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 **Piedmont Plastics**
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Precision Board Plus™

PBLT-20

DESCRIPTION & APPLICATION:

PBLT-20 is a rigid, High Density Urethane, (HDU), Tooling/Modeling board designed for Prototype Machining, Water Jet Cutting, Pattern Making, Thermoforming, Prepreg Composite Layup Tooling, Vacuum Form Tooling, Tool Path Proofing, Lost Wax Casting Masters, Master Model Making, Artistic Carving Blocks, Indoor and Outdoor Signage. PBLT Plus is made in the USA.

Precision Board Plus PBLT is formulated with eco-friendly, "Green" urethane components. The new Plus material has a Certified "Carbon Foot Print" of 3 to 1 and a Certified "Rapidly Renewable Green Resource Content" of 23.9%. This means each 3"x 4'x8' sheet of PBLT-20 saves 38.5 pounds of plastic material which assists meeting LEED requirements for obtaining USGBC and ICC 700 building credits.

Precision Board Plus **does not contain: CFCs or VOCs.** See MSDS for details.

Precision Board Plus PBLT comes in standard sizes of 20"x60", 24"x60", 30"x80", 45"x60" 4'x8', 4'x10', 5'x8' and 5'x10'. Thickness ranges from 1/2" to 24". Custom bonded blocks available in any size. PBLT Densities are 4, 6, 8, 10, 12, 15, 18, 20, 30, 34, 40, 48, 60, 70, & 75 pcf. Other densities available.

Precision Board Plus is **non-abrasive**, can be machined with HSS bits or cut with any standard cutting tool. PBLT's tight cell structure allows adjusting spindle speed & table feed to produce either chips or dust as desired. Check Coastal's on-line Onsrud Router Search guide for most efficient cutter bit for desired speeds & feeds. PBLT Plus does not outgas or affect prepreg resin cure.

See FAQ for important oven/autoclave ramping procedures and other pertinent information. **

PBLT can be bonded to itself or most other substrates using Coastal Enterprises' one part urethane adhesives: PB Bond-240 and PB Fast Set or EP-76, a two part, epoxy adhesive.

PHYSICAL PROPERTIES:

Density	ASTM D-1623	20 lbs/Cubic Foot
Compressive Strength	ASTM D-1621	956 psi
Compressive Modulus	ASTM D-1621	39,101 psi
Tensile Strength	ASTM D-1623	601
Tensile Modulus	ASTM D-1623	59,985 psi
Shear Strength	ASTM C-273	516 psi
Shear Modulus	ASTM C-273	7,900 psi
Flexural Strength Method 1A	ASTM D-790	960 psi
Flexural Modulus Method 1A	ASTM D-790	30,120 psi
Hardness Shore D	ASTM D-2240	34
Elongation		6.7%
Dimensional Stability	ASTM D-2126	1.2% Max.
Water Absorption	ASTM D-2842	0.01% by Vol. after 96 hrs.
Closed Cell Content	ASTM D-2856	97%
"K" Value Thermal Conductivity	ASTM C-177	0.543
Impact Resistance	0°F 4.6 oz. 1" Dia. 9'6" drop	No cracking observed
Freeze Thaw	ASTM D-2126, 25 Cycles	No disbonding or distortion occurred
Mold and Mildew Resistance	ASTM D-3273	Does not support growth
Dielectric Constant	ASTM D-1678	1.3
Maximum Service Temperature	Dry	200° F
Coefficient of Thermal Expansion (CTE)	DMA/TMA	20 X 10 ⁻⁶ °F
Glass Transition	FAR 25.853 Vertical Burn	209°F
Flammability Tests:	MIL P 26514 Burn Test	Pass
	ASTM D-1692-74 Burn Test	Pass
	ASTM D635-06 Burn Test	Pass

** Follow heat temperature ramping of 1°F up per minute & 2°F down per minute. See FAQ for additional data.

Any Questions please contact Coastal Enterprises Company

(800) 845-0745

www.PrecisionBoard.com

WARRANTY: All recommendations for product use have been derived from experience and test data believed to be reliable. We warrant and guarantee the uniformity of our products within manufacturing tolerance. However, since the use of our products is beyond our direct control, they are furnished upon the condition that each party shall make his/her own tests to determine their suitability for his/her particular purpose. Except as stated herein, Coastal Enterprises Company makes no warranty or guarantee, expressed or implied, and disclaims all responsibility for results obtained, nor assumes any liability for any damages, whether arising out of negligence or breach of guarantee and is hereby expressly limited to replacement of product only. For additional information on product handling, please refer to Precision Board Plus MSDS.