

Model Board M450, M600 & M945

Material for the CNC process

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Technical Data Sheet

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Model Board M450	Physical Data & Description (approx. values)			
<ul style="list-style-type: none"> • Manufacture of design and styling models • Manufacture of substructure for cubing and DCM • Very high dimensional stability and low density • Fine structure and homogeneous surface • Resistant surface with good edge stability • Easily workable • Good formation of shavings by milling • Dense and smooth surface • Easy to seal and good to varnish 	Colour	Orange		
	Density	ISO 845	g/cm ³	0.45
	Shore hardness	ISO 868	-	D 50
	Flexural Strength	ISO 178	MPa	12
	E-modulus	ISO 604	MPa	430
	Compressive strength	ISO 178	MPa	10*
	Heat distortion temperature	ISO 75 B	°C	78
	Linear thermal expansion coefficient α_L	DIN 53 752	K ⁻¹	55 x 10 ⁻⁶

* at 10% compressive strain

Model Board M600	Physical Data & Description (approx. values)			
<ul style="list-style-type: none"> • Data control models and cubings • Master models in tool and mould construction • Dense fine surface • Easy to seal and good to varnish • Low dust formation when milled • Easy machinability • Very high dimensional stability • Good compressive strength and edge stability • Good heat distortion temperature 	Colour	Light Brown		
	Density	ISO 845	g/cm ³	0.60
	Shore hardness	ISO 868	-	D 58
	Flexural Strength	ISO 178	MPa	18-20
	E-modulus	ISO 604	MPa	750
	Compressive strength	ISO 178	MPa	16-18
	Impact resistance	ISO 179 Ue	kJ/m ²	8
	Heat distortion temperature	ISO 75 B	°C	75-80
	Linear thermal expansion coefficient α_L	DIN 53 752	K ⁻¹	55 x 10 ⁻⁶

Model Board M945	Physical Data & Description (approx. values)			
<ul style="list-style-type: none"> • Manufacture of various moulds and tools • Manufacture of master models and mouldings for high quality demands • Excellent milling properties • High abrasion resistance • Very high compressive and flexural strength as well as edge stability • Dense surface with good slipping properties 	Colour	Green		
	Density	ISO 845	g/cm ³	1.3
	Shore hardness	ISO 868	-	D 83
	Flexural Strength	ISO 178	MPa	100
	E-modulus	ISO 178	MPa	3,400
	Compressive strength	ISO 604	MPa	95
	Impact resistance	ISO 179 Ue	kJ/m ²	25
	Heat distortion temperature	ISO 75 B	°C	80
	Linear thermal expansion coefficient α_L	DIN 53 752	K ⁻¹	65-70 x 10 ⁻⁶