



Freeman M-3400 Modeling Board

Description

The Freeman M-3400 Modelling Board is especially well-suited to a variety of applications. Due to its outstanding machinability, it can be used for master and copy models, styling and design models, or architectural models.

Physical Properties

Color	Brown
Hardness (Shore D)	63
Density (g/cc)	0.55
Density (lb./ft. ³)	34
Compression Strength (psi)	2,900
Flexural Strength (psi)	2,900
Temperature Resistance (°F)	149
Coefficient Thermal Expansion (in/in°F)	17 x 10 ⁻⁶

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.

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