

DESCRIPTION

Machinable board with high dimensional stability for room temperature curing laminates.

PROPERTIES

- Low coefficient of thermal expansion
- Excellent surface aspect after machining
- Very good dimensional stability
- Low density

PHYSICAL PROPERTIES

Color		Off white	
Density at 77°F (25°C)		lbs./ft ³ (g/cm ³)	54 (0.86)

MECHANICAL PROPERTIES at 23°C

Hardness	ASTM D-2240	Shore D1	80
Tensile Strength	ASTM D-638	psi (MPa)	4,700 (32)
Tensile Modulus	ASTM D-638	psi (MPa)	442,000 (3,000)
Elongation	ASTM D-638	%	1%
Flexural strength	ASTM D-790	psi (MPa)	6,100 (42)
Flexural modulus	ASTM D-790	psi (MPa)	390,000 (2,700)
Compressive strength	ASTM D-695	psi (MPa)	9,700 (67)
Compressive modulus	ASTM D-695	psi (MPa)	297,000 (2,000)
Coefficient of thermal expansion (CTE) (50 – 140°F) (10 – 60°C)	ASTM E831-05	ppm/°F (°C)	18 (32)
Coefficient of thermal expansion (CTE) (50 – 176°F) (10 – 80°C)	ASTM E831-05	ppm/°F (°C)	22 (40)
Glass transition temperature (T _g)	ASTM E1545-00	°F (°C)	197 (92)
Impact strength (IZOD) <i>Unnotched specimens</i>	ASTM D-256	Ft.lbf/in (J/m)	0.3 (17)

(1) Average values obtained on slabs

ASSEMBLY / FINISH

Axson tooling boards can be bonded with AL 2108 or H9951

HANDLING PRECAUTIONS

Normal health and safety precautions should be observed when handling these products :

Ensure good ventilation

Wear gloves, and safety glasses.

Do not smoke when machining.

For further information, please consult the material safety data sheet.

MACHINING PARAMETERS		
	Cutter edge velocity (Vc in ft/min (or m/min))	Feed per tooth (fz in inches (or mm/revolution))
Rough shape	TBD (820 (250) for Lab 1151)	TBD (0.011 (0.28) for Lab 1151)
Finish	TBD (1312 (400) for Lab 1151)	TBD (0.004 (0.09) for Lab 1151)

$n = (12 \text{ English (or 1000 metric) } X Vc) / (PI X Dc)$	$Vf = n X fz X Z$
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- Vc: Cutter edge velocity in ft/mi or (m/min)
- Dc: cutting diameter in in or (mm)
- n: Spindle speed in revolution/min
- fz: Feed per tooth in inches (or mm)/revolution
- Z: number of teeth
- Vf: feed speed in inches (or mm)/min

STORAGE CONDITIONS

Product is to be stored flat in a dry place.

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.