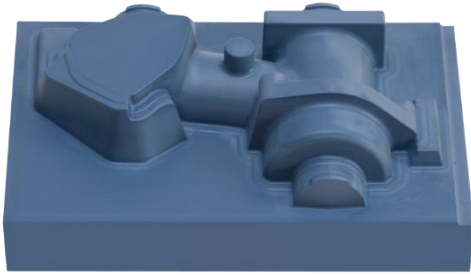


Figure 15: SikaBlock® M960

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	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	250	400	400	200
Revolutions [1/min]	3 800	8 000	15 900	13 300	16 000	16 000	16 000
Feedrate per tooth [mm]	0.5	0.5	0.2	0.2	0.15	0.15	0.15
Feed rate (Vf) [mm/min]	5 700	8 000	6 400	5 300	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

PROCESSING

- SikaBlock® must be conditioned to 18 °C – 25 °C prior to be machined.
- SikaBlock® can be easily machined using conventional methods such as sawing, drilling, milling, etc.
- Bonding areas must be clean, dry and free of dust and grease or oil (cleaning e.g. with Sika® Cleaner G+M).
- For bonding SikaBlock® boards together, use SikaBiresin® B181 (for more information see Product Data Sheet).

7.6 SIKABLOCK® LAB 850



Figure 16: SikaBlock® LAB 850

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	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]	3 789	7 957	16 000	16 000	16 000	16 000	16 000
Feedrate per tooth [mm]	0.4	0.5	0.2	0.15	0.12	0.12	0.1
Feed rate (Vf) [mm/min]	4 547	7 957	6 366	4 800	3 840	3 840	3 200
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

PROCESSING

- SikaBlock® must be conditioned to 18 °C – 25 °C prior to be machined.
- SikaBlock® can be easily machined using conventional methods such as sawing, drilling, milling, etc.
- Bonding areas must be clean, dry and free of dust and grease or oil (cleaning e.g. with Sika® Cleaner G+M).
- For bonding SikaBlock® boards together, use SikaBiresin® B181 (for more information see Product Data Sheet).

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Corporate / English

7.7 SIKABLOCK® M980

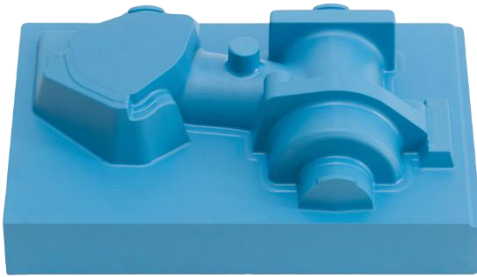


Figure 17: SikaBlock® LAB 850

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	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	15 900	16 000	16 000	16 000	16 000
Feedrate per tooth [mm]	0.5	0.5	0.2	0.15	0.1	0.1	0.1
Feed rate (Vf) [mm/min]	5 700	8 000	6 400	4 800	3 200	3 200	3 200
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

PROCESSING

- SikaBlock® must be conditioned to 18 °C – 25 °C prior to be machined.
- SikaBlock® can be easily machined using conventional methods such as sawing, drilling, milling, etc.
- Bonding areas must be clean, dry and free of dust and grease or oil (cleaning e.g. with Sika® Cleaner G+M).
- For bonding SikaBlock® boards together, use SikaBiresin® B181 (for more information see Product Data Sheet).

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Corporate / English

7.8 SIKABLOCK® M995

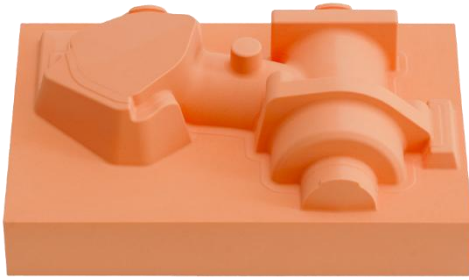


Figure 18: SikaBlock® M995

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	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	15 900	16 000	16 000	16 000	16 000
Feedrate per tooth [mm]	0.5	0.5	0.2	0.15	0.1	0.1	0.1
Feed rate (Vf) [mm/min]	5 700	8 000	6 400	4 800	3 200	3 200	3 200
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

PROCESSING

- SikaBlock® must be conditioned to 18 °C – 25 °C prior to be machined.
- SikaBlock® can be easily machined using conventional methods such as sawing, drilling, milling, etc.
- Bonding areas must be clean, dry and free of dust and grease or oil (cleaning e.g. with Sika® Cleaner G+M).
- For bonding SikaBlock® boards together, use SikaBiresin® B181 (for more information see Product Data Sheet).

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7.9 SIKABLOCK® LAB 1000/M1700

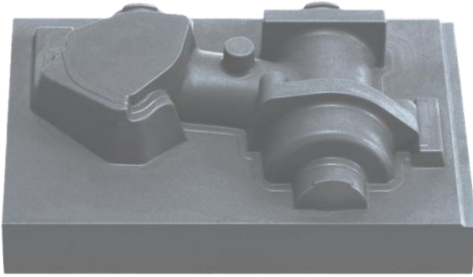


Figure 19: SikaBlock® LAB 1000/M1700

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	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	15 900	16 000	16 000	16 000	16 000
Feedrate per tooth [mm]	0.5	0.5	0.2	0.15	0.1	0.1	0.1
Feed rate (Vf) [mm/min]	5 700	8 000	6 400	4 800	3 200	3 200	3 200
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

PROCESSING

- SikaBlock® must be conditioned to 18 °C – 25 °C prior to be machined.
- SikaBlock® can be easily machined using conventional methods such as sawing, drilling, milling, etc.
- Bonding areas must be clean, dry and free of dust and grease or oil (cleaning e.g. with Sika® Cleaner G+M).
- For bonding SikaBlock® boards together, use SikaBiresin® B181 (for more information see Product Data Sheet).

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Corporate / English

7.10 SIKABLOCK® M1000/M1050

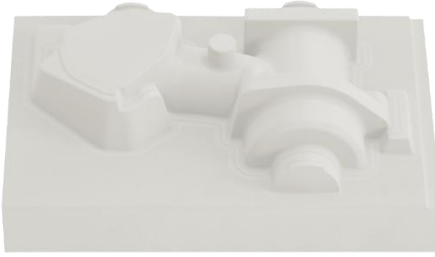


Figure 20: SikaBlock® M1000



Figure 21: SikaBlock® M1050

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	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]	650	650	600	250	400	400	200
Revolutions [1/min]	5 000	10 400	15 900	13 300	16 000	16 000	16 000
Feedrate per tooth [mm]	0.42	0.42	0.2	0.2	0.15	0.15	0.15
Feed rate (Vf) [mm/min]	6 300	8 800	6 400	5 300	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

PROCESSING

- SikaBlock® must be conditioned to 18 °C – 25 °C prior to be machined.
- SikaBlock® can be easily machined using conventional methods such as sawing, drilling, milling, etc.
- Bonding areas must be clean, dry and free of dust and grease or oil (cleaning e.g. with Sika® Cleaner G+M).
- For bonding SikaBlock® boards together, use SikaBiresin® B181 (for more information see Product Data Sheet).

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Corporate / English

8 EPOXY BOARDS

8.1 SIKABLOCK® M976 EP/LAB 975 New

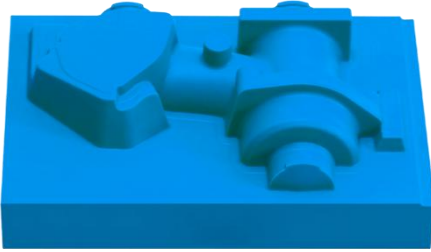


Figure 22: SikaBlock® M976 EP



Figure 23: LAB 975 New

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	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]	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

PROCESSING

- SikaBlock® must be conditioned to 18 °C – 25 °C prior to be machined.
- SikaBlock® can be easily machined using conventional methods such as sawing, drilling, milling, etc.
- Bonding areas must be clean, dry and free of dust and grease or oil.
- For bonding SikaBlock® boards together, use SikaBiresin® B176 (for more information see Product Data Sheet).

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Corporate / English

9 LEGAL NOTE

The information and, in particular, the recommendations relating to the application and end-use of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the products suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.