



## Freeman M-4350 Modeling Board

### Description

The Freeman M-4350 modeling board is an excellent choice for applications where elevated temperature resistance, but a lower density is required. With an extremely low coefficient of thermal expansion, this board is well suited to laminate and RIM tooling as well as less demanding vacuum forming applications.

### Physical Properties

Color	Violet
Hardness (Shore D)	70
Density (g/cc)	0.7
Density (lb./ft. <sup>3</sup> )	43.7
Compression Strength (psi)	4,937
Flexural Strength (psi)	4,351
Temperature Resistance (°F)	221
Coefficient Thermal Expansion (in/in°F)	19 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
2,000 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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