



Freeman M-3800 Modeling Board

Description

Freeman M-3800 is a medium density modeling board that offers a fine surface and outstanding machining capabilities. Between its excellent edge definition and easy workability, the M-3800 is well suited to applications ranging from design to master models.

Physical Properties

Color	Brown
Hardness (Shore D)	55
Density (g/cc)	0.6
Density (lb./ft. ³)	37.5
Compression Strength (psi)	2,466
Flexural Strength (psi)	2,466
Flexural Modulus (psi)	130,534
Deflection Temperature (°F)	163
Coefficient of Thermal Expansion (in/in/°F)	32.7x10 ⁻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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