Technical Data Sheet

maridur® 70

Application	Properties
• interior constructions for yachts • furniture manufacture • base rail boards, skirting • profiles • the material is ideal for high gloss lacquering	• fine cell structure • very good machinability by hand and machine • excellent paintability • no swelling • easy to coat

Description

- **maridur® 70** is a premium and easily machinable plastic

Technical Data*	
Density approx. **kg/m3**	720
Compressive strength (DIN EN ISO 604) approx. **MPa**	30 – 35
Bending strength (DIN EN ISO 178) approx. **MPa**	25 – 30
Linear thermal expansion coefficient temperature from approx. 25 up to 70 °C (according to DIN 53752) **$10^{-6} \cdot K^{-1}$**	45 - 50 x $10^{-6} \cdot K^{-1}$
Shore-D (DIN 53505) **Shore-D**	69 – 77
Deflection temperature **°C**	80 - 85

*measured average values

Possible dimensions:

- 2000 x 500 x 10 - 100 mm
- 2000 x 1000 x 10 - 100 mm

The boards should be stored flat and at room temperature. Before processing, the boards should be acclimatized at a temperature between 18 – 25 °C.

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Glue

We use a two component epoxy based adhesive. However, you may also use any other polyurethane, epoxy or polyester based adhesive of your choice.

Processing instructions

Sawing

- machining is possible with all common saws (horizontal or vertical saw as well as normal table and hand circular saws)
- we recommend using only carbide-tipped saw blades
- angle of gash from 8 to 10 degrees
- cutting speed 40 to 80 m/min.

Milling (router)

- we recommend carbide-tipped tools (for maridur® a sharp cutting edge is required)
- best milling results are achieved with high rpm (revolutions per minute) and high feed rates
- milling with a drawing cut and a small lip angle is beneficial

Dowels (round dowels)

- select the dowel hole 0,1 to 0,2 mm larger than the outer diameter of the dowel (this is the only way to ensure a uniform adhesive application)
- ribbed dowels support a sufficient adhesive application on the cylinder side of the dowels

All given data are recommended guidelines, which are used in our company to achieve optimum results.
Depending on the machine type, tool and workpiece, the parameters need to be selected and adapted by the processor.
The maximum permissible values specified by the respective machine and tool manufacturer must be observed and may NOT be exceeded.

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