



BCC PRODUCTS, INC.

BLEHM PLASTICS

FAST CAST – EPOXIES – ADHESIVES - POLYSULFIDES - URETHANES – POLYESTER PASTES – TOOLING BOARDS – RELEASE AGENTS – SILICONES

FOAM TOOLING & MODELING BOARD

(MACHINEABLE)

MB1100

MB 1100 is an Olive colored rigid closed-cell polyurethane foam tooling and modeling board. MB 1100 is low density foam of approximately 10lbs/ft³ board. Easily cut using CNC machining equipment or by hand the MB 1100 is perfectly suited for temporary master models, architectural design models, foundry patterns as well as design verification and prototype tools.

Outstanding Features

- * Easily machined or hand carved
- * Very little abrasion
- * No shrinkage
- * Excellent at high speed cutting
- * Excellent surface finish
- * Exceptional dimensional stability

Uses

- * Proofing intricate CNC designs
- * Numerous tooling aids
- * Temporary master models (automotive/aerospace)
- * Various prototypes
- * Architectural models
- * Foundry applications
- * Bases for die models

Physical Properties

Density (lbs/ft ³)	10
Hardness (Shore D)	20
Tensile Strength (psi)	350
Flexural Strength (psi)	380
Service Temperature (min/max)	-300/+195
Compressive Strength	280
Coefficient of Thermal Expansion (in./in./EF)	33 x 10 ⁻⁶

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MODEL & TOOLING BOARD

MB 1100

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Availability

For convenience, MB 1100 is shipped pre-planed (top and bottom surfaces) for preparation in gluing assembled pieces.

Available sizes:	2" x 24" x 96"	2" x 48" x 96"
	4" x 24" x 96"	4" x 24" x 96"
	6" x 48" x 96"	6" x 48" x 96"
	8" x 24" x 96"	8" x 48" x 96"

Construction Hints

1. In order to achieve the required thickness for models and patterns with heights greater than two inches it is necessary to cut (saw) MB 1100 lengthwise into as many sections needed for your model.
2. Apply BC 5003 Epoxy Laminating System or DP-11-83 adhesive to each surface to be mated. Clamp with minimal pressure and allow curing overnight at room temperature. Excess clamping pressure can cause surface defects and stress upon the completed model.
3. The glued MB 1100 assembly can now be bonded to a chosen base plate using BC 5003 Laminating System and fiberglass cloth. Suggested base plate materials are: Impreg Wood, metal tubing, fabricated honeycomb panel or MB 1100 Foam Board.
4. MB 1100 is now ready to be carved or machined. Standard woodworking tools and/or high speed steel cutters are recommended for contouring to required size.
5. Finish with pattern coating or sanding lacquer sealer.

Machining/CNC Milling

(Recommendations)

Speed 1500-1600 RPM	Feed 50-80 IPM	Cutters:	2 or 4 flute drill bit
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