



EB6200

EPOXY TOOLING & PATTERN PLANK

BCC Products EB6200 is a "grain-free" elevated temperature epoxy modeling material known for its superior surface finish, dimensional stability and the ability to maintain tolerances even after being subjected to temperature variations. EB6200 has excellent dimensional stability results from the low coefficient of thermal expansion and high glass transition temperature.

Application and Features:

- * Master Models (Aerospace)
- * Automotive Die Models
- * Vacuum Forming at Elevated Temperatures
- * Lay-Up Tools for Medium and High Temperature Curing Prepreg
- * Excellent machinability
- * Low dust generation
- * Maximum use temperatures of 325°F (162°C)

USAGE AND GENERAL INFORMATION

Instructions for use:

Manufactured for the aerospace and automotive industries that need a high-temperature material for large patterns EB6200 is best when bonded with BC5105 epoxy high temp adhesive. Before bonding be sure surface is clean of any debris and dry. Preassembly is suggested to verify areas of bonding and cutting if required.

Clamping or vacuum bagging of bonded material is suggested to obtain proper bond lines. Apply adhesive with spreader so bond line is no thicker than 1mm.

General bonded material should be built so the machining will remove end material from blocks.

Construction Hints

1. In order to achieve the required thickness for models and patterns with heights greater than two inches it is necessary to cut (saw) EB6200 lengthwise into as many sections needed for your model.
2. The glued EB assembly can now be bonded to a chosen base plate. Suggested base plate materials are: Impreg Wood, metal tubing, fabricated honeycomb panel or additional EB6200 Model Board.
3. EB6200 is now ready to be carved or machined. Standard woodworking tools and/or high speed steel cutters are recommended for contouring to required size.
4. Finish with pattern coating or sanding lacquer sealer.

BCC Products Inc.

2140 Earlywood Dr. • Franklin, IN 46131

Order-Line: 800-556-0067 • Fax: 317-736-4872 • www.bccproducts.com

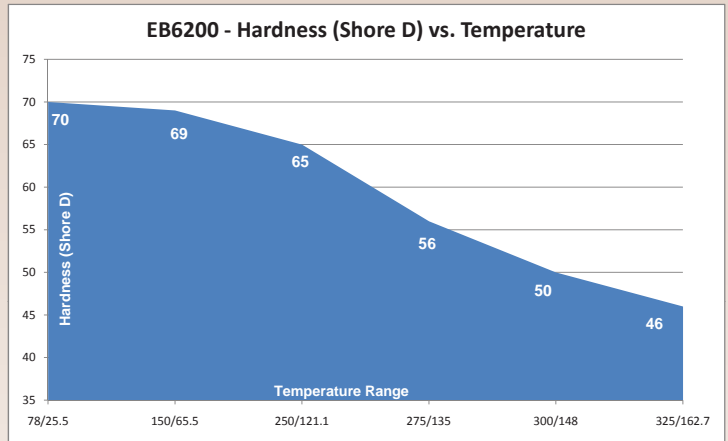


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SPECIFICATIONS/PHYSICAL PROPERTIES

	VALUE	TEST METHOD
Color	Brown	Visual
Hardness, Shore D	72	ASTM D-2240
Density, g/cm ³ (lbs/ft ³)	0.76 (47)	ASTM D-792
Heat Deflection Temperature, °F	300	ASTM D-648
Glass Transition Temperature, °F	>325	ASTM D-3418
Coefficient of Thermal Expansion,		
in/in/°F	21 x 10 ⁻⁶	TMA
in/in/°C	37.8 x 10 ⁻⁶	TMA
Izod Impact, Notched (Unnotched),		
ft-lbs/in	0.56	ASTM D-256
g/cm	1.05	ASTM D-256
Tensile Strength, psi	4,400	ASTM D-638
Flexural Strength, psi	5,150	ASTM D-790
Flexural Modulus, psi	349,000	ASTM D-790
Compressive Strength, psi	4,800	ASTM D-695
Compressive Modulus, psi	342,000	ASTM D-695



Hardness (Shore D) vs. Temperature range °F (°C)

70D	78°F (25.5°C)
69D	150°F (65.5°C)
65D	250°F (121.1°C)
56D	275°F (135°C)
50D	300°F (148°C)
46D	325°F (162.7°C)

ADDITIONAL SPECIFICATIONS/INFORMATION

Sizing

Available sizes:

2"x24"x60"

4"x24"x60"

6"x24"x60"

Additional sizes on special requests only.

Machining/CNC Milling (Recommendations):

Roughing Speed

1500-2,000 RPM

Feed

80-100 IPM

Cutters:

2 or 4 flute carbide bit

Finishing Speed

6,000 - 7,000 RPM

Feed

300 - 450 IPM

Cutters:

3/4" ball end, 4 flute carbide bit

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