



Freeman T-9950 Metal Forming Board

Description

Freeman T-9950 is a high-density polyurethane board that pairs high durability with excellent machinability. Capable of withstanding extended usage and handling along with scenarios requiring exposure to moderately high heat, the T-9950 is well suited to the meet needs of applications ranging from vacuum forming to slow compression metal forming.

Physical Properties

Color	Grey
Hardness (Shore D)	88
Density (g/cc)	1.7
Density (lb./ft. ³)	106
Compression Strength (psi)	15,954
Flexural Strength (psi)	9,428
Flexural Modulus (psi)	1,073,281
Deflection Temperature (°F)	185
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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