



# R1/P1 Easy Green

## R1/P1 Easy Green Datasheet

2036 Nevada City Hwy  
Box 573  
Grass Valley, CA 95945  
Ph: (530) 272-1133  
Fax: (530) 272-1070  
Email:  
[sales@goldenwestmfg.com](mailto:sales@goldenwestmfg.com)  
Web: [goldenwestmfg.com](http://goldenwestmfg.com)

### DESCRIPTION & APPLICATION:

R1/P1 is a rigid very smooth and non-abrasive, High Density Urethane, (HDU), Tooling/Modeling board designed for Prototype CNC Machining, Pattern Making, Thermoforming, Prepreg Composite Layup Tooling Vacuum Form Tooling, Tool Path Proofing, Lost Wax Casting Masters, Master Model Making, Artistic Carving Blocks. R1/P1 is made in the USA. This product is not recommended for painting. R1/P1 cell structure has small pinholes. This product is an excellent alternative to machinable wax as it is physically stronger and is less likely to break, especially on thin wall areas down to 1/16" thick.

R1/P1 does not contain **CFCs** or **VOCs**. See the MSDS on our website.

R1/P1 can be machined with HSS bits or cut with any standard cutting tool. R1/P1 density is 65 lbs. per cubic foot. Stock block sizes are 12" x 12", 12" x 24", 24" x 24" & 24" x 48" in thicknesses from 1.65" to 6". Minimum thickness is 1.65" and the maximum thickness is unlimited.

Custom shapes (disks, cones, rectangles, triangles, donuts, cubes, mandrels, or to your specifications) and sizes are typically available to ship within one week, most larger sizes will require a slightly longer lead time. A liquid Premix system is also available.

A liquid patch repair kit of the same resin and filler is available to change or repair this material making sanding the bond line a snap.

### PHYSICAL PROPERTIES:

Density	ASTM D-1623	65 lbs. per cubic foot
Compressive Strength	ASTM D-1621	3050 psi
Compressive Modulus	ASTM D-1621	128,000 psi
Tensile Strength	ASTM D-1623	1130 psi
Tensile Modulus	ASTM D-1623	128,000 psi
Shear Strength	ASTM C-273	3010 psi
Shear Modulus	ASTM C-273	84,039 psi
Flexural Strength Method 1 A	ASTM D-790	3410 psi
Flexural Modulus Method 1 A	ASTM D-7900	99,500 psi
Hardness / Shore D	ASTM D-2240	65
Elongation		2.7 %
Dimensional Stability	ASTM D-2126	0.53 % Max
Water Absorption	ASTM D-2842	0.01 % by volume after 96 hrs.
Closed Cell Content	ASTM D-2856	96%
"K" Value Insulation Factor	ASTM C-177	1.4%
Impact Resistance	0°F 4.6 OZ. 1" Dia. 9"6" drop	No cracking observed
Freeze Thaw	ASTM D-2126, 25 cycles	No de-bonding or distortion occurred
Mold and Mildew Resistance	ASTM D-3273	Does not support growth
Dielectric Constant	ASTM D-1678	1.3
Maximum Service Temperature	Dry	255° F
Coefficient of Thermal Expansion (CTE)		72 x 10 <sup>-6</sup> ° F
Specific Heat @ 77° F	ASTM E-1269	1.08
Glass Transition	DMA/TMA	277° F
Flammability Tests:	FAR 25.853 Vertical Burn	Pass
	MIL P 26514 Burn Test	Pass
	ASTM D-1692-74 Burn Test	Pass
	ASTM D-635-06 Burn Test	Pass

Follow heat temperature ramping of 1° F up per minute and 2° F down per minute. This plastic is non-abrasive. Use carbide cutters or cobalt helix cutters (1600-1100 RPM @ 30 I.P.M.).

**Questions? Please contact Goldenwest Manufacturing, Inc.**

**(530) 272-1133** or email [sales@goldenwestmfg.com](mailto:sales@goldenwestmfg.com)  
[www.goldenwestmfg.com](http://www.goldenwestmfg.com)

**WARRANTY:** All recommendations for product use have been derived from experience and test data believed to be reliable. We warrant and guarantee the uniformity of our products within manufacturing tolerance. However, since the use of our products is beyond our direct control, they are furnished upon the condition that each party shall make his/her own tests to determine their suitability for his/her particular purpose. Except as stated herein, Goldenwest Manufacturing Inc. makes no warranty or guarantee, expressed or implied, and disclaims all responsibility for results obtained, nor assumes any liability for any damages, whether arising out of negligence or breach of guarantee and is hereby expressly limited to replacement of product only. For additional information on product handling, please refer to R1/P1 MSDS on our website.