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## DESCRIPTION

*Abrasion resistant machining board designed for foundry patterns, core boxes and any other tools made by CNC.*

## PROPERTIES

- Outstanding impact resistance
- Very good abrasion resistance
- Easy machining
- Very good surface aspect after machining

### PHYSICAL PROPERTIES

	Test Method	Units	Test Results
Color			red
Density at 73°F (23°C)	ISO 2781 : 1996	Lbs/ft <sup>3</sup> (g/cc)	74 (1.18)

### MECHANICAL PROPERTIES at 73°F (23°C )

	Test Method	Units	Test Results
Hardness			
- at 73°F (23°C)	ISO 868 :2003	Shore D1 / D15	80 / 78
- at 176°F (80°C)			55 / -
Flexural modulus	ISO 178 : 2001	psi (MPa)	203,000 (1,400)
Flexural strength	ISO 178 :2001	psi (MPa)	8,300 (57)
Tensile modulus	ISO 527 :1993	psi (MPa)	218,000 (1,500)
Tensile strength	ISO 527 :1993	psi (MPa)	8,300 (35)
Elongation at break	ISO 527 : 1993	%	35
Compressive strength	ISO 604 :2002	psi (MPa)	5,900 (41)
Impact strength (CHARPY) <i>Unnotched specimens</i>	ISO 179/1eU :1994	ft.lbf/in <sup>2</sup> (kJ/m <sup>2</sup> )	34 (72)
Abrasion loss	ISO 5470-1 : 1999	in <sup>3</sup> (mm <sup>3</sup> )	0.006 (93)
Glass transition temperature (Tg)	ISO 11359 : 2002	°F (°C)	176 (80)
Coefficient of thermal expansion (CTE) 50 – 140°F (10 - 60°C)	ISO 11359 : 1999	10 <sup>-6</sup> .°F <sup>-1</sup> (°C)	53 (95)

## ASSEMBLY / FINISH

*Ambient Use Adhesive System - TCC230 Epoxy Adhesive with TCC-102 or TCC-104 Hardeners*  
*Fast Patch Paste - TCC-5220 A/B Fast Patch Paste*

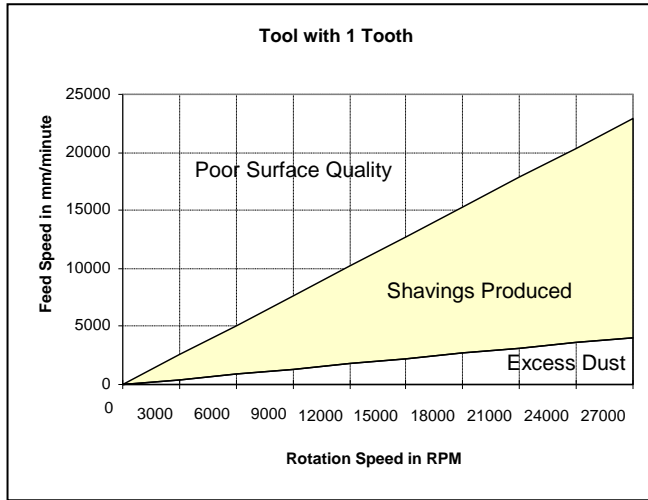
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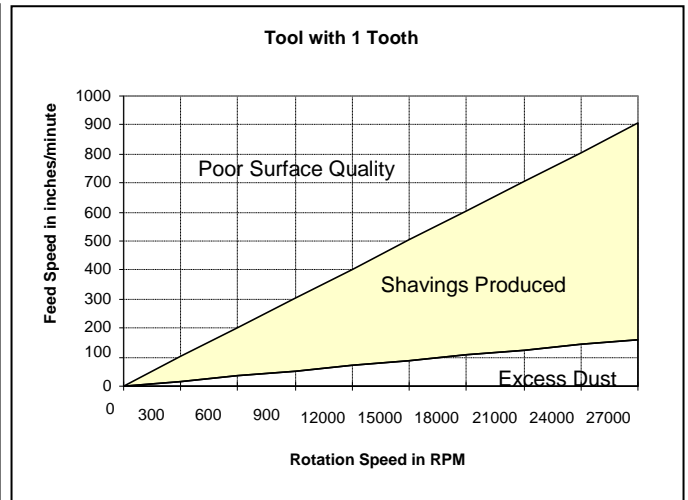
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## Machining Recommendations



Metric Machining Envelope



English Machining Envelope

### MACHINING PARAMETERS

	Cutter edge velocity (Vc in ft/min or (m/min))	Feed per tooth (fz in in or mm/revolution)
Rough shape	328 – 1312 (100 – 400)	0.021 (0.53)
Finish	1312 (400)	0.002 (0.06)

$$n = ((12 \text{ English or } 1000 \text{ metric}) \times Vc) / (\pi \times Dc)$$

$$Vf = n \times fz \times Z$$

- Vc: Cutter edge velocity in ft/min or (m/min)
- Dc: cutting diameter in in or (mm)
- n: Spindle speed in revolution/min
- fz: Feed per tooth in in or mm/revolution
- Z: number of teeth
- Vf: feed speed in in or mm/min

### STORAGE CONDITIONS

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



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## HANDLING PRECAUTIONS

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

- Ensure good ventilation
- Wear gloves, and safety glasses
- Do not smoke when machining.

For additional information, please consult the Safety Data Sheet (SDS).

## DISCLAIMER

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