



**BCC PRODUCTS, INC.**

**BLEHM PLASTICS**

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

## **FOAM TOOLING & MODELING BOARD**

(MACHINEABLE)

**MB1300**

MB 1300 is a Mahogany colored rigid closed-cell polyurethane foam tooling and modeling board. MB 1300 is medium low density foam of approximately 30lbs/ft<sup>3</sup> board. Easily cut using CNC machining equipment the MB 1300 is perfectly suited for visual master models, architectural design models as well as design verification and prototype tools.

### **Outstanding Features**

- \* Excellent machinability
- \* Non abrasive material saving on cutting tools
- \* No shrinkage
- \* Excellent at high speed cutting
- \* Excellent surface finish
- \* Exceptional dimensional stability

### **Uses**

- \* Proofing intricate CNC designs
- \* Numerous tooling aids
- \* Master models (automotive/aerospace)
- \* Various prototypes
- \* Architectural models
- \* Foundry applications
- \* Bases for Die models

### **Physical Properties**

Density (lbs/ft <sup>3</sup> )	31
Hardness (Shore D)	58
Tensile Strength (psi)	1,250
Flexural Strength (psi)	2,400
Service Temperature (min/max)	-300/+195
Compressive Strength	2,200
Coefficient of Thermal Expansion (in./in./EF)	33 x 10 <sup>-6</sup>

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## MODEL & TOOLING BOARD

### MB 1300

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#### Availability

For convenience, MB 1300 is shipped pre-planed (top and bottom surfaces) for preparation in gluing assembled pieces.

Available sizes:      2" x 24" x 96"  
                                 4" x 24" 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 1300 lengthwise into as many sections needed for your model.
2. Apply BC 5003 Epoxy Laminating System or the DP-11-88 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 1300 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 1300 Model Board.
4. MB 1300 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>	<b>Feed</b>	<b>Cutters:</b>	2 or 4 flute drill bit
1500-1600 RPM	50-80 IPM		

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