

## DESCRIPTION

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

## PROPERTIES

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

PHYSICAL PROPERTIES		
Colour	LAB 850 BE NEW	dark blue
Specific gravity of cured product at 23 °C	ISO 2781 : 1996	1.18

MECHANICAL PROPERTIES at 23 °C			
Hardness			
- at 23 °C	ISO 868 :2003	Shore D1 / D15	80 / 78
- at 80 °C			55 / -
Flexural modulus	ISO 178 : 2001	MPa	1,400
Flexural strength	ISO 178 :2001	MPa	57
Tensile modulus	ISO 527 :1993	MPa	1,500
Tensile strength	ISO 527 :1993	MPa	35
Elongation at break	ISO 527 : 1993	%	35
Compressive strength	ISO 604 :2002	MPa	41
Impact strength (CHARPY) <i>Unnotched specimens</i>	ISO 179/1eU :1994	kJ/m <sup>2</sup>	72
Abrasion loss	ISO 5470-1 : 1999	mm <sup>3</sup>	93
Glass transition temperature (Tg)	ISO 11359 : 2002	°C	80
Coefficient de dilatation linéaire (CTE) (+10 à +60 °C)	ISO 11359 : 1999	10 <sup>-6</sup> K <sup>-1</sup>	95

## ASSEMBLY / FINISH

*Axson tooling boards can be bonded with H 9951 adhesive ( long pot life - epoxy adhesive) or H 8110 BE ( short pot life – PU adhesive ), consumption about 400g/m<sup>2</sup>.*

MACHINING PARAMETERS		
	Cut speed (Vc in m/min)	Feed per tooth (fz in mm/revolution)
Rough shape	100 à 400	0.53
Finish	400	0.06

$n = ( 1000 \times Vc ) / ( \pi \times Dc )$	$Vf = n \times fz \times Z$
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- 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

## 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.

## DIMENSIONS

- 1000 x 500 x 50 mm
- 1000 x 500 x 75 mm
- 1000 x 500 x 100 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.