

CTB - 44

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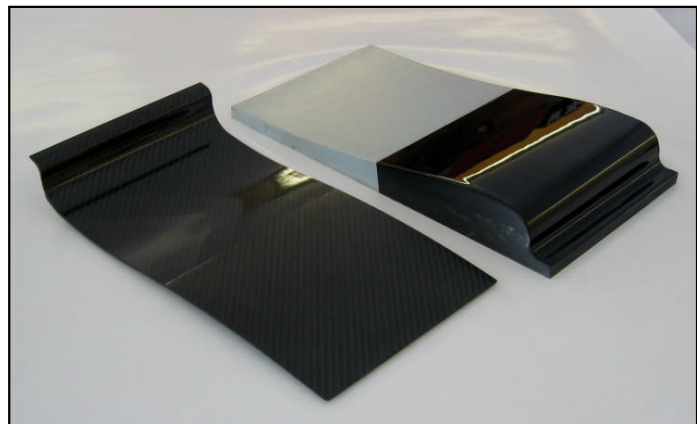


Composite Tooling Board

CTB - 44 is a tooling board manufactured by CMT Materials specifically for use in composites processing. Designed for use up to 250°F and 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 - 44* may also be used for master models, fixturing, and other heat resistant applications. This moderate density epoxy systems features low coefficient of thermal expansion for outstanding accuracy and dimensional stability. The *CTB - 44* utilizes a smaller cell structure than most boards that produces slightly higher mechanical properties and a smoother surface finish. The material offers the following:

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

	<i>CTB - 44</i>
Color	Blue Gray
Density	44 lb/ft ³
Hardness	80 Shore D
Flexural Strength	6,470 psi
Flexural Modulus	334 ksi
Compressive Strength	8,010 psi
Compressive Modulus	290 ksi
Glass Transition Temp	285° F
Coefficient of Thermal Expansion (75° F to 200°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"
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% Steptover
 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.