

DESCRIPTION

Stamping tools, checking fixtures, hammer forming tools.

PROPERTIES

- *Easy machining*
- *Excellent surface aspect after machining*
- *Produces shaving and little dust when worked*
- *Low coefficient of friction allowing sheet metal and flow on the tool*
- *Good dimensional stability*
- *High compressive strength*

PHYSICAL PROPERTIES		
Colour		grey
Specific gravity of cured product at 23°C	ISO 2781 : 1996	1.67

MECHANICAL PROPERTIES at 23°C			
Hardness	ISO 868 :2003	Shore D1 / D15	89 / 88
Flexural modulus	ISO 178 :2001	MPa	5,800
Flexural strength	ISO 178 :2001	MPa	90
Compressive Modulus	ISO 604 :2002	MPa	110
Impact strength (CHARPY) <i>Unnotched specimens</i>	ISO 179/1eU :1994	kJ/m ²	12
Glass transition temperature (Tg)	ISO 11359 : 2002	°C	92
Coefficient of linear thermal expansion (C _L TE) (+10 to +80°C)	ISO 11359 : 1999	10 ⁻⁶ .K ⁻¹	50

ASSEMBLY / FINIH

Axson LAB 1000 tooling boards can be bonded with H9951 adhesive long pot life (consumption about 400g/m²) or GC1 125 (consumption about 900g/m²).

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	0.35
Finish	400	0.06

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

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

- 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

The slabs must be stored in a dry place provided

DIMENSIONS

830 x 500 x 50 mm

830 x 500 x 100 mm

830 x 500 x 75 mm

Other larger dimensions possible in Mass Casting MC 1000 (please contact us).

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.