NECURITE® 630

Data Sheet

Characteristics:

- Made of recycled polyurethane
- large volume board material based on PU
- good edge stability
- good scratch-resistance
- dimensionally stable
- paintable
- compatible with silicone

Applications:

- master and copy models
- cubing and data models
- styling and design models
- wind tunnel and water channel models
- architectural models
- general modelling

Technical data:

Colour	beige
Coefficient of thermal expansion:	variable
Temperature resistance:	approx. 48 °C
Shore D	approx. 71
Compressive strength:	approx. 8 - 10 N/mm²
Flexural strength:	approx. 6 - 8 N/mm²
Density:	approx. 0,625 g/cm³ (+/-0,025)
Abrasion resistance (at defined parameters)	approx. 3680mm^3 (2,3 g/5 min.)
Fire protection classification	B2
Thermal conductivity	approx. 0,060 – 0,080 W/mk

- manufactured fluorocarbohydrate-free
- physiolgically harmless

Measurements:

1500	500	50	mm
2000	1000	50	mm

Surface machined parallel, other dimensions on request

Storage/Transport:

NECURITE®-boards should be stored on a flat underground and in a dry space at a temperature between 18℃ and 25℃.
Variations in temperature should be avoided during the transport and storage.

© **NECUMER-PRODUCT GmbH** – Bruchheide 16 - D-49163 Bohmte Tel +49 (0) 5471/95020 - Fax +49 (0) 5471/950299
E-Mail: info@necumer.de - Internet www.necumer.de Version: 04 March 2010

Processing:

Adhesive / Putty	Colour	Mixture ratio A to B (by weight)	Pot life In minutes at 20℃	Curing time at 20℃ in hours
NECURON® K6	brown	1:1	2-3	0,5
NECURON® K8	colourless transparent	1:1	10	4-6
NECURON® S6	brown	1:1	10-12	6-8

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

Machining:

Machining temperature: 20℃ - 25℃
Tools: metal-cutting tools

Milling parameters:

	Roughing	Finishing
Type of tool	Finishing tools d=80mm	Finishing tools d=80mm
Tool diameter [d] (mm)	80	80
Cutting speed.[Vc] (m/sek)	50	50
Speed [n] (1/min)	12000	8000
Feed speed (m/min)	10	7,5
Tooth speed [fz] (mm)	0,21	0,21
Number of teeth [z]	4	4
Cutting depth [a_e] (mm)	4	0,5
Cutter mark lenght [f_{zeff}] (mm)	38	5

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This material does not contain any fillers that release harmful dust during machining. Nevertheless the dust content in the air should not rise above 6 mg/m³. 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 authorised places or conveyed to authorised 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.