



FREEMAN T-7600 FOUNDRY BOARD

➔ **Freeman T-7600 offers excellent strength characteristics and machinability.**

Offering superior impact and abrasion resistance, T-7600 is well-suited to the creation of durable foundry patterns and core boxes.

Additionally, its fine surface finish and exceptional machinability make it an ideal material for dimensionally accurate tooling.



Specifications

● Ideal ◐ Acceptable ○ Not recommended

	Hardness (Shore D)	Density (g/cc)	Density (lb.ft. ³)	Compressive Strength (psi)	Flexural Strength (psi)	CTE (in./in./°F)	Color	CNC Proofing	Models	Low-density Substructure	Tooling Aids & Fixtures	Foundry Patterns	Vacuum-form Molds	Intermediate-temp Master & Lay-up Tools	High-temp Master & Lay-up Tools	Metaforming tools
T-7600	80	1.2	76	11,603	13,053	36.1 x 10 ⁻⁶	Orange	○	○	○	○	●	◐	○	○	○
ASTM	D-2240	D-792	D-792	D-695	D-790	D-3386	-	-	-	-	-	-	-	-	-	-

Availability

Thickness	Width	Length	Board Feet
1.18"	19.7"	58.27"	9.4
1.97"	19.7"	58.27"	15.7
2.96"	19.7"	58.27"	23.6
3.94"	19.7"	58.27"	31.4

Machining Specifications & Parameters

	Roughing Speed (RPM)	Roughing Feed (IPM)	Finishing Speed (RPM)	Finishing Feed (IPM)
Freeman T-7600	1,600	40	10,000	100

Cutters

Roughing: 1" Ball End mill, 4-Flute, Carbide

Finishing: 5/8" Ball End mill, 2-Flute, Carbide

Depth

Roughing: Varied from 1/4" to 2 1/2" deep with 40% stepover

Finishing: 1/8" deep leaving 0.002" scallop height

These machining parameters are starting points. Cutter type, material, spindle speed, feed rate, machine power, and rigidity all affect machining results. User must determine best parameters for specific applications.

Recommended Adhesives & Repair Materials

Fre-Weld 8103 Epoxy Adhesive

Handling time: 60-90 min.

Cure time: 8 hr.

This adhesive cures at room temperature and features excellent vibration and impact resistance with high peel and shear strength.

TUF-Fil®

Handling time: 11 min.

Cure time: 15-20 min.

Freeman TUF-Fil is suitable for high-wear applications. It may be scraped, filed, tapped and sanded when fully cured.

Freeman 4105 Laminating System

Handling time: 24 hr.

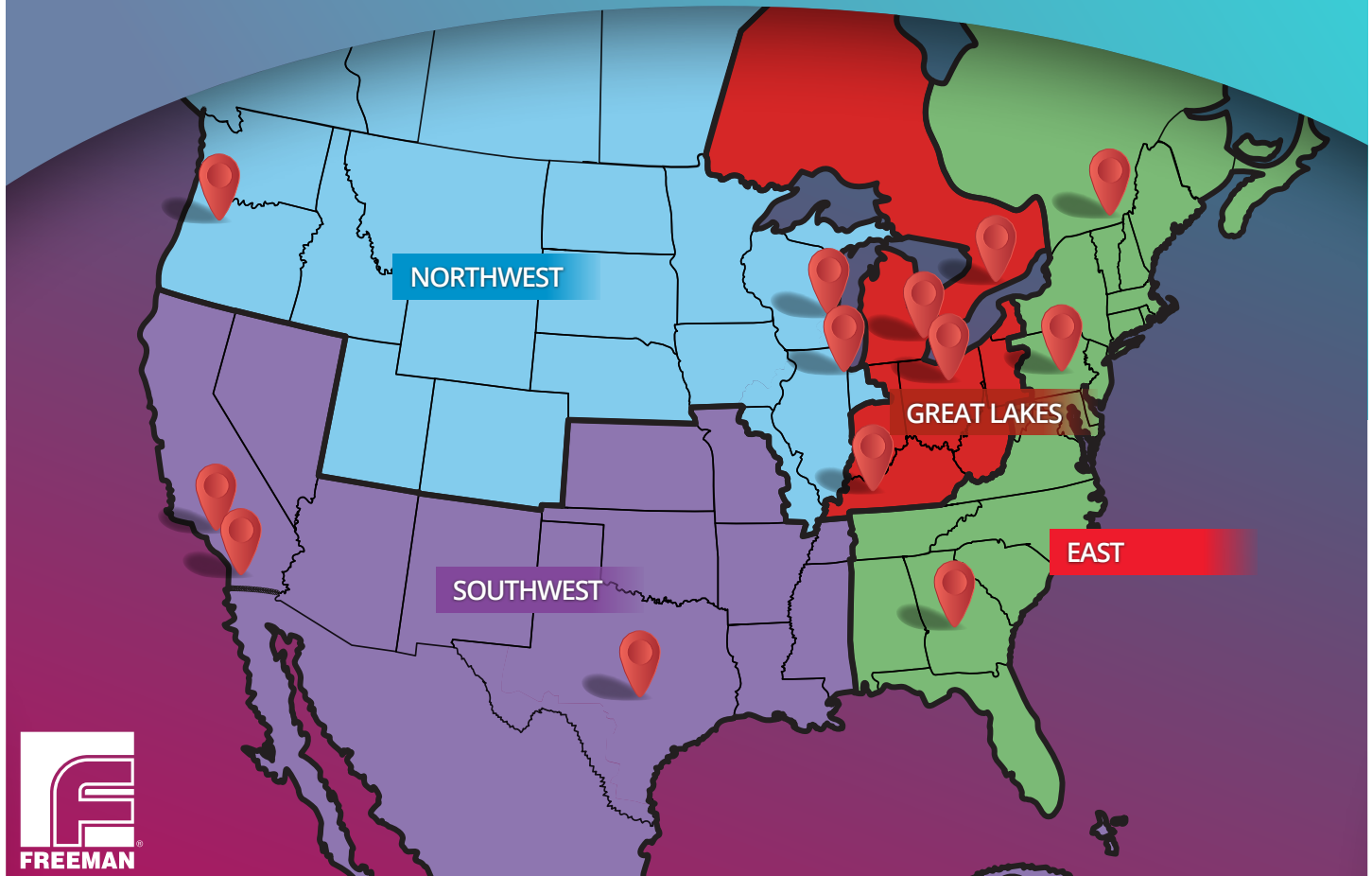
This unfilled, high-temperature laminating system can be used as an adhesive with T-7600 for intermittent prototype thermoforming applications.



Please see our website, www.FreemanSupply.com, for more details and usage instructions for these products.

FREEMAN'S REGIONS AND LOCATIONS

Freeman's strategic stocking locations remain in place while we have restructured our sales force and technical teams across North America. This will positively impact the quality, consistency, and accuracy of your Freeman experience.



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