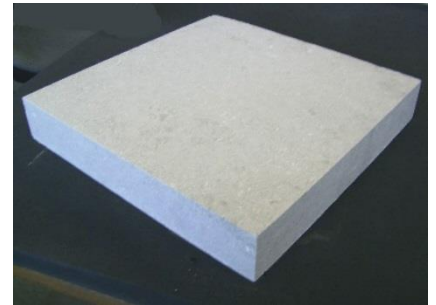




Aqua Block Data Sheet

Aqua Blocks produced out of our standard material Aquacore offers a very fast washout time. They work very well for standard Autoclave applications. If smoother surface finish, tighter tolerances and high-pressure during curing are requested then we recommend the use of our Solidcore blocks. For these very stable blocks we recommend the washout by pressurised water. For bonding we recommend Aqua Tool Bond, our water-soluble adhesive.

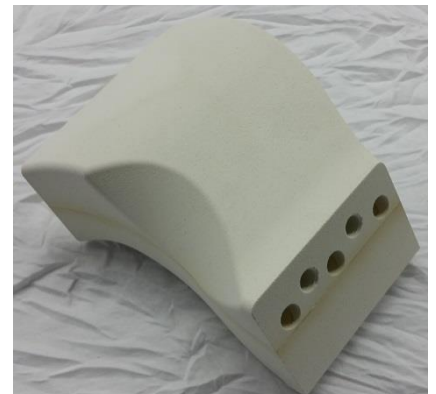
- Prefabricated and dried
- Vacuum sealed to avoid moisture uptake
- Bondable to thicker constructions
- Colour light grey
- Ready to use
- Machinable (see instructions)
- Various thickness available
- Other dimensions on request



Technical properties	Aquacore Block	Solidcore Block
Compressive strength	up to 6bar	over 40bar
Density	0.46 gr/cm ³	0.86 gr/cm ³
Temperature resistance	195°C	195°C
CTE	4.7 e ⁻⁶	14.0 e ⁻⁶

Standard Sizes Aquacore and Solidcore Blocks***

Article No	Dimension
88050	620 x 620 x 50 mm (19.22 Litre)
88051	620 x 620 x 30 mm (11.53 Litre)
88055	620 x 620 x 80 mm (30.75 Litre)
88060	620 x 620 x 100 mm (38.44 Litre)
88065	620 x 620 x 120 mm (46.13 Litre)
88070	620 x 620 x 150 mm (57.66 Litre)
88073	620 x 620 x 180 mm (69.20 Litre)
88075	620 x 620 x 200 mm (76.88 Litre)
79949***	500 x 500 x 25 mm (6.25 Litre)
79950***	500 x 500 x 50 mm (12.50 Litre)
79951***	500 x 500 x 75 mm (18.75 Litre)
79954***	500 x 500 x 150 mm (37.50 Litre)
8807	Aqua Tool Bond Adhesive (½ Gallon)



Basic data for machining Aqua Blocks

Roughing	Finishing
Speed 5'000rpm	Speed 8'000rpm
Feed 60in / 1524mm / min	Feed 25in / 635mm / min
Cutting depth 0.2" / 5.0mm	Cutting depth 0.005" / 0.13mm

Cutting depth relating to a 3-flute end mill carbide cutter (face- or ball end).

Meant as a guide only! If a complex shape operator should adjust accordingly. Call or fax Aero Consultants AG for assistance with your specific manufacturing requirements. Aero Consultants AG makes no warranty expressed or implied, including warranties of merchantability or fitness for a particular use. Under no circumstances will Aero Consultants AG be liable for incidental, consequential or other damages, alleged negligence, breach of warranty, strict liability, tort or any other legal theory arising out of the use or handling of this product.