



## Freeman M-3700 Modeling Board

### Description

Freeman M-3700 is well suited for use in CNC styling models, prototypes, and master models.

### Physical Properties

Color	Brown
Hardness (Shore D)	59
Density (g/cc)	0.59
Density (lb./ft. <sup>3</sup> )	37
Compression Strength (psi)	2,538
Flexural Strength (psi)	3,263
Deflection Temp. (°F)	201
Tg, (°F)	221
Coefficient Thermal Expansion (in./in./°F)	$31 \times 10^{-6}$

### 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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