



NECUMER
SOLID SOLUTIONS

NECURON[®] 730

EPOXY BOARD MATERIAL - TECHNICAL DATA SHEET

TECHNICAL DATA

Colour
Coefficient of thermal expansion
Temperature resistance
Shore D
Compressive strength
Flexural strength
Density
Abrasion resistance (at defined parameters)
Fire protection classification
Electrical current resistance
Notched impact strength
Thermal conductivity

CHARACTERISTICS

- EPOXY BOARD
- VERY HIGH TEMPERATURE RESISTANCE
- VERY LOW COEFFICIENT OF THERMAL EXPANSION

APPLICATIONS

- PREPREG LAY UP TOOLS
- VAC FORM TOOLS
- LAMINATING PATTERNS AND TOOLS

DIMENSIONS

BASIC FORMAT (MM)

1,500 x 500

AVAILABLE HEIGHTS (MM)

10, 15, 20, 25, 30, 35,
40, 45, 50, 75, 100, 150

Other dimensions on request.

Surfaces machined parallel.

blue
approx. 29×10^{-6} K⁻¹
approx. 130 - 135 °C
approx. 75
approx. 57 N/mm²
approx. 33 N/mm²
approx. 0.8 g/cm³
approx. - mm³
-
approx. - Ω x cm
approx. - kJ/m²
approx. - W/mk

visual
DIN 53752-B
ISO 75
ISO 868
DIN 53421
ISO 178
ISO 845
DIN ISO 4649
DIN 4102
IEC 93
ISO 179-1
DIN 52612

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

PROCESSING

ADHESIVE	COLOUR	MIXTURE RATIO A TO B (BY WEIGHT)	POT LIFE IN MINUTES AT 20°C	CURING TIME AT 20°C
NECURON® K7S	STRAW- COLOURED	1:0,25	20-30	4-5 HRS

■ 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: Metal-cutting tools

When producing voluminous models from NECURON® 730 VP, we generally recommend to ensure, that the material is not thicker than 10 cm (recommendation: milling the inside of the tool) to assure an even heating of the tool. This measure prevents the formation of cracks.

Recommendation for tempering: Increase by 1°C every 3 minutes

Machining epoxy boards with a laser may produce (depending on the processing temperature) visible sooty decomposition products, water vapor and carbon dioxide as well as carbon monoxide and traces of phenols.

MILLING PARAMETERS

PARAMETERS

Type of tool
Tool diameter [d](mm)
Cutting speed [Vc](m/sek)
Speed [n](1/min)
Feed speed (m/min)
Tooth speed [fz](mm)
Number of teeth [z]
Cutting depth [ae](mm)
Cutter mark length [fzeff](mm)

ROUGHING

Finishing tools d=80mm
80
50
12000
10
0.21
4
6
38

FINISHING

Finishing tools d=80mm
80
50
8000
7.5
0.21
4
0.5
5-10

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 transport and storage.

NECURON® 730

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.

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