



## Freeman M-1900 Polyurethane Foam Board

### Description

Freeman M-1900 is medium density foam board that offers a good surface and excellent machinability. With its high accuracy and dimensional stability, it is a good option for master and styling models as well as general pattern making.

### Physical Properties

Color	Cream
Hardness (Shore D)	25
Density (g/cc)	0.3
Density (lb./ft. <sup>3</sup> )	19
Compression Strength (psi)	653
Flexural Strength (psi)	682
Maximum Usage Temperature (°F)	230
Coefficient Thermal Expansion (in/in°F)	27.8 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
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.

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