

CTB - 42 & 44

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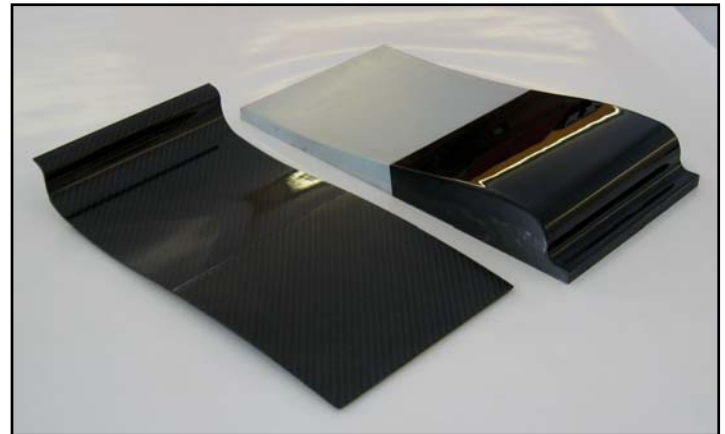


Composite Tooling Board

CTB - 42 and CTB - 44 are two new tooling boards manufactured by CMT Materials specifically for use in composites processing. Both are designed for use up to 250°F and are well suited for constructing forming tools for composite fabrication in pre-preg and autoclave cure, wet-lay up, vacuum infusion, and other composite processes. CTB - 42 and CTB - 44 may also be used for master models, fixturing, and other heat resistant applications. These moderate density epoxy systems feature low coefficient of thermal expansion for outstanding accuracy and dimensional stability. The CTB - 44 utilizes a smaller cell structure that produces slightly higher mechanical properties and a smoother surface finish. However, both materials offer the following:

- Good Machinability
- Superior Edge Definition
- Good Dimensional Stability
- Wide Variety of Standard Sizes
- Specialty Size Fabrication
- Outstanding Surface Finish

	CTB - 42	CTB - 44
Color	Gray	Blue Gray
Density	42 lb/ft ³	44 lb/ft ³
Hardness	79 Shore D	80 Shore D
Flexural Strength	5,600 psi	6,470 psi
Flexural Modulus	332 ksi	334 ksi
Compressive Strength	7,985 psi	8,010 psi
Compressive Modulus	304 ksi	290 ksi
Glass Transition Temp	285° F	285° F
Coefficient of Thermal Expansion (75° F to 200°F)	22 x 10 ⁻⁶ in/in /°F	22 x 10 ⁻⁶ in/in /°F



Available Sizes

1"x 24"x 60" 2"x 24"x 60" 3"x 24"x 60" 4"x 24"x 60" 5"x 24"x 60" 6"x 24"x 60"

Custom Sizes Available Upon Request

Machining

Cutters: Roughing - 1" Hog Ball End Mill, 4-Flute, HS Steel 8% Cobalt
 Finishing - 5/8" Ball End Mill, 2-Flute Carbide
Depth: Roughing - Varied from 1/4" to 2 1/2" Deep with a 40% Stepper
 Finishing - 1/8" Deep leaving 0.002" scallop height
Blades: Use Carbide Offset-tooth blade for faster cutting and less binding
Roughing Speed 1,600 RPM **Roughing Feed** 40 IPM **Finishing Speed** 10,000 RPM **Finishing Feed** 100 IPM

Safety

Do not use or handle this product until the Material Safety Data Sheet has been read and understood.