



BCC PRODUCTS, INC.

BLEHM PLASTICS

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

FOUNDRY PLANK

(MACHINEABLE)

MB4000 RED

BCC Products now offers a revolutionary state-of-the-art machineable foundry plank for today's demanding tooling requirements. **MB4000 Red** 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
- * Polishable to a high gloss

Uses

- * Proofing intricate NC designs
- * Numerous tooling aids
- * Various prototypes
- * Architectural models
- * Foundry patterns and core boxes
- * Short run metal stamping dies

Physical Properties

Color	Red
Density, ASTM D-792 (lbs/ft ³ ; gms/cm ³)	71; 1.14
Hardness, ASTM D-2240, Shore D	86
Ultimate Tensile Strength (psi)	10,890
Elongation, ASTM D-638, %	14.5
Flexural Strength, ASTM D-790, psi	17,350
Flexural Modulus, ASTM D-790, psi	428,300
Heat Distortion Temperature, ASTM D-648 °F (°C)	214 (101)
Coefficient of Thermal Expansion per TMA, ASTM D-3386	
in/in/°F (-22°F to +86°F)	35.60x10 ⁻⁶
in/in/°C (-30°C to +30°C)	64.08x10 ⁻⁶
Glass Transition Temp., DMA, ASTM D-4065, °F (°C)	240 (115.6)
Notched Izod Impact, ASTM D-256, ft.lb./in.	.85
Un-notched Izod Impact, ASTM D-256, ft.lb./in.	21.96

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

Foundry Plank MB4000 RED

page - 2 -

Availability

MB4000 is offered in RED color. A standard carton of MB4000 contains one 60 inch x 16 inch x 2 inch board which yields approximately 13 1/3 board feet. For convenience, the MB 4000 Foundry Plank is shipped pre-planed (top and bottom surfaces) for preparation in gluing assembled pieces.

Available Sizes:	2" x 16" x 60"	1" x 24" x 60"
	3" x 16" x 60"	2" x 24" x 60"
	4" x 16" x 60"	3" x 24" x 60"
		4" x 24" x 60"

Special Order:	5" x 24" x 60"
	6" 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 HS Steel 8% Cobalt
	Finishing:	1/2" Ball End Mill 4 Flute HS Steel 8% Cobalt