

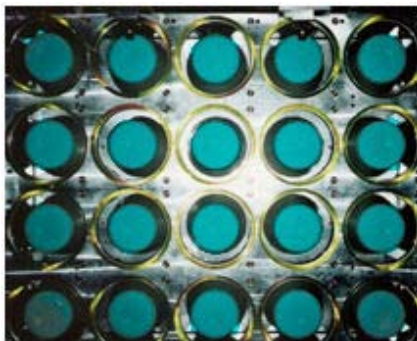
Thermoplastic Syntactic Foam



Technical Data Sheet

Ultra S, a new copolymer syntactic plug material is tailored to balance key processing and preparation properties. The material allows for easy polishing to an extremely smooth surface with improved toughness over thermoset syntactic.

Ultra S eliminates the machining difficulties of conventional epoxy syntactic foams producing easily managed chips with no dust. The smooth finish helps to reduce mark-off and scratching on the final part



surface for improved clarity.

- Excellent Polishing Characteristics for a Smooth Plug Surface
- Moderate-to-Good Toughness and Durability
- Good Temperature Resistance
- Low Heat Transfer to Reduce Haze and Increase Gloss on Clear Parts
- Lightweight
- Available in Rod, Sheet or Block sizes.

Color:	Slate Blue
Density:	46 lbs/ft ³
Thermal Conductivity:	0.07 BTU/hr-ft- ⁰ F
Specific Heat:	0.37 BTU/lb ⁰ F
Coefficient of Thermal Expansion:	35 x 10 ⁻⁶ in/in/ ⁰ F
Compressive Strength :	6300 psi
Compressive Modulus:	408 Ksi
Service Temperature:	350 ⁰ F

Tooling Tech Group
100 Enterprise Drive
Fort Loramie, Ohio 45845
Ph: (937) 295-3672
Fax: (937) 295-3677
info@toolingtechgroup.com

Typical Properties

Machining :

Tooling: Cemented carbide or solid carbide (C-2 type)
Non-coated, with maintained sharp edge.

Cutting Speed: 400 - 1700 ft/min

Feed Rate: 6 – 15 in/min

Cut Depth: 0.20 in max

Coolant: None or Air