



## Freeman T-6900 Tooling Board

### Description

The Freeman T-6900 Tooling Board offers an exceptional strength profile, making it ideal for more demanding applications. Its high compressive strength and abrasion resistance make it ideal for foundry tooling, some metal forming applications, tapping models as well as master and design models.

### Physical Properties

Color	Red
Hardness (Shore D)	80
Density (g/cc)	1.1
Density (lb./ft. <sup>3</sup> )	68.6
Compression Strength (psi)	12,618
Flexural Strength (psi)	13,343
Temperature Resistance (°F)	158
Coefficient Thermal Expansion (in/in/°F)	23 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
1,600 RPM	40 IPM	10,000 RPM	100 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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