



# MB4000

## FOUNDRY AND PATTERN PLANK

BCC Products now offers a revolutionary state-of-the-art machineable foundry plank for today's demanding tooling requirements. MB4000 Red 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
- \* Polishable to a high gloss
- \* Proofing intricate NC designs
- \* Numerous tooling aids
- \* Various prototypes
- \* Architectural models
- \* Foundry patterns and core boxes
- \* Short run metal stamping dies



We specially formulated the repair material, its the only one on the market for MB4000

### SPECIFICATIONS/PHYSICAL PROPERTIES

Color.....	Red
Density, ASTM D-792 (lbs/ft3; gms/cm3).....	71; 1.14
Hardness, ASTM D-2240, Shore D .....	86
Ultimate Tensile Strength (psi).....	10,890
Elongation, ASTM D-638, %.....	14.5
Flexural Strength, ASTM D-790, psi.....	17,350
Flexural Modulus, ASTM D-790, psi.....	428,300
Heat Distortion Temperature, ASTM D-648 °F (°C) .....	214 (101)
Coefficient of Thermal Expansion per TMA, ASTM D-3386	
in/in/°F (-22°F to +86°F) .....	35.60x10-6
in/in/°C (-30°C to +30°C) .....	64.08x10-6
Glass Transition Temp., DMA, ASTM D-4065, °F (°C).....	240 (115.6)
Notched Izod Impact, ASTM D-256, ft.lb./in. ....	.85
Un-notched Izod Impact, ASTM D-256, ft.lb./in. ....	21.96
Repair Material .....	DP-11-75
Adhesive.....	BC5003 Red

### BCC Products Inc.

2140 Earlywood Dr. • Franklin, IN 46131

Order-Line: 800-556-0067 • Fax: 317-736-4872 • [www.bccproducts.com](http://www.bccproducts.com)



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### ADDITIONAL SPECIFICATIONS / INFORMATION

#### Packaging

MB4000 is offered in RED color. A standard carton of MB4000 contains one 60 inch x 16 inch x 2 inch board which yields approximately 13 1/3 board feet. For convenience, the MB 4000 Foundry Plank is shipped pre-planed (top and bottom surfaces) for preparation in gluing assembled pieces.

#### Available Sizes:

2" x 16" x 60"	1" x 24" x 60"
3" x 16" x 60"	2" x 24" x 60"
4" x 16" x 60"	3" x 24" x 60"
4" x 24" x 60"	

#### Special Order Sizing:

5" x 24" x 60"
6" x 24" x 60"

#### Machining (Recommendations)

<i>Roughing Speed</i>	<i>Roughing Feed</i>	<i>Finishing Speed</i>	<i>Finishing Feed</i>
1500-2000 RPM	50-70 IPM	3200-6000 RPM	100-200 IPM

#### Cutters:

*Roughing:* 1/2" Ball End Mill - 4 Flute HS Steel 8% Cobalt

*Finishing:* 1/2" Ball End Mill - 4 Flute HS Steel 8% Cobalt

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