



NECURON® 250

BOARD MATERIAL - TECHNICAL DATA SHEET

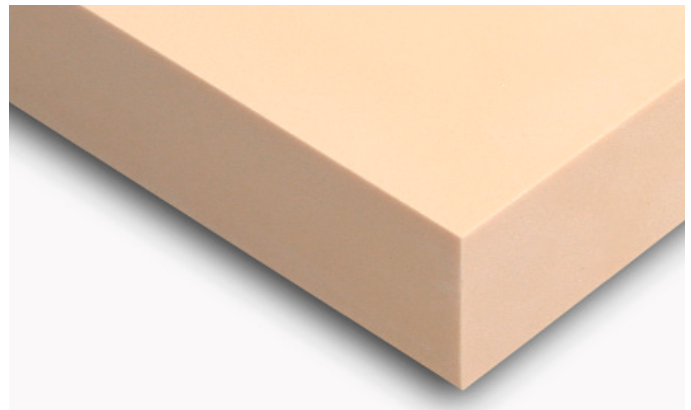
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CHARACTERISTICS

- processing possible by hand and machine
- pleasant and quick to process

APPLICATIONS

- test milling programmes
- back filling of moulds and patterns
- styling and display models
- test models
- draw dies
- substructure for hard styling clay
- large volume models



TECHNICAL DATA

Colour	apricot
Coefficient of thermal expansion	approx. $65 \times 10^{-6} \text{ K}^{-1}$
Temperature resistance	approx. 60 °C
Shore D	approx. 23
Compressive strength	approx. 3.6 N/mm ²
Flexural strength	approx. 5.1 N/mm ²
Density	approx. 0.25 g/cm ³
Abrasion resistance (at defined parameters)	approx. - mm ³
Fire protection classification	B3
Electrical current resistance	approx. - $\Omega \times \text{cm}$
Notched impact strength	approx. - kJ/m ²
Thermal conductivity	approx. - W/mk

- Contains no halogens, plasticizer or solvent
- Manufactured fluorocarbohydrate-free
- Physiologically harmless

DIMENSIONS

1,000	1,000	50	mm
1,000	1,000	100	mm
2000	1,000	100	mm

Surfaces machined parallel.

The deflection may be up to 10 mm per 2 m.

Other dimensions on request (max. dimension 3000 x 1000 x 200 mm).

STORAGE/TRANSPORT

NECURON®-boards should be stored on a flat underground and in a dry space at a temperature between 18°C and 25°C. Variations in temperature should be avoided during the transport and storage.



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PROCESSING

Adhesive	Colour	Mixture ratio A to B (by weight)	Pot life in minutes at 20°C	Curing time at 20°C in hours
NECURON® K0	cream-coloured	1:1	2-3	25-30 min

or usual and compatible patternmaking adhesives/resins
We recommend that boards are plane-parallel to ensure good glue joints.

MACHINING

Machining temperature: 20°C - 25°C
Tools: Wood- or metal-working tools

MILLING PARAMETERS

Type of tool	ROUGHING	FINISHING
	Finishing tools d=80mm	Finishing tools d=80mm
Tool diameter [d] (mm)	80	80
Cutting speed [Vc] (m/sek)	50	50
Speed [n] (1/min)	12000	8000
Feed speed (m/min)	12	8
Tooth speed [fz] (mm)	0.25	0.25
Number of teeth [z]	4	4
Cutting depth [ae] (mm)	10	0.5
Cutter mark length [fzeff] (mm)	38	15

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- 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).
- Technical statements and recommendations refer to current standard of technique and are based on our own experience. Further developments and improvements are reserved. Due to the variety of processing possibilities own experiments are recommended to optimise results.
- This data sheet is not legally binding. Actual specifications and / or features may vary.