



BCC PRODUCTS, INC.



BLEHM PLASTICS

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

FOAM TOOLING & MODELING BOARD

(MACHINEABLE)

MB 1150

MB 1150 is an Avocado colored rigid closed-cell polyurethane foam tooling and modeling board. MB 1150 is low density foam of approximately 15lbs/ft³ board. Easily cut using CNC machining equipment or by hand the MB 1150 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)	15
Hardness (Shore D)	30
Tensile Strength (psi)	600
Flexural Strength (psi)	780
Service Temperature (min/max)	-300/+195
Compressive Strength	560-590
Coefficient of Thermal Expansion (in./in./EF)	33 x 10 ⁻⁶

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MODEL & TOOLING BOARD

MB 1150

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Availability

For convenience, MB 1100is 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 1150 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 1150 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 1150 Foam Board.
4. MB 1150 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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