

# KIWI TOOLING

Suppliers of high performance tooling board

## KT/978 EPOXY TOOLING BOARD

Our premium high performance epoxy tooling board known for its superior surface finish. It is the preferred solution in advanced CNC manufacturing applications. KT/978 is ideally suited to environments where dimensional stability is critical. Its excellent dimensional stability results from its low coefficient of thermal expansion and high glass transition temperature. It is recommended for use up to 145°C. Outperforms other boards available on the NZ market for stability at high temperatures and surface finish.

### Applications

- Master models for epoxy prepregs especially carbon fibre.
- Automotive and Marine dies, used by the Formula 1 car constructors.
- Wet lay up, pre-preg, thermoforming tools.
- Heat curing composite tools including short run vacuum forming moulds.

978

Colour	Blue
Hardness, Shore D	70
Density, g/cm <sup>3</sup> (kg/m <sup>3</sup> )	0.68 (680)
Glass Transition Temperature	145°C
Coefficient of Thermal Expansion	$39 \times 10^{-6}$
Flexural Strength, MPa	38
Flexural Modulus, MPa	2,200
Compressive Strength, MPa	50.0
Compressive Modulus, MPa	2,400

Sheet Size: 1524 x 608mm

Thicknesses stocked: 50mm, 75mm, 100mm

Machining Parameters		
	Cut speed (Vc in m/min)	Feed per tooth (fz in mm/revolution)
Rough shape	100 to 400	0.35
Finish	400 to 800	0.05 à 0.15

$$n = (1000 \times Vc) / (\pi \times Dc) \quad Vf = n \times fz \times Z$$

- Vc: Cutting speed in m/min
- Dc: cutting diameter in mm
- n: Spindle speed
- fz: Feed per tooth in mm/revolution
- Z: number of teeth
- Vf: feed speed

## Kiwi Tooling Ltd

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