

DESCRIPTION

Checking fixtures, stamping tools for non ferrous sheet metals, hammer forming tools.

PROPERTIES

- Excellent surface aspect after machining
- Low coefficient of friction allowing sliding
- High compressive strength
- Produces shavings (little dust)
- Gloss recovering
- Good dimensional stability

PHYSICAL PROPERTIES		
Colour		off-white
Specific gravity of cured product at 23 °C	ISO 2781 : 1996	1.60

MECHANICAL PROPERTIES at 23 °C			
Hardness	ISO 868 :2003	Shore D1 / D15	90
Compressive strength	ISO 604 :2002	MPa	120
Impact strength (CHARPY) <i>Unnotched specimens</i>	ISO 179/1eU :1994	kJ/m ²	10
Glass transition temperature (Tg)	ISO 11359 : 2002	°C	100
Coefficient of thermal expansion (CTE) (+10 to +80 °C)	ISO 11359 : 1999	10^{-6} K^{-1}	45

ASSEMBLY / FINIH

Axson LAB 1001 tooling boards can be bonded with ADEKIT A100 or GC1 050/GC 10 (about 900 g/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
- fz: Feed per tooth in mm/revolution
- Z: number of teeth
- Vf: feed speed

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
---------------------	----------------------

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.