



Prolab 65

HIGHEST SURFACE QUALITY

Prolab 65 offers very dense surface structure and is especially suitable for high-class cubing and master models, core models and for foundry tools in first tests.

- 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

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
- 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

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 845	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 (T _g)	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
Feed rate 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

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.sikaadvancedresins.com



Sika Deutschland GmbH

Sika Advanced Resins

Stuttgarter Strasse 139
72574 Bad Urach

Germany

Telefon + 49 (0) 7125 940-492

Fax + 49 (0) 7125 940-401

E-Mail tooling@de.sika.com

www.sikaadvancedresins.de

Sika Automotive France SAS

Sika Advanced Resins

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

www.sikaadvancedresins.fr

BUILDING TRUST

