



# LAB 975 New

## HEAT RESISTANT EPOXY TOOLING BOARD WITH HIGH DIMENSIONAL STABILITY

**LAB 975 New is the first choice for the construction of prepreg tools, master models and vacuum forming moulds for temperatures up to 130 °C.**

- Density 0.70 kg/ltr.
- High temperature resistance up to 130 °C
- Very low coefficient of thermal expansion  $\alpha_T$  32-42 x 10<sup>-6</sup>
- High compressive strength
- Easy workability
- Excellent surface quality

# LAB 975 New

## AREAS OF APPLICATION

- Manufacturing of heat resistant master models for the construction of prepreg tools for the autoclave up to 130 °C
- Manufacturing of master models, vacuum forming moulds and laminating moulds

## PRODUCT BENEFITS

- High dimensional stability
- Easy workability
- Very good surface after finishing
- Medium density
- High temperature resistance
- Good price-performance-ratio

## DESCRIPTION

- **Basis:** Epoxy, green
- **Adhesive:** H 8973/H 8973
- **Filler:** H 8973/H 8973 + Filler RZ55
- **Dimensions in mm:** 1500 x 500 x Thickness 50/75/100/150/200

### PHYSICAL DATAS (APPROX. VALUES)

Density	ISO 2781	kg/ltr.	0,70
Shore hardness, 23 °C	ISO 868	-	D 75
Flexural strength	ISO 178	MPa	30
E-Modulus	ISO 178	MPa	2,300
Compressive strength	ISO 604	MPa	50
Heat distortion temperature	ISO 11359	°C	130
Coefficient of thermal expansion (CTE), $\alpha_T$	DIN 53 752	K <sup>-1</sup>	32-42 x 10 <sup>-6</sup>

### MILLING PARAMETERS

Milling steps	1.	2.	3.	4.	5.	6.	7.
Strategy	Roughing Z - constant	Rest material Z - constant	Rest material Z - constant	Rest material Z - constant	Finishing flat areas	Finishing Z - constant	Finishing rest material shapes
Milling tool	Torus cutter	Torus copying cutter	Ball nose copying cutter	Ball nose copying cutter	Torus copying cutter	Ball nose copying cutter	End mill cutter
Diameter [mm]	42	20	12	6	8	8	4
Number of teeth	3	2	2	2	2	2	2
Radius [mm]	3	4	6	3	1	4	2
Cutting speed (Vc) [m/min]	540	500	600	300	400	400	200
Revolutions [1/min]	4,100	7,957	16,000	16,000	16,000	16,000	16,000
Feedrate per tooth [mm]	0.6	0.5	0.2	0.18	0.13	0.13	0.13
Feed rate (Vf) [mm/min]	7,380	7,957	6,366	5,760	4,160	4,160	4,160
Cutting depth (ap) [mm]	3	2	1	0.3	0.3	0.15	0.1
Cutting width/Line spacing (ae) [mm]	30	10	2	0.5	4	0.3	0.1

Changes that serve technical progress, as well as errors and misprints reserved. 06/2021

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Please consult the Product Data Sheet prior to any use and processing.

Actual Product Data Sheets and information about additional products please find in:

[www.sikaadvancedresins.com](http://www.sikaadvancedresins.com)



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