

DE-COMP COMPOSITES, INC.

MACHINE URETHANE DIE BOARD STOCK

TB-800



General Description: TB-800 is a tough, dimensionally stable, urethane board stock. Uses for dies, fixtures, stretch forms, etc.

Typical Properties:

Color	Red
Density (g/cm ³)	1.17
Hardness, Shore D	85-90
Compressive Strength (psi)	12,800
Compressive Modulus	4.4×10^5
Flexural Strength (3point)(psi)	8,990
Flexural Modulus	4.4×10^5
Tensile Strength(psi)	10,370i
Glass transition Temperature (TG)	107 C
Coefficient of Thermal Expansion	3.8×10^{-5}

RECOMMENDED CNC MACHINING INFORMATION (CARBIDE CUTTERS ARE HIGHLY RECOMMENDED)

	INCHES PER MINUTE FEED IPM	PLUNGE	SPINDLE SPEED-RPM
2"E-Mill for Roughing .200" Pick	100	25	6000
2"E-Mill for Finishing	60	25	6000
3/4"Ball	75	20	3000+
1/2"Ball	60-75	10-20	3000+
1/2"x 1/32"R	40	20	4000
1/4"Ball	60	10-20	5000

THESE ARE POSSIBLE RECOMMENDATIONS. THERE MIGHT BE SOME VARIANCE DEPENDING ON CUTTERS AND CNC MILLS CAPABILITIES.

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Section: Tooling Materials

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