



# Technical Data Sheet

## Freeman T-6250 Tooling Board

### Description

The Freeman T-6250 is a durable tooling board offering excellent machine surface and higher temperature resistance. This board would be ideal for intermediate temperature applications, such as laminate tooling, RIM molding, and vacuum forming. The Freeman T-6250 can withstand temperatures up to 266°F.

### Physical Properties

Color	Violet
Hardness (Shore D)	80
Density (g/cc)	1
Density (lb./ft. <sup>3</sup> )	62.4
Compression Strength (psi)	7,541
Flexural Strength (psi)	8,267
Temperature Resistance (°F)	266
Coefficient Thermal Expansion (in./in./°F)	21.1 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
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.

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