

# REN SHAPE<sup>®</sup> 5008

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## Vacuum Forming Tooling Board

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REN SHAPE 5008 is a tooling board specifically designed for use in vacuum forming. It is designed for use up to 250°F and is well suited for building vacuum forming molds as well as master models, lay-up tools for prepreg curing, and other heat resistant tooling. This moderate density epoxy system features a low coefficient of thermal expansion for outstanding accuracy and dimensional stability. REN SHAPE 5008 also offers the following:

- Good Machinability
- Superior Edge Definition and Dimensional Stability
- Outstanding Surface Finish

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### Typical Properties

Color	Light Blue
Density	42 lb/ft <sup>3</sup>
Hardness	68 Shore D
Flexural Strength	4,600 psi
Flexural Modulus	350,000 psi
Compressive Strength	8,200 psi
Compressive Modulus	350,000 psi
Tensile Strength	3,500 psi
Glass Transition Temp	287° F
Coefficient of Thermal Expansion (-22° F to 86°F)	18 x 10 <sup>-6</sup> in/in /°F

### Available Sizes

2"x 24"x 60"  
4"x 24"x 60"  
6"x 24"x 60"

### Accessories

Adhesive: REN WELD 5008  
Patch Paste: REN PATCH 5008

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## Applications

REN SHAPE 5008 applications may include prototype and production vacuum forming molds, temporary intermediate-temperature master and lay-up tools and master models for composite parts.

## Machining

Cutters:      Roughing - 1" Hog Ball End Mill, 4-Flute, HS Steel 8% Cobalt  
                  Finishing - 5/8" Ball End Mill, 2-Flute Carbide  
Depth:        Roughing - Varied from 1/4" to 2 1/2" Deep with a 40% Steptover  
                  Finishing - 1/8" Deep leaving 0.002" scallop height  
Blades:        Use Carbide Offset-tooth blade for faster cutting and less binding  
Roughing Speed 1,600 RPM    Roughing Feed 40 IPM    Finishing Speed 10,000 RPM    Finishing Feed 100 IPM

## Safety

Do not use or handle this product until the Material Safety Data Sheet has been read and understood.