



**BCC PRODUCTS, INC.**

**BLEHM PLASTICS**

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

## **FOAM TOOLING & MODELING BOARD**

(MACHINEABLE)

**MB 1200**

MB 1200 is an Apricot and/or Pink colored rigid closed-cell polyurethane foam tooling and modeling board. MB 1200 is low density foam of approximately 20lbs/ft<sup>3</sup> board. Easily cut using CNC machining equipment or by hand the MB 1200 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 <sup>3</sup> )	20
Hardness (Shore D)	40
Tensile Strength (psi)	895
Flexural Strength (psi)	1,330
Service Temperature (min/max)	-300/+195
Compressive Strength	1,140-1,130
Coefficient of Thermal Expansion (in./in./EF)	33 x 10 <sup>-6</sup>
Color:	Apricot and Pink available

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## MODEL & TOOLING BOARD

### MB 1200

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#### Availability

For convenience, MB 1200 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 1200 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 1200 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 1200 Foam Board.
4. MB 1200 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)

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