



TECHNICAL DATA SHEET

SK2TM125-1

Epoxy tooling board for master-model

► DESCRIPTION

SK2TM125-1 can be used as master models for epoxy prepregs or heat curing composite tools or parts, short run vacuum forming moulds.

► PROPERTIES

- High dimensional stability
- Easy machining
- Low specific gravity
- High temperature resistance

PHYSICAL PROPERTIES		
Composition	-	Epoxy
Colour	-	Blue
Specific gravity at 23°C	ISO 2781 : 98	0.75

MECHANICAL AND THERMAL PROPERTIES AT 23°C			
Hardness	ISO 868 : 85	Shore D1	73
Flexural strength	ISO 178 : 93	MPa	30
Flexural modulus	ISO 178 : 93	MPa	2,200
Compressive strength	ISO 604 : 97	MPa	50
Coefficient of linear thermal expansion (C _L TE) (+10 to +100°C)	T.M.A.-Mettler	10 ⁻⁶ .K ⁻¹	35-45

Temperature °C		23	80	100	120	130
Hardness Shore D à 1 s	ISO 868 : 85	73	71	69	66	63

Owing these results, SK2TM125-1 could be used until a temperature of 125° C for prepreg curing with 4 bars pressure in autoclave.



TECHNICAL DATA SHEET

SK2TM125-1

Epoxy tooling board for master-model

► ASSEMBLY

Tooling boards SK2TM125-1 can be bonded with SK2TM125-2 (consumption about 600 g/m²).

► HANDLING PRECAUTIONS

Normal health and safety precautions should be observed when handling this product:

- ensure good ventilation
- wear gloves and safety glasses
- do not smoke when machining.

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

MACHINING PARAMETERS		
	Cutting speed (Cs in m/min)	Feed per tooth (mm/tr)
Roughing cut ⁽¹⁾	100 - 400	0,35
Finishing cut ⁽²⁾	400 - 800	0,05 - 0,15

(1) **Roughing cut:** Cutting parameters are determined with a carbide inserts ball nose endmill:

- Helix angle: 6°
- Clearance angle: 14°

(2) **Finishing cut:** Cutting parameters are determined with a 2 teeth ball nose endmill:

- Helix angle: 30°
- Clearance angle: 14°

Surface painting is recommended SK2TM80-3

► STORAGE

Storage conditions: it is recommended to store at temperature from -20°C until +30°C in the original packing.



TECHNICAL DATA SHEET

SK2TM125-1

Epoxy tooling board for master-model

► DIMENSIONS

Unit	Length	Width	Thickness
SK2TM125-1	1500mm	500mm	50mm
	1500mm	500mm	100mm
	1500mm	500mm	75mm

Please contact us for other dimensions.

► GUARANTEE

The information of our technical data sheet is based on our present knowledge and the result of tests conducted under precise conditions. It is the responsibility of the user to determine the suitability of the products, under their own conditions before commencing with the proposed application. We refuse any guarantee about the compatibility of a product with any particular application. We disclaim all responsibility for damage from any incident, which results from the use of these products. The guarantee conditions are regulated by our general sale conditions.