



NECURON® 651

Data Sheet

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Characteristics:

- very fine structure
- smooth surface
- easy to varnish
- excellent processing properties

Applications:

- master models and copy models
- cubing models
- work models
- general modelling

Technical data:

Colour	brown
Coefficient of thermal expansion	approx. $52 \times 10^{-6} \text{ K}^{-1}$
Temperature resistance	approx. 70°C
Shore D	approx. 68
Compressive strength	approx. 26 N/mm ²
Flexural strength	approx. 30 N/mm ²
Density	approx. 0.70 g/cm ³
Abrasion resistance (at defined parameters)	approx. - mm ³
Fire protection classification	B2
Electrical current resistance	approx. - $\Omega \times \text{cm}$
Notched impact strength	approx. - kJ/m ²
Thermal conductivity	approx. 0.11 W/mk

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

Measurements:

1200	500	130	mm
1200	500	150	mm
1500	500	40	mm
1500	500	50	mm
1500	500	60	mm
1500	500	75	mm
1500	500	100	mm
1500	500	130	mm
1500	500	150	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	Pot life in minutes at 20°C	Curing time at 20°C in hours
NECURON® K6	brown	1:1	2-3	0.5
NECURON® K8	transparent	1:1	10	4-6
NECURON® S6	brown	1:1	10-12	6-8

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-working tools

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)	10	7.5
Tooth speed [fz] (mm)	0.21	0.21
Number of teeth [z]	4	4
Cutting depth [a _e] (mm)	4	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.