



TECHNICAL DATA SHEET

SK2TM92-1

Model boards with metal filler

► DESCRIPTION

SK2TM92-1 board can be used for manufacturing stamping tools, checking fixtures and hammer forming tools.

Product contains aluminium filler in order to increase thermal conductivity.
Thermal Conductivity value: 0.9 W/m·K.

► PROPERTIES

- Easy machining
- Excellent surface aspect after machining
- Produces shaving and little dust when worked
- Low coefficient of friction allowing sheet metal and flow on the tool
- Good dimensional stability
- High compressive strength

PHYSICAL PROPERTIES		
Colour	-	Grey
Density at 23°C	ISO 2781 : 1996	1,67

MECHANICAL AND HEAT PROPERTIES AT 23°C			
Hardness	ISO 868 : 2003	Shore D1 / D15	89/88
Flexural modulus	ISO 178 : 2001	MPa	5,800
Flexural strength	ISO 178 : 2001	MPa	90
Compressive strength	ISO 604 :2002	MPa	110
Impact strength (CHARPY) Unnotched specimens	ISO 179/1eU :1994	kJ/m2	12
Glass temperature transition (Tg)	ISO 11359 : 2002	°C	92
Coefficient of thermal expansion (CTE) (+10 to +60°C)	ISO 11359 : 1999	10 ⁻⁶ .K ⁻¹	50



TECHNICAL DATA SHEET

SK2TM92-1

Model boards with metal filler

► ASSEMBLY / FINIH

Tooling boards SK2TM92-1 can be bonded with SK2TM80-2 epoxy adhesive long pot life (consumption about 400g/m²).

► SAFETY 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 (Vs in m/min)	Feed per tooth (fz in mm/revolution)
Rough shape	100	0,35
Finish	400	0,06

$n = (1000 \times Vc) / (\pi \times Dc)$	$Vf = n \times fz \times Z$
--	-----------------------------

- *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

► STORAGE

Storage conditions: it is recommended to store in a dry place at temperatures between -20°C and +30°C in original packing, protected from direct sun and heat source



TECHNICAL DATA SHEET

SK2TM92-1

Model boards with metal filler

► PACKAGING

Packing	Length	Width	Thickness
SK2TM92-1	830mm	500mm	50mm
	830mm	500mm	75mm
	830mm	500mm	100mm

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.