



# Precision Board

## High Temperature Tooling Board

### PBHT-6

Manufacturers of  
Precision Board

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Product Data Sheet

#### DESCRIPTION:

Precision Board, PBHT, is a rigid, high temperature urethane tooling board that is designed for Prototype Machining, Prepreg Composite Layup Tooling, Vacuum Form Tooling, Tool Proofing, Pattern Making, and Master Model Making.

PBHT is designed to perform at 300°F and does not outgas or affect prepreg resin cure. PBHT has a low CTE.

Precision Board PBHT comes in standard sizes of 20" x 60", 24" x 60", 4' x 8', 4' x 10', 5' x 8', and 5' x 10'. Thicknesses range from 1/2" to 20". Other special sizes are available upon request. Densities are available in 4, 6, 10, 12, 15, 18, 20, 30, and 40 pounds per cubic foot (pcf). Other special densities are available upon request.

#### APPLICATION:

Precision Board is non-abrasive and can be machined and cut with HSS cutters, or any standard cutting tool.

PBHT can be bonded to itself or other substrates using Coastal Enterprises' single component urethane adhesives: PB Bond-240 and PB Fast Set, or EP-76 epoxy adhesive. Please refer to PB Bond-240, PB Fast Set, and EP-76 data sheets for particulars.

#### PHYSICAL PROPERTIES:

Density	ASTM D-1622	6 lbs/Cubic Foot
Compressive Strength	ASTM D-1621	109 PSI
Tensile Strength	ASTM D-1623	70 PSI
Shear Strength	ASTM D-273	40 PSI
Dimensional Stability	ASTM D-2126	1.2% Max.
Water Absorption	ASTM D-2842	0.056% by Vol. after 96 hrs.
Closed Cell Content	ASTM D-2856	97%
"K" Value Insulation Factor	ASTM C-177	0.216
Impact Resistance	O° 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	300° F
Coefficient of Thermal Expansion (CTE)		32 X 10 <sup>-6</sup> °F
Precision Board does not contain any Chlorinated Fluorocarbons (CFC's)		
Flammability Tests:	FAR 25.853 Vertical Burn	Pass
	MIL P 26514 Burn Test	Pass
	ASTM D-1692-74 Burn Test	Pass

**For questions regarding the use of Precision Board PBHT,  
please contact Coastal Enterprises Company  
at (800) 845-0745**

**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 are 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 PBHT MSDS.