

# Technical Data Sheet

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## Model Board M600

### *0.65 g/cm<sup>3</sup> Polyurethane Model Board*

Model Board M600 is a board and block material with very fine structure and smooth surface finish which is easy to varnish for architectural and design applications. Model Board M600 is conveniently machinable and can also be processed manually.

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#### **Characteristics**

- Good edge stability
- Good scratch resistance
- Dimensionally stable
- Paintable
- Compatible with silicone

#### **Applications**

- Master models and copy models
- Styling and design models
- Architectural models
- General modeling

#### **Technical Data**

Property	Units	Typical Value
Colour	-	White
Coefficient of Thermal Expansion	K <sup>-1</sup>	60 x 10 <sup>-6</sup>
Temperature Resistance	°C	50
Hardness	Shore D	60
Compressive Strength	N/mm <sup>2</sup>	22
Flexural Strength	N/mm <sup>2</sup>	23
Density	g/cm <sup>3</sup>	0.65

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## Board Measurements

Product Code	Board Size (mm)
M600-2	1500 x 500 x 50
M600-3	1500 x 500 x 75

## Processing

Model Board M600 can be processed using wood or metal working tools. Boards of M600 can be combined by using EP 5941 Model Board adhesives.

Model Board M600 is CFC and HCFC free, and is physiologically harmless.

## Milling Parameters

Property	Roughing	Finishing
Type of Tool	Finishing Tools d = 80mm	Finishing Tools d = 80mm
Tool diameter [d] (mm)	80	80
Cutting Speed [Vc] (m/sec)	50	50
Speed [n] (1/min)	12000	8000
Feed Speed (m/min)	10	7.5
Tooth Speed [fz] (mm)	0.21	0.21
Number of Teeth [z]	4	4
Cutting Depth [a <sub>e</sub> ] (mm)	10	0.5
Cutter Mark Length [f <sub>zeff</sub> ] (mm)	38	10

## Storage / Transport

Model Board M600 boards should be stored on a flat surface in dry conditions at a temperature of between 18 and 25°C. Variations in temperature should be avoided during transport and storage.

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## **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 and MSDS 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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## **Alchemie Limited**

Alchemie Ltd develop, formulate and distribute Epoxy Resins, Polyurethane Resins, Silicones, Model Boards and Sheet Wax for use in the following applications:

- Electrical encapsulation
- Rapid Prototyping
- Prototypes
- Casting
- Gel Coating
- Laminating
- Model Making
- Master Models
- Flexible and rigid mould making

We offer fast service, technical support, development expertise, innovative products, diverse knowledge and experience.

We are a well-established company, with a high level of investment and experience. We implement BS EN ISO 9001.

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