FREEMAN

Technical Data Sheet

Freeman T-5000 Fixture Board

Description

Freeman T-5000 is a medium-high density fixture board that offers many desirable characteristics. Between its fine surface structure, easy machinability, and excellent thermal capabilities, the T-5000 is a good choice for applications ranging from design models to laminate and low-volume thermoforming tools.

Physical Properties

Color	Grey
Hardness (Shore D)	65
Density (g/cc)	0.8
Density (lb./ft.^{3})	49.9
Compression Strength (psi)	4,496
Flexural Strength (psi)	4,496
Flexural Modulus (psi)	188,549
Deflection Temperature (°F)	192
Coefficient of Thermal Expansion (in/in/°F)	38.3x10^{-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.

READ SAFETY DATA SHEETS AND PRODUCT LABELS BEFORE USING PRODUCT