



# TOOLING BOARD SELECTOR CHART

## EPOXY TOOLING BOARDS

Product	BE368	BE978	BE769	BE650	BE265
Colour	Violet	Blue	Green	Green	Grey
Density (Kg/m <sup>3</sup> )	710	680	720	675	780
Applications	Master Models Automotive Die Models Vacuum Forming at medium Temperatures Lay-Up Tools for Low Medium Temperature Curing Prepreg Light weight coring materials	Master Models Automotive Die Models Vacuum Forming at medium Temperatures Lay-Up Tools for Low Medium Temperature Curing Prepreg Light weight coring materials	Master Models Automotive Die Models Vacuum Forming at High Temperatures Lay-Up Tools for medium to high temperature curing prepreg Direct Tooling Coring materials	Master Models Automotive Die Models Vacuum Forming at medium Temperatures Lay-Up Tools for Low Medium Temperature Curing Prepreg Light weight coring materials	Master Models Automotive Die Models Vacuum Forming at high Temperatures Lay-Up Tools for High Temperature Curing Prepreg Direct Tooling
Key Properties	Good surface finish Low CTE Intermediate TG Easily machined Excellent dimensional stability	Excellent surface finish Low CTE, Intermediate TG Easily machined Excellent dimensional stability	Excellent surface finish Low CTE & high TG Good dimensional stability High compressive strength Suitable for use up to 175°C	Very fine surface finish Low CTE Intermediate TG Easily machined Excellent dimensional stability	Excellent surface finish Low CTE & high TG Good dimensional stability High compressive strength Suitable for use up to 185°C
Hardness (Shore D)	73	70	70	71	79
Coefficient of Thermal Expansion (10 <sup>-6</sup> K <sup>-1</sup> )	39	39	39	35	40
Deflection Temperature (Tg) °C	120	145	175	147	190
Compressive Strength (MPa)	61	50	50	57	53
Flexural Strength (MPa)	36	38	38	35	32
Dimensions (mm) Length x Width	1524 x 608	1524 x 608	1524 x 608	1524 x 608	1524 x 608
Thickness (mm)	50 75 100 150	30 50 75 100 125 150 200	30 50 75 100	50 125	30 50 75 100



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## Medium Density Polyurethane

Product	BP700	BP750	BP850
Colour	Brown	Aquamarine	Grey
Density (Kg/m <sup>3</sup> )	700	750	850
Applications	Master models Cubing models Working models Vacuum forming tools Architectural models	Foundry patterns Master models Laminating tools Design models Cubing models	Foundry patterns Jigs and fixtures Master templates Laminating tools Thermoforming tools
Key Properties	Very fine surface structure Low CTE Good temperature resistance Easily machined Good dimensional stability	Very fine surface structure Low CTE Good dimensional stability High mechanical strength Good dimensional stability Good temperature resistance	Excellent surface structure Low CTE & high TG Good dimensional stability High mechanical strength Excellent dimensional stability
Hardness (Shore D)	70	72	70
Coefficient of Thermal Expansion (10 <sup>-6</sup> k <sup>-1</sup> )	45	40	47
Deflection Temperature (Tg) °C	70	93	94
Compressive Strength (MPa)	35	48	46
Flexural Strength (MPa)	25	45	49
Dimensions (mm) Length x Width	1524 x 608	1524 x 608	1524 x 608
Thickness (mm)	30 50 75 100 150 200	30 50 75 100	30 50 75 100



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## High Density Polyurethane

Product	BP1100	BP1250	BP1400	BP1404
Colour	Ivory	Emerald Green	Cobalt Blue	Green
Density (Kg/m <sup>3</sup> )	1100	1250	1400	1400
Applications	Foundry patterns Master models Vacuum forming moulds Core boxes Tooling jigs Fixtures	Foundry patterns Hammer forms Core boxes Pattern plates Vacuum forming moulds Metal forming Jigs & fixtures	Patterns, jigs & fixtures Vacuum forming moulds Metal forming	Foundry patterns Hammer forms Core boxes Pattern plates Vacuum forming moulds Metal forming Jigs & fixtures
Key Properties	Excellent surface finish Low CTE & high TG Good dimensional stability High compressive strength Easily machined	Excellent surface structure Polishable Low CTE & high TG Good dimensional stability High abrasion resistance High mechanical properties High impact strength	Excellent surface finish Low CTE & high TG Good dimensional stability High compressive strength Easily machined	Excellent surface structure Polishable Low CTE & high TG Good dimensional stability High abrasion resistance High mechanical properties High impact strength
Hardness (Shore D)	84	85	85	85
Coefficient of Thermal Expansion (10 <sup>-6</sup> K <sup>-1</sup> )	45	80	42	80
Deflection Temperature (Tg) °C	85	85	92	80
Compressive Strength (MPa)	55	75	100	80
Flexural Strength (MPa)	50	87	100	77
Dimensions (mm) Length x Width	1524 x 608 1000 x 500	1516 x 608 1000 x 500	1000 x 500	1516 x 608 1000 x 500
Thickness (mm)	30 50 75 100	30 50 75 100	30 50 100	30 50 75 100