



# NECURON® 620

## BOARD MATERIAL - TECHNICAL DATA SHEET

US  
1/2

### CHARACTERISTICS

- very fine structure
- smooth and paintable surface
- excellent processing properties

### APPLICATIONS

- master and copy models
- cubing and data models



### TECHNICAL DATA

Color	light brown
Coefficient of thermal expansion	approx. $33.88 \times 10^{-6} \text{ F}^{-1}$
Temperature resistance	approx. 140 °F
Shore D	approx. 57
Compressive strength	approx. 3,480 psi
Flexural strength	approx. 3,916 psi
Density	approx. 38.70 lbs/ft <sup>3</sup>
Abrasion resistance (at defined parameters)	approx. - in <sup>3</sup>
Fire protection classification	-
Electrical current resistance	approx. - $\Omega \times \text{in}$
Notched impact strength	approx. - ft.lb./in <sup>2</sup>
Thermal conductivity	approx. - BTU-in/hr-ft <sup>2</sup> -°F

- Contains no halogens, plasticizer or solvent
- Manufactured fluorocarbohydrate-free
- Physiologically harmless

### DIMENSIONS

59.1	19.7	1.97	inch
59.1	19.7	2.95	inch
59.1	19.7	3.94	inch
59.1	19.7	5.91	inch

Surfaces machined parallel.  
Other dimensions on request.

### STORAGE/TRANSPORT

NECURON®-boards should be stored on a flat underground and in a dry space at a temperature between 64.4°F and 77°F. Variations in temperature should be avoided during the transport and storage.



**NECURON® 620**  
BOARD MATERIAL - TECHNICAL DATA SHEET

US  
2/2

**PROCESSING**

Adhesive	Color	Mixture ratio A to B (by weight)	Pot life in minutes at 68°F	Curing time at 68°F
NECURON® K6	brown	1:1	2-3	15 - 30 min
NECURON® K8N	amber	100:50	10	5 hrs

or usual and compatible patternmaking adhesives/resins  
We recommend that boards are plane-parallel to ensure good glue joints.

**MACHINING**

Machining temperature: 68°F - 77°F  
Tools: Metal-cutting tools

**MILLING PARAMETERS**

	ROUGHING	FINISHING
Type of tool	Finishing tools d = 3.15 in	Finishing tools d = 3.15 in
Tool diameter [d] (in)	3.15	3.15
Cutting speed [Vc] (ft./sec)	164	164
Speed [n] (1/min)	12000	8000
Feed speed (ft./min)	32.81	24.61
Tooth speed [fz] (in)	0.0083	0.0083
Number of teeth [z]	4	4
Cutting depth [ae] (in)	0.276	0.012
Cutter mark length [fzeff] (in)	1.50	0.39-0.79

**NECURON® 620**

- This material does not contain any fillers that release harmful dust during machining. Nevertheless the dust content in the air should not rise above 0.2 lb/in<sup>3</sup>. Safety procedures recommended by the vocational co-operative of the chemical industry should be complied with.
- The article is not a regulatory product according to ICC regulations. In accordance with general local and national regulations waste is to be disposed by incineration in authorized places or conveyed to authorized tips (EAK 120105).
- Technical statements and recommendations refer to current standard of technique and are based on our own experience. Further developments and improvements are reserved. Due to the variety of processing possibilities own experiments are recommended to optimise results.
- This data sheet is not legally binding. Actual specifications and / or features may vary.