

RAMPF MB-0670

Polyurethane Board for Modeling

Typical Properties

Color	Brown
Density (ρ)	4.1.8 lb/ft ³ [0.67 g/cm ³]
Hardness	60 – 65 Shore D
Flexural Strength	2,900 – 3,600 psi [20 – 25 MPa]
Compressive Strength	2,200 – 2,900 psi [15 – 20 MPa]
Coefficient of Thermal Expansion (CTE)	(28 - 31) x 10 ⁻⁶ in/in ^o F [(50.4 – 55.8) x 10 ⁻⁶ m/m/ ^o C]
Deflection Temperature, HDT	167 – 176 °F [75 – 80 °C]

Machining

Cutters: *Roughing* - 1"(25.4mm) Hog Ball End Mill, 4-flute, HS Steel 8% Cobalt

Finishing - 5/8"(15.875mm) Ball End Mill, 2-flute carbide

Depth: *Roughing* - varied from 1/4"(6.35mm) to 2.5"(63.5mm) with 40% stepover

Finishing: 1/8"(3.175mm) deep leaving 0.002" (0.05mm) scallop height

Blades: Use carbide offset-tooth blade for faster cutting and less binding

Roughing speed: 2,000RPM · Roughing Feed 100IPM

Finishing speed: 15,000RPM · Finishing Feed 200IPM

Processing

The product should be machined at ambient room temperature (68-77 °F (20-25 °C)).

Storage

The material should be stored flat and in a dry place. Temperature variations should be avoided during storage and transportation.

Handling Precautions

Good workplace ventilation is to be ensured during processing. At the same time, the employer's liability insurance association's industrial hygiene safety regulations regarding the handling of reaction resins and their hardeners are to be observed.

Please take heed of the appropriate safety data sheets.

Available Sizes

1.0" x 19.7 x 59.1 (25mm x 500 x 1500) 2.0" x 24 x 60 (50mm x 610 x 1524)

2.0" x 19.7 x 59.1 (50mm x 500 x 1500) 3.0" x 24 x 60 (75mm x 610 x 1524)

3.0" x 19.7 x 59.1 (75mm x 500 x 1500) 4.0" x 24 x 60 (100mm x 610 x 1524)

3.9" x 19.7 x 59.1 (100mm x 500 x 1500)



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Key Properties

- Fine surface structure
- Easily shaped and machined
- Low coefficient of thermal expansion
- Good dimensional stability

Applications

- Master Models
- Cubing Models
- Patterns