



Freeman T-4900 Modeling Board

Description

The Freeman T-4900 offers notable physical properties, including an excellent surface finish and optimal machining capabilities. This material is well suited to the creation of styling and master models as well as some laminate applications.

Physical Properties

Color	Gray
Hardness (Shore D)	72
Density (g/cc)	0.77
Density (lb./ft. ³)	48
Compression Strength (psi)	4,206
Flexural Strength (psi)	4,786
Temperature Resistance (°F)	158
Coefficient Thermal Expansion (in/in°F)	23.3 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.

READ SAFETY DATA SHEETS AND PRODUCT LABELS BEFORE USING PRODUCT