



# NECURON® 702

## BOARD MATERIAL - TECHNICAL DATA SHEET

US  
1/2

### CHARACTERISTICS

- epoxy board
- very high temperature resistance
- very low coefficient of thermal expansion

### APPLICATIONS

- prepreg lay up tools
- vac form tools
- laminating patterns and tools



### TECHNICAL DATA

|   |   |
|---|---|
| Color                                       | green   |
| Coefficient of thermal expansion            | approx. $23.33 \times 10^{-6} \text{ F}^{-1}$ |
| Temperature resistance                      | approx. 287°F                                 |
| Shore D                                     | approx. 74                                    |
| Compressive strength                        | approx. 8,267 psi                             |
| Flexural strength                           | approx. 5,076 psi                             |
| Density                                     | approx. 49.31 g/cm <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

|    |    |   |      |
|----|----|---|------|
| 60 | 24 | 2 | inch |
| 60 | 24 | 3 | inch |
| 60 | 24 | 4 | 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.



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### PROCESSING

| Adhesive     | Color         | Mixture ratio<br>A to B (by weight) | Pot life in minutes<br>at 68°F | Curing time at<br>68°F in hours |
|--------------|---------------|-------------------------------------|--------------------------------|---------------------------------|
| NECURON® K8T | colorless     | 1:0.2                               | 30                             | 18                              |
| NECURON® K7L | straw-colored | 100:25                              | 40-60                          | 12-16                           |
| NECURON® K7S | straw-colored | 100:25                              | 20-30                          | 4-5                             |

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

| Type of tool                    | ROUGHING                    | FINISHING                   |
|---------------------------------|-----------------------------|-----------------------------|
|                                 | 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)         | 0.236                       | 0.020                       |
| Cutter mark length [fzeff] (in) | 1.50                        | 0.20-0.39                   |

### NECURON® 702

- 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.