



BCC PRODUCTS, INC.

BLEHM PLASTICS

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

FIXTURE BOARD

(MACHINEABLE)

MB 3500 GRAY/WHITE

BCC Products now offers a revolutionary state-of-the-art machinable fixture board for today's demanding tooling requirements. **MB 3500** is an extremely tough, high impact Urethane Plank, that can replace aluminum and other metals for many foundry applications.

Outstanding Features

- * Excellent machinability
- * Low dust emission, mostly shavings
- * No shrinkage
- * Excellent impact and wear resistance
- * Excellent surface detail reproduction
- * Excellent surface finish

Uses

- * Fixtures
- * Proofing intricate NC designs
- * Numerous tooling aids
- * Various prototypes
- * Architectural models
- * Foundry patterns and core boxes
- * Jigs

Physical Properties

Color	Gray or White
Density, ASTM D-792 (lbs/ft ³ ; gms/cm ³)	48; .77
Hardness, ASTM D-2240, Shore D	73 ± 2
Ultimate Tensile Strength (psi)	6,525
Flexural Strength, ASTM D-790, psi	11,660
Flexural Modulus, ASTM D-790, psi	337,200
Heat Distortion Temperature, ASTM D-648 °F (°C)	200 (93)
Coefficient of Thermal Expansion per TMA, ASTM D-3386 in/in/°F (-22°F to +86°F)	29.00 x 10 ⁻⁶
Glass Transition Temp., DMA, ASTM D-4065, °F (°C)	215 (101)

2140 Earlywood Drive, P.O. Box 327, Franklin, IN 46131

Ph (317) 736-4090 Fax (317) 736-4872

Web: www.bccproducts.com & www.blehmplastics.com

MB3500

Page 2

Availability

MB 3500 is offered in GRAY and WHITE color. A standard carton of MB 3500 contains one 60 inch x 16 inch x 2 inch board which yields approximately 13 1/3 board feet. For convenience, the MB 3500 Fixture Board is shipped pre-planed (top and bottom surfaces) for preparation in gluing assembled pieces.

In Stock Sizes:	2" x 16" x 60"	Special Order Sizes:	5" x 24" x 60"
	3" x 16" x 60"		6" x 24" x 60"
	4" x 16" x 60"		
	1" x 24" x 60"		
	2" x 24" x 60"		
	3" x 24" x 60"		
	4" x 24" x 60"		

Machining

(Recommendations)

Roughing Speed	Roughing Feed	Finishing Speed	Finishing Feed
1500-2000 RPM	50-70 IPM	3200-6000 RPM	100-200 IPM

Cutters:	Roughing:	1/2" Ball End Mill 4 Flute Carbide
	Finishing:	1/2" Ball End Mill 4 Flute Carbide