FREEMAN

Technical Data Sheet

Freeman T-7400 Tooling Board

Description

The Freeman T-7400 board offers excellent machinability and impact resistance making it ideal for foundry pattern and core boxes.

Physical Properties

Color	Red
Hardness (Shore D)	83
Density (g/cc)	1.19
Density (lb./ft.^{3})	74
Compression Strength (psi)	14,142
Flexural Strength (psi)	14,887
Deflection Temp. (°F)	172
Coefficient Thermal Expansion (in./in./°F)	45 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
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