

DESCRIPTION

Machinable slab with aluminum filler designed for checking fixtures

PROPERTIES

- Contains aluminum
- Excellent surface aspect after machining
- Very good dimensional stability
- Low density

PHYSICAL PROPERTIES			
Color		grey	
Density at 23°C	ISO 2781 : 1996	lbs./ft ³ (g/cc)	51 (0.82)

MECHANICAL PROPERTIES at 23°C			
Hardness	ISO 868 :2003	Shore D1	76
Flexural modulus	ISO 178 :2001	psi (MPa)	360,000 (2,500)
Flexural strength	ISO 178 :2001	psi (MPa)	6,600 (45)
Compressive strength	ISO 604 :2002	psi (MPa)	8,100 (56)
Coefficient of thermal expansion (CTE) (50 – 140°F) (10 – 60°C)	ISO 11357 : 1999	ppm/°F (°C)	27 (50)
Glass transition temperature (Tg)	ISO 11359 : 2002	°F (°C)	158 (70)
Impact strength (CHARPY) <i>Unnotched specimens</i>	ISO 179/1eU :1994	Ft.lbf/in ² (kJ/m ²)	3 (6)

(1) Average values obtained on slabs

ASSEMBLY / FINISH

Axson tooling boards can be bonded with H 9951 or AL 2120

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 further information, please consult the material safety data sheet.

MACHINING PARAMETERS

	Cutter edge velocity (Vc in ft/min (or m/min))	Feed per tooth (fz in inches (or mm/revolution))
Rough shape	820 (250)	0.011 (0.28)
Finish	1312 (400)	0.004 (0.09)

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

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

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

STORAGE CONDITIONS

The slabs must be stored in a dry place provided

GUARANTEE

The information contained in this technical data sheet result from research and tests conducted in our Laboratories under precise conditions. It is the responsibility of the user to determine the suitability of AXSON products, under their own conditions before commencing with the proposed application. AXSON guarantee the conformity of their products with their specifications but cannot guarantee the compatibility of a product with any particular application. AXSON disclaim all responsibility for damage from any incident which results from the use of these products. The responsibility of AXSON is strictly limited to reimbursement or replacement of products which do not comply with the published specifications.