



Freeman T-7800 Tooling Board

Description

Freeman T-7800 is a high-density polyurethane tooling board that offers optimal durability. With its ability for high dimensional accuracy, outstanding impact resistance, and notable thermal capabilities, the T-7800 is an ideal choice for applications ranging from foundry patterns to jigs and fixtures.

Physical Properties

Color	Red or Green
Hardness (Shore D)	82
Density (g/cc)	1.25
Density (lb./ft. ³)	78
Compressive Strength (psi)	14,504
Flexural Strength (psi)	11,603
Flexural Modulus (psi)	507,633
Deflection Temperature (°F)	210
Coefficient of Thermal Expansion (in/in/°F)	25 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.

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