obomodulan® 1200 green - polyurethane board material

Applications	**Properties**
• checking fixtures • core boxes • pattern plates	• very fine cell structure • easy to shape and machine

Technical data (measured average values)		
Density approx.	**1200 kg/m³**	
Colour	**green**	
Compressive strength	**80 - 85 MPa**	DIN EN ISO 604
Bending strength	**90 - 95 MPa**	DIN EN ISO 178
Linear thermal expansion coefficient temperature from approx. 25 - 70 °C	**60 - 65 x 10^{-6} · K^{-1}**	according to DIN 53752
Shore hardness	**83 - 87 Shore-D**	DIN 53505
Deflection temperature	**80 - 85 °C**	

Standard dimensions	1000 x 500 x 30 mm 1000 x 500 x 50 mm 1000 x 500 x 75 mm 1000 x 500 x 100 mm	1500 x 500 x 30 mm 1500 x 500 x 50 mm 1500 x 500 x 75 mm 1500 x 500 x 100 mm	2000 x 500 x 50 mm 2000 x 500 x 75 mm 2000 x 500 x 100 mm
	Other dimensions, cut size parts and glued blocks on request.		
glue	**OBO-bond green**		
	Mixing ratio by proportion of weight	Resin 100	Hardener 50
	Pot life 150 g / 20 °C	15 - 20 min.	
	Curing time at room temperature	4 - 10 hours	
Storage	The boards must be stored dry, on a flat underground, at room temperature! Strong temperature differences during storage and transport should be avoided.		

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Machining	Before machining, the boards should acclimatise at a temperature of 18 - 25 °C. The obomodulan® materials can be machined with all standard wood and metal working machines. The used milling cutters should be made of carbide. Solid carbide for small milling cutters and hard metal carbide blades for larger milling cutter diameters. The geometry of the cutting tools is the same as for the machining of aluminium. However, we recommend that you test your own machines in order to get the best possible results.
Working and safety recommendations	Please read the material safety data sheet for all necessary information on health and safety at work and the general safety recommendations.
Waste disposal	After prior consultation of the responsible authorities (waste management company, district, trade supervision office, etc.), cured PU foam can be disposed as household or commercial waste in most regions.
Legal notice	All information about the material, the processing and machining are given without obligation to the best of our knowledge and are not to be taken as an assurance of the properties of the material or the processing and application possibilities in individual cases. The user must check the product himself for its suitability for the intended application. In all other respects our terms of sale apply, which can be viewed and downloaded at any time from our homepage www.obo-werke.de.