

## APPLICATIONS

*Abrasion resistant machining slab designed for foundry patterns, core boxes and any other tools realised in CNC.*

## PROPERTIES

- Outstanding impact resistance
- Easy machining
- Good abrasion resistance
- Very good surface aspect after machining

PHYSICAL PROPERTIES		
Colour	-	green
Density at 23 °C	ISO 2781 :1996	1.30

MECHANICAL AND THERMAL PROPERTIES AT 23 °C			
Hardness	ISO 868 : 2003	Shore D1	85
Abrasion loss	ISO 5470-1 :1999	mm <sup>3</sup>	160
Compressive strength at yield	ISO 604 : 2002	Mpa	68
Flexural strength	ISO 178 : 2001	Mpa	75
Flexural modulus	ISO 178 : 2001	MPa	1,900
Tensile strength	ISO 527: 1993	MPa	46
Elongation at break	ISO 527 : 1993	%	8.5
Impact resistance ( <i>unnotched specimens</i> )	ISO 179/1D : 1994	kJ/m <sup>2</sup>	30
Temperature of glass transition	IOS 11359 : 2002	°C	90
Coefficient of thermal expansion (CTE) (+10 to +80 °C)	ISO 11359 : 1999	10 <sup>-6</sup> .K <sup>-1</sup>	85

## ASSEMBLY

*Axson LAB 920 GN tooling board can be bonded with the H 9951 (long pot life – epoxy adhesive), consumption about 400 g/m<sup>2</sup>.*

<b>MACHINING PARAMETERS (1)</b>		
	Cut speed (Cs in m/min)	Speed per rotation for 1 tooth (mm/tr)
Rough shape	100 to 400	0.30
Finish	400	0.06

**NOTA:** To obtain good results use tools with an angle of cutting and angle of taper higher than zero.

## SAFETY PRECAUTIONS

Normal health and safety precautions should be observed when handling this product :

- ensure good ventilation
- wear gloves and safety glasses
- do not smoke when machining.

For further information, please consult the product safety data sheet.

## STORAGE

The slabs must be stored in a dry place provided.

## DIMENSIONS

- 1000 x 500 x 100 mm
  - 1000 x 500 x 75 mm
  - 1000 x 500 x 50 mm
- Other larger dimensions possible in Mass Casting MC 1151 (please contact us).

## GUARANTEE

The information of our technical data sheet are based on our present knowledge and the result of tests conducted under precise conditions. It is the responsibility of the user to determine the suitability of AXSON products, under their own conditions before commencing with the proposed application. AXSON refuse any guarantee about the compatibility of a product with any particular application. AXSON disclaim all responsibility for damage from any incident which results from the use of these products. The guarantee conditions are regulated by our general sale conditions.