



REN SHAPE 5179

Polyurethane Foundry & Tooling Board

Description

Ren shape 5179 is a red colored polyurethane board that is specifically designed for the machining of highly accurate, dimensionally stable, and wear resistant foundry patterns. This board machines well with minimal chipping.

Physical Properties

PROPERTIES	ASTM method	Cured Value
Color	Visual	Red
Hardness (Shore D)	D- 2240	85
Density	D-792	1.17 g/cm ³
Heat deflection temperature	D-648	93°C
Glass transition temperature	DMA	115°C
Coefficient of thermal Expansion	TMA	3.54 x 10 ⁻⁵
Izod Impact, Notched(unnotched), ft-lbs/in	D-256	1.41 (13.26)
Tensile strength	D-638	10,000 psi
Tensile modulus	D-638	392,000 psi
Flexural strength	D-790	15,600 psi
Flexural modulus	D-790	409,000 psi
Compressive Strength	D-695	12,700 psi
Compressive Modulus	D-695	325,000 psi

Obs. These physical properties are reported as typical test values obtained by our test laboratory. If assistance is needed in establishing specifications, please consult our technical department.
Dimensions: 2 pol x 24 pol x 60 pol

Machining

The following speed and feed conditions are recommended as starting points. Adjust speed and feed to your specific conditions.

Roughing speed	Roughing Feed	Finishing Speed	Finishing Feed
1,500 rpm	60 IPM	10,000 rpm	100 IPM

Obs. IPM(inches per minute)

Cutters:

Roughing = 1 " Ball End Mill , 2-flute , High speed metal(min. of 8% cobalt suggested)
Finishing = 5/8" Ball End Mill , 4-flute, Carbide

Depth:

Roughing = 1/4 " to 2 " deep with a 40% step over
Finishing = 1/8" deep leaving 0.002" scallop.

**This is the actual stage of our developments with this product.
The main responsibility for the success, is over the users.**

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