

DESCRIPTION

Machinable slab designed for checking fixtures.

PROPERTIES

- Low density
- Excellent surface aspect (after machining)
- Very good dimensional stability

PHYSICAL PROPERTIES		
Colour		grey
Specific gravity of cured product at 23 °C	ISO 2781 : 1996	0,82

MECHANICAL PROPERTIES at 23 °C			
Hardness	ISO 868 :2003	Shore D1	76
Flexural modulus	ISO 178 :2001	MPa / <i>psi</i>	2,500 / 360,000
Flexural strength	ISO 178 :2001	MPa / <i>psi</i>	45 / 6,570
Compressive strength	ISO 604 :2002	MPa / <i>psi</i>	56 / 8,140
Coefficient of thermal expansion (CTE) (+50 to +140 °F)	ISO 11357 : 1999	$10^{-6}.K^{-1} / 10^{-6}.F^{-1}$	50 / 27
Temperature of glass transition (Tg)	ISO 11359 : 2002	°C / °F	70 / 158
Impact strength (CHARPY) <i>Unnotched specimens</i>	ISO 179/1eU :1994	kJ/m ²	6

(1) Average values obtained on slabs.

ASSEMBLY / FINISH

Axson tooling boards can be bonded with GC1 050/GC 10 or H 9951.

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	250	0,28
Finish	400	0,09

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

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

- 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

- 1,500 x 500 x 50 mm 61.07 x 19.70 x 1.97 inches
- 1,500 x 500 x 75 mm 61.07 x 19.70 x 2.95 inches
- 1,500 x 500 x 100 mm 61.07 x 19.70 x 3.94 inches

Other larger dimensions possible in Mass Casting MC 1151 (please contact us).

GUARANTEE

The information contained in this technical data sheet result from research and tests conducted in our Laboratories 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 guarantee the conformity of their products with their specifications but cannot guarantee 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 responsibility of AXSON is strictly limited to reimbursement or replacement of products which do not comply with the published specifications.