



## Freeman M-3000 Modeling Board

### Description

Freeman M-3000 is lower density modelling board that offers a fine surface and exceptional workability. It is an ideal material for master and styling models as well as general model building.

### Physical Properties

Color	Apricot
Hardness (Shore D)	55
Density (g/cc)	0.48
Density (lb./ft. <sup>3</sup> )	30
Compression Strength (psi)	1,740
Flexural Strength (psi)	2,174
Temperature Resistance (°F)	140
Coefficient Thermal Expansion (in/in°F)	18 x 10 <sup>-6</sup>

### Machining

Machining parameters listed are starting points. Cutter type, material, spindle speed, feed rates, and other factors will determine machining results.

Roughing Speed	Roughing Feed	Finishing Speed	Finishing Feed
2,000 RPM	100 IPM	15,000 RPM	200 IPM

Cutters:       **Roughing** 1" Ball End mill, 4-Flute, Carbide  
                  **Finishing** 5/8" Ball End mill, 2-Flute, Carbide

Depth:         **Roughing** Varies from 1/4" to 2-1/2" deep with 40% stepover  
                  **Finishing** 1/8" deep leaving 0.002" scallop height

The user shall determine the suitability of this product for their application and assumes all risks and liabilities associated with the use of this product. The exclusive remedy for all proven claims is replacement of our materials only and in no event shall Freeman Mfg. & Supply Co. be liable for special, incidental, or consequential claims.

READ SAFETY DATA SHEETS AND PRODUCT LABELS BEFORE USING PRODUCT