



## Freeman T-7400 Tooling Board

### Description

The Freeman T-7400 board offers excellent machinability and impact resistance making it ideal for foundry pattern and core boxes.

### Physical Properties

Color	Red
Hardness (Shore D)	83
Density (g/cc)	1.19
Density (lb./ft. <sup>3</sup> )	74
Compression Strength (psi)	14,142
Flexural Strength (psi)	14,887
Deflection Temp. (°F)	172
Coefficient Thermal Expansion (in./in./°F)	$45 \times 10^{-6}$

### 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.