

KBoard 45

POLYURETHANE MACHINABLE SLAB
MASTERS - PATTERNS - MOCK-UPS - PROTOTYPES
SPECIFIC GRAVITY: 0.45 - HARDNESS 47 SHORE D

APPLICATIONS

Machinable slab designed for production of patterns, mock-ups, prototypes and masters by milling or machining by hand.

PROPERTIES

- Non porous material
- Excellent surface aspect (direct paint after sanding)
- Very good dimensional stability
- Machining by hand or by machine with wood cutting tools or aluminium cutting tools

PHYSICAL PROPERTIES (1)		
Colour	-	pink
Density at 23°C	ISO 2781 : 1996	0.45

MECHANICAL AND HEAT PROPERTIES AT 23°C (1)			
Hardness	ISO 868 : 2003	Shore D1	47
Coefficient of thermal expansion (CTE) (+25° to +70°C)	ISO 11359 : 1999	10 ⁻⁶ .K ⁻¹	75
Glass temperature transition	ISO 11359 : 2002	°C	70
Compressive yield strength	ISO 604 : 2002	MPa	11

(1) Average values obtained on slabs

ASSEMBLY

Kirside Products KBoard may be bonded with most epoxy adhesives or mastics on small surfaces.

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.

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MACHINING PARAMETERS ⁽²⁾

	Cut speed (Cs in m/min)	Speed per rotation for 1 tooth (mm/tr)
Rough shape	100 at 500	0.15 at 0.90
Finish	400 at 800	0.07 at 0.10

(2) Parameters defined with tools with angle of cutting and angle of taper higher than zero.

DIMENSIONS

- 1.550 x 500 x 50 mm
- 1.550 x 500 x 75 mm
- 1.550 x 500 x 100 mm

STORAGE

The slabs must be stored in a dry place provided.

GUARANTEE

The information on this 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 Kirkside Products KBoard, under their own conditions before commencing with the proposed application. Kirkside Products refuse any guarantee about the compatibility of a product with any particular application. Kirkside Products 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.