

## Description

A board and block material made from recycled polyurethane.

## Features

- Made from recycled polyurethane.
- Large volume board material based on polyurethane.
- Good edge stability.
- Good scratch resistance.
- Dimensionally stable.
- Paintable.
- Compatible with silicone.
- Permeable to air.

## Applications

- Master and copy models.
- Cubing and data models.
- Styling and design models.
- Wind tunnel and water channel models.
- Architectural models.
- General modelling.

## Technical Data

	Typical Value
Colour	Beige
Coefficient of Thermal Expansion	Variable
Temperature Resistance	100°C
Compressive Strength	7.1 N/mm <sup>2</sup>
Flexural Strength	4.5 N/mm <sup>2</sup>
Modulus of Elasticity	30 MPa
Density	0.55 ± 0.04 gcm <sup>-3</sup>
Fire Protection Classification	B2

Modelboard M550 contains no halogens, plasticizer or solvent, it is manufactured fluorocarbohydrate free and is physiologically harmless.

## Machining

Modelboard M550 can be machined with wood or metal working tools and should be machined at 20 – 25°C.

Modelboard M550 is suitable for use with the majority of standard patternmaking adhesives and resins. We recommend carrying out compatibility tests before use. We recommend that boards are plane parallel to ensure a strong bond.

## Milling Parameters

	Roughing	Finishing
Type of Tool	Finishing Tools d = 80mm	Finishing Tools d = 80mm
Tool Diameter (d)	80 mm	80 mm
Cutting Speed (Vc)	50 m/sec	50 m/sec
Speed (n)	12000 min <sup>-1</sup>	8000 min <sup>-1</sup>
Feed Speed	10 m/min	7.5 m/min
Tooth Speed (fz)	0.21 mm	0.21 mm
Number of Teeth (z)	4	4
Cutting Depth (ae)	4 mm	0.5 mm
Cutter Mark Length (fzeff)	38 mm	5 mm

## Storage and Transport

Modelboard M550 should be stored on a flat surface, in dry conditions, at a temperature between 18 – 25°C. Variations in temperature should be avoided during storage.

## Board Sizes

Product Code	Dimensions
M550-2	2440 x 1220 x 50 mm

Surfaces are machined parallel.

## Tolerance

Product Code	Dimensions
Length	± 8 mm
Width	± 5 mm
Thickness	± 0.5 mm

## Further Information

This data is not to be used for specifications. Values listed are for typical properties and should not be considered minimum or maximum.

Our technical advice, whether verbal or in writing, is given in good faith, but without warranty. This also applies where proprietary rights of third parties are involved. It does not release you from the obligation to test the products supplied by us as to their suitability for the intended process and use.

Before using any of our products, users should familiarise themselves with the relevant Technical Data Sheet (TDS) and Safety Data Sheets (SDS) provided by Alchemie Ltd.

This material does not contain any fillers that release harmful dust during machining. Nevertheless, the dust content in the air should not rise above 6 mg/m<sup>3</sup>. Safety procedures recommended by the vocational co-operative of the chemical industry should be complied with. The article is not a regulatory product according to ICC regulations. In accordance with general local and national regulations waste is to be disposed by incineration in authorised places or conveyed to authorised tips (EAK 120105).

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