



Freeman M-1300 Polyurethane Foam Board

Description

Freeman M-1300 is a 12.5 lb. foam ideal for situations where an easy machining, highly dimensionally stable material is required. Offering high clarity of detail, excellent readability and a good strength profile, the M-1300 is well suited to a variety of patterning applications.

Physical Properties

Color	Cream
Density (g/cc)	0.2
Density (lb./ft. ³)	12.5
Compression Strength (psi)	363
Flexural Strength (psi)	377
Maximum Usage Temperature (°F)	230
Coefficient Thermal Expansion (in/in°F)	33.3 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
2,500 RPM	200 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