



NECURON® 1020

Data Sheet

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Characteristics:

- high flexural strength, compressive strength and abrasion resistance

Applications:

- hammer form and flanging tools
- foundry models with high mechanical stress
- foundry assemblies and core boxes
- sheet metal forming tools and metal bending tools for thin sheet metal

Technical data:

Colour	blue
Coefficient of thermal expansion	approx. $65 \times 10^{-6} \text{ K}^{-1}$
Temperature resistance	approx. 70 °C
Shore D	approx. 80
Compressive strength	approx. 82 N/mm ²
Flexural strength	approx. 79 N/mm ²
Density	approx. 1.20 g/cm ³
Abrasion resistance (at defined parameters)	approx. 420 mm ³
Fire protection classification	-
Electrical current resistance	approx. - $\Omega \times \text{cm}$
Notched impact strength	approx. 14.3 kJ/m ²
Thermal conductivity	approx. - W/mk

- contains no halogens, plasticizer or solvent
- manufactured fluorocarbohydrate-free
- physiologically harmless

Measurements:

1200	400	50	mm
1200	400	75	mm
1200	400	100	mm
1000	500	50	mm
1000	500	75	mm
1000	500	100	mm

surfaces machined parallel, other dimensions on request

Storage/Transport:

NECURON®-boards should be stored on a flat underground and in a dry space at a temperature between 18°C and 25°C.

Variations in temperature should be avoided during the transport and storage.



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Processing:

Adhesive / Putty	Colour	Mixture ratio A to B (by weight)	Pot life in minutes at 20°C	Curing time at 20°C in hours
NECURON® K8	colourless transparent	1:1	10	4-6

or usual and compatible patternmaking adhesives/resins

We recommend that boards are plane-parallel to ensure good glue joints.

Machining:

Machining temperature: 20°C - 25°C

Tools: metal-cutting tools, large receptacle for removing shavings is required

Milling parameters:

	Roughing	Finishing
Type of tool	finishing tools d=80mm	finishing tools d=80mm
Tool diameter [d] (mm)	80	80
Cutting speed [Vc] (m/sec)	50	50
Speed [n] (1/min)	12000	8000
Feed speed (m/min)	7.5	5
Tooth speed [fz] (mm)	0.16	0.16
Number of teeth [z]	4	4
Cutting depth [a _e] (mm)	3.5	0.5
Cutter mark length [f _{zeff}] (mm)	38	5

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This material does not contain any fillers that release harmful dust during machining. Nevertheless the dust content in the air should not rise above 6 mg/m³. Safety procedures recommended by the vocational co-operative of the chemical industry should be complied with. The article is not a regulatory product according to ICC regulations. In accordance with general local and national regulations waste is to be disposed by incineration in authorised places or conveyed to authorised tips (EAK 120105).

Technical statements and recommendations refer to current standard of technique and are based on our own experience. Further developments and improvements are reserved. Due to the variety of processing possibilities own experiments are recommended to optimise results.