

Description

Model Board M652 is a board and block material with very fine structure and smooth surface. It is easy to varnish and has excellent processing properties.

Features

- Very fine structure
- Smooth and paintable surface
- Excellent processing properties

Applications

- Master and copy models
- Cubing and data models
- General modelling

Technical Data

	Typical Value
Colour	Brown
Temperature Resistance	68 °C
Coefficient of Thermal Expansion	$40 \times 10^{-6} \text{ K}^{-1}$
Hardness	70D
Density	0.70 gcm^{-3}
Compressive Strength	26 Nmm^{-2}
Flexural Strength	30 Nmm^{-2}
Fire Protection Classification	B2
Thermal Conductivity	0.11 W/m.K

Model Board M652 contains no halogens, plasticizer or solvent, it is manufactured fluorocarbohydrate free and is physiologically harmless.

Processing

Boards of M652 can be combined using Model Board Adhesive MG 651. We recommend that boards are square and plane-parallel to ensure good glue joints

Machining

Model Board M652 can be machined with metal working tools and should be machined at 20 – 25°C.

Machining polyurethane boards with a laser may produce (depending on the processing temperature) visible sooty decomposition products, water vapor and carbon dioxide as well as carbon monoxide and nitrogenous compounds, including nitrogen oxides and traces of hydrogen cyanide and isocyanate vapours.

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^{-1}	8000 min^{-1}
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

Model Board M652 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 (mm)
M652-2	1500 x 500 x 50
M652-3	1500 x 500 x 75
M652-4	1500 x 500 x 100

Surfaces are machined parallel.

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/m³. 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).

Alchemie® and Alchemix® are registered trademarks of Alchemie Ltd.