



Technical Data Sheet

Freeman T-5050 Epoxy Tooling Board

Description

The Freeman T-5050 Epoxy Tooling Board offers excellent surface finish along with higher temperature resistance of 266°F. This modeling board is ideal for applications requiring elevated temperatures such as laminate tooling, low cure prepreg, RTM molding.

Physical Properties

Color	Blue
Hardness (Shore D)	75
Density (g/cc)	0.85
Density (lb./ft. ³)	53
Compression Strength (psi)	8,267
Flexural Strength (psi)	4,786
Temperature Resistance (°F)	266
Coefficient Thermal Expansion (in/in°F)	16.1 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
1,600 RPM	40 IPM	10,000 RPM	100 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