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BLEHM QUALITY - DEPENDABILITY PLASTICS

MB2001

Model and Tooling Board MB 2001 is a dense, highly machineable, dimensionally stable tooling plank for today's CNC machining applications. As an advancement over similar products on the market, MB 2001 yields low dust emission during machining, less abrasiveness to CNC cutters, and affords the user a highly defined surface finish.

* Excellent machinability
* Low dust emission
* No shrinkage
* Low moisture absorption
* No grain
* Excellent surface detail reproduction
* Proofing intricate CNC designs
* Numerous tooling aids
* Master models (automotive/aerospace)
* Various prototypes
* Architectural models
* Foundry applications
* Bases for Die models

We even make the fect repair material. The only one on the market for MB2001

Density (lbs/ft3; gms/cm3)	46.5; 0.74
Hardness (Shore D)	68
Tensile Strength (psi)	3,800
Flexural Strength (psi)	5,150
Flexural Modulus (psi)	154,200
Glass Transition Temp (Tg) MDA,°F	208
Heat Distortion Temperature (°F)	172
Coefficient of Thermal Expansion (in./in./°F)	4.68×10^{5}
Repair material	BC4578
Adhesive	DP-11-88

BP Industrial

Order-Line: 800-355-8444 • Direct: 419-843-6058 • www.bp-ind.com

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additional Specifications information

Sizing

For convenience, MB 2001 is shipped pre-planed (top and bottom surfaces) for preparation in gluing assembled pieces.

Available sizes:

2” x 16” x 60”	1” x 24” x 60”
3” x 16” x 60”	2” x 24” x 60”
4” x 16” x 60”	3” x 24” x 60”
	4” x 24” x 60”
	6” x 24’ x 60”

Construction Hints

1. In order to achieve the required thickness for models and patterns with heights greater than two inches it is necessary to cut (saw) MB 2001 lengthwise into as many sections needed for your model.
2. Apply BC 5003 Epoxy Laminating System to each surface to be mated. Clamp with minimal pressure and allow to cure overnight at room temperature. Excess clamping pressure can cause surface defects and stress upon the completed model.
3. The glued MB 2001 assembly can now be bonded to a chosen base plate using BC 5003 Laminating System and fiberglass cloth. Suggested base plate materials are: Impreg Wood, metal tubing, fabricated honeycomb panel or MB 2001 Model Board.
4. MB 2001 is now ready to be carved or machined. Standard woodworking tools and/or high speed steel cutters are recommended for contouring to required size.
5. Finish with pattern coating or sanding lacquer sealer.

Machining/CNC Milling (Recommendations):

Roughing Speed	***Feed***	***Cutters:***
1500-2,000 RPM	80-100 IPM	2 or 4 flute carbide bit
Finishing Speed	***Feed***	***Cutters:***
10,000-12,000 RPM	150-200 IPM	4 flute carbide bit