



# TECHNICAL DATA SHEET

## SK2TM80-1

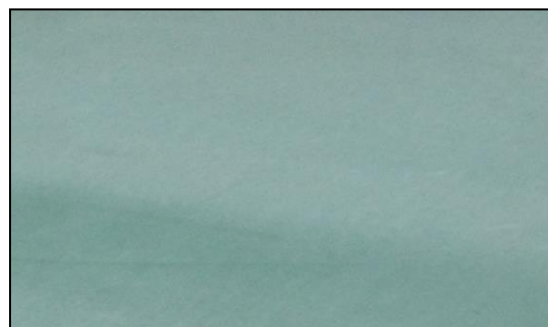
### Polyurethane abrasion resistant machinable board

#### ► DESCRIPTION

SK2TM80-1 – polyurethane abrasion resistant machinable board intended for models of foundry, core and any other tools machined in CNC machines.

#### ► PROPERTIES

- Outstanding impact resistance
- Easy machining
- Good abrasion resistance
- Very good surface aspect after machining



#### PHYSICAL PROPERTIES

Color		Green
Density at 23°C	ISO 2781 : 1996	1,30

#### MECHANICAL AND THERMAL PROPERTIES AT 23°C

Hardness	ISO 868 : 2003	Shore D1	85
Abrasion loss	ISO 5470-1 :1999	mm <sup>3</sup>	160
Compressive strength at yield	ISO 604 :2002	MPa	68
Flexural strength	ISO 178 : 2001	MPa	75
Flexural modulus	ISO 178 : 2001	MPa	1.900
Tensile strength	ISO 527 :1993	MPa	46
Elongation at break	ISO 527 :1993	MPa	8,5
Impact resistance (CHARPY) (ISO 179/1eU unnotched specimens)	ISO 179/1eU : 2002	kJ/m <sup>2</sup>	30
Temperature of glass transition (Tg)	ISO 11359 : 2002	°C	90



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Coefficient of thermal expansion (CTE) (+10 to +60°C)	ISO 11359 : 1999	$10^{-6} \cdot K^{-1}$	85
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#### ► ASSEMBLY

The boards SK2TM80-1 can be bonded with epoxy adhesive SK2TM80-2 or (long pot life – epoxy adhesive), consumption about 400 g/cm<sup>2</sup>.

MACHINING PARAMETERS		
	Cut speed (Cs in m/min)	Speed per rotation for 1 tooth (mm/tr)
Rough shape	100 to 400	0,30
Finish	400	0,06

*NOTE: To obtain good results use tools with an angle of cutting and angle of taper higher than zero.*

#### ► 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.

#### ► STORAGE

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

#### ► DIMENSIONS

Unit	Length	Width	Thickness
SK2TM80-1	1000mm	500mm	50mm
	1000mm	500mm	75mm
	1000mm	500mm	100mm

Please contact us for other dimensions.



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## ► 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.