

## DESCRIPTION

*Machinable slab designed for production of large dimensions patterns, mock-ups, prototypes and masters by CNC milling or machining by hand.*

## PROPERTIES

- Non-porous material
- Excellent surface aspect (direct paint after sanding)
- Thickness 150 or 200 mm available
- Machining by hand or by machine with wood cutting tools or aluminium cutting tools

PHYSICAL PROPERTIES		
Colour		brown
Specific gravity of cured product at 23 °C	ISO 2781 : 1996	0,73

MECHANICAL PROPERTIES at 23 °C			
Hardness	ISO 868 :2003	Shore D1	70
Flexural modulus	ISO 178 :2001	MPa	1,000
Flexural strength	ISO 178 :2001	MPa	34
Compressive strength	ISO 604 :2002	MPa	28
Impact strength (CHARPY)	ISO 179/1eU :1994	kJ/m <sup>2</sup>	11
Glass temperature transition (Tg)	ISO 11359 : 2002	°C	60
Coefficient of thermal expansion (CTE) (+10 à +40 °C)	ISO 11359 : 1999	10 <sup>-6</sup> .K <sup>-1</sup>	75

## ASSEMBLY / FINISH

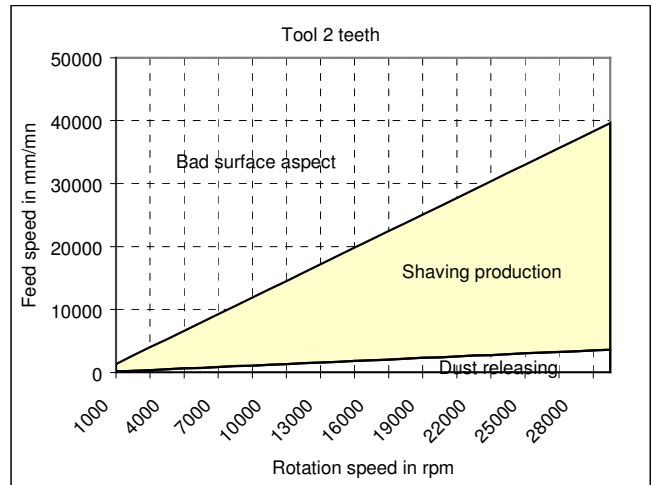
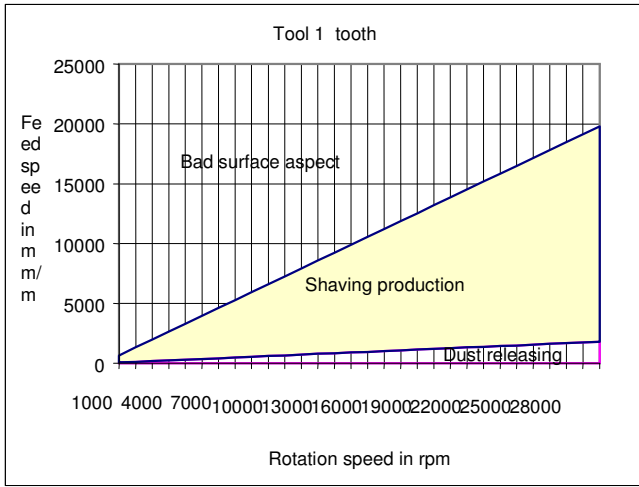
*Axson tooling boards can be bonded with PROLAB GLUE adhesive.  
Small surfaces bonding and finishing: A77/P mastic or EASYMAX.*

## HANDLING PRECAUTIONS

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

- ensure good ventilation,
- wear gloves, safety glasses and waterproof clothes,
- do not smoke when machining.

*For further information, please consult the product safety data sheet.*



## MACHINING PARAMETERS

	Cut speed (Vc in m/min)	Feed per tooth (fz in mm/revolution)
Rough shape	100 to 500	0,15 to 0,70
Finish	400 to 800	0,07 to 0,10

$$n = (1000 \times Vc) / (\pi \times Dc)$$

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

- Vc: Cutting speed in m/min
- Dc: cutting diameter in mm
- n: Spindle speed in revolution/min
- fz: Feed per tooth in mm/revolution
- Z: number of teeth
- Vf: feed speed in mm/min

## STORAGE CONDITIONS

Boards must be stored in a dry and temperate place.

## DIMENSIONS

- 1,500 x 500 x 150 mm
- 1,500 x 500 x 200 mm

## GUARANTEE

The information of our technical data sheet are based on our present knowledge and the result of tests conducted 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 refuse any guarantee about 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 guarantee conditions are regulated by our general sale conditions.