



## Freeman M-3900 Modeling Board

### Description

The Freeman M-3900 Modelling Board offers a notable balance of density and finish, resulting in a smooth surface that both machines and paints well. This material is suitable to master and copy model applications.

### Physical Properties

Color	Light Brown
Hardness (Shore D)	68
Density (g/cc)	0.62
Density (lb./ft. <sup>3</sup> )	38.7
Compression Strength (psi)	3,480
Flexural Strength (psi)	3,916
Temperature Resistance (°F)	149
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.

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