



MB3500

FIXTURE AND PATTERN PLANK

BCC Products now offers the MB3500 a revolutionary state-of-the-art machinable fixture board for today's demanding tooling requirements. MB 3500 is an extremely tough, high impact Urethane Plank, that can replace aluminum and other metals for many foundry applications.

- * Excellent machinability
- * Low dust emission, mostly shavings
- * No shrinkage
- * Excellent impact and wear resistance
- * Excellent surface detail reproduction
- * Excellent surface finish
- * Fixtures
- * Proofing intricate NC designs
- * Numerous tooling aids
- * Various prototypes
- * Architectural models
- * Foundry patterns and core boxes
- * Jigs



We even make the perfect repair material. The only one on the market for MB3500

SPECIFICATIONS/PHYSICAL PROPERTIES

Color	Gray or White
Density, ASTM D-792 (lbs/ft ³ ; gms/cm ³).....	48; .77
Hardness, ASTM D-2240, Shore D	73 + 2
Ultimate Tensile Strength (psi).....	6,525
Flexural Strength, ASTM D-790, psi	11,660
Flexural Modulus, ASTM D-790, psi.....	337,200
Heat Distortion Temperature, ASTM D-648 F (C).....	200 (93)
Coefficient of Thermal Expansion per TMA, ASTM D-3386	
in/in/ F (-22 F to +86 F).....	29.00 x 10 ⁻⁶
Glass Transition Temp., DMA, ASTM D-4065, F (C)	215 (101)
Repair Material	BC4553 Gray
Adhesive.....	BC5003 Clear

BCC Products Inc.

2140 Earlywood Dr. • Franklin, IN 46131

Order-Line: 800-556-0067 • Fax: 317-736-4872 • www.bccproducts.com



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ADDITIONAL SPECIFICATIONS/INFORMATION

Packaging

MB 3500 is offered in GRAY and WHITE color. A standard carton of MB 3500 contains one 60 inch x 16 inch x 2 inch board which yields approximately 13 1/3 board feet. For convenience, the MB 3500 Fixture Board is shipped pre-planed (top and bottom surfaces) for preparation in gluing assembled pieces.

In Stock Sizes:

2" x 16" x 60"

3" x 16" x 60"

4" x 16" x 60"

1" x 24" x 60"

2" x 24" x 60"

3" x 24" x 60"

4" x 24" x 60"

Special Order Sizes:

5" x 24" x 60"

6" x 24" x 60"

Machining (Recommendations)

Roughing Speed

1500-2000 RPM

Roughing Feed

50-70 IPM

Finishing Speed

3200-6000 RPM

Finishing Feed

100-200 IPM

Cutters:

Roughing: 1/2" Ball End Mill - 4 Flute Carbide

Finishing: 1/2" Ball End Mill - 4 Flute Carbide

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