



Freeman M-950 Polyurethane Foam Board

Description

Freeman M-950 is a low-density, highly versatile foam board well suited to a wide range of applications. The M-950's excellent machinability, low dust production and high dimensional stability coupled with its 9 lb. density make it a good choice for applications spanning from styling models to low weight substructures.

Physical Properties

Color	Cream
Density (g/cc)	0.15
Density (lb./ft. ³)	9
Compression Strength (psi)	247
Flexural Strength (psi)	217
Maximum Operating 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.

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