



TECHNICAL DATA SHEET

SK2TM75-4

Polyurethane board for master models

► DESCRIPTION

SK2TM75-4 - is a polyurethane board designed for production of patterns, mock-ups, prototypes and masters by milling or machining by hand.

► PROPERTIES

- Non porous material
- Excellent surface aspect (direct paint after sanding)
- Very good dimensional stability
- Machining by hand or by machine with wood cutting tools or aluminium cutting tools.



PHYSICAL PROPERTIES		
Colour		brown
Density at 23°C	ISO 2781 : 1996	0,65

MECHANICAL AND HEAT PROPERTIES AT 23°C			
Hardness	ISO 868 : 2003	Shore D1	63
Flexural modulus	ISO 178 : 2001	MPa	1,000
Flexural strength	ISO 178 : 2001	MPa	34
Compressive strength	ISO 604 : 2002	MPa	28
Impact strength (CHARPY)	ISO 179/1eU : 2002	kJ/m ²	11
Glass temperature transition (Tg)	ISO 11359 : 2002	°C	85
Coefficient of thermal expansion (CTE) (+10 to +60°C)	ISO 11359 : 1999	10 ⁻⁶ .K ⁻¹	75



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► ASSEMBLY / FINISH

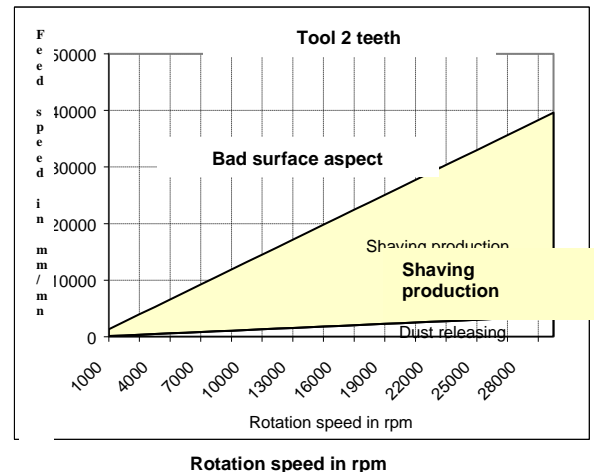
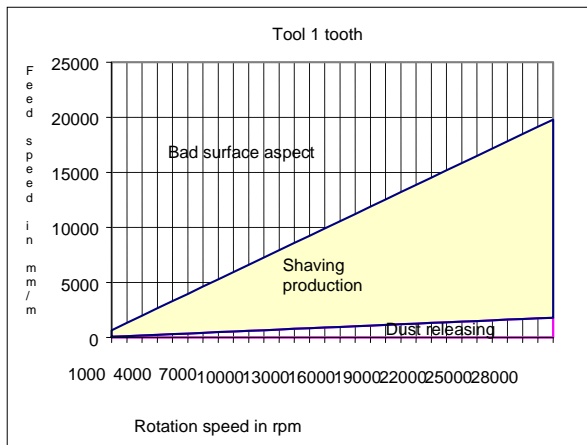
Polyurethane boards can be bonded with SK2TM75-5.
Small surfaces bonding and finishing SK2TM75-6.

► 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		
	Cut speed (Vc in m/min)	Feed per tooth (fz in mm/revolution)
Rough shape	100 to 500	0,15 to 0,70
Finish	400 to 800	0,07 to 0,10

$n = (1000 \times Vc) / (\pi \times Dc)$	$Vf = n \times fz \times Z$
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- Vc: Cutting speed in m/min
- Dc: Cutting diameter in mm
- n: Spindle speed in revolution/min
- fz: Feed per tooth in mm/revolution
- Z: Number of teeth
- Vf: Feed speed in mm/min



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► DIMENSIONS

Unit	Length	Width	Thickness
SK2TM75-4	850mm	500mm	30mm
	1500mm	500mm	75mm
	1500mm	500mm	150mm
	1500mm	500mm	50mm
	1500mm	500mm	100mm
	1500mm	500mm	200mm

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

► 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.