FREEMAN

Technical Data Sheet

Freeman T-7600 Foundry Board

Description

Freeman T-7600 is a high-density polyurethane foundry board that offers exceptional durability and machining capabilities. The T-7600 exhibits superior impact and abrasion resistance, making it well suited to demanding foundry applications. Additionally, its fine surface finish and excellent machinability make the T-7600 an ideal choice for the creation of precise, dimensionally accurate tooling.

Physical Properties

Color	Orange
Hardness (Shore D)	80
Density (g/cc)	1.2
Density (lb./ft.^{3})	76
Compression Strength (psi)	11,603
Flexural Strength (psi)	13,053
Maximum Usage Temperature (°F)	176
Coefficient Thermal Expansion (in/in°F)	36.1 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