

# Foundry Grade



## Pattern Materials

### MB4000

#### Foundry Plank

BCC Products now offers a revolutionary state-of-the-art machineable foundry plank for today's demanding tooling requirements. MB4000 Red is an extremely tough, high impact Urethane Plank. MB4000 has these great qualities:

- \* Excellent machinability
- \* Low dust emission, mostly shavings
- \* No shrinkage
- \* Excellent impact and wear resistance
- \* Excellent surface detail reproduction
- \* Excellent surface finish
- \* Polishable to a high gloss

#### Features:

Density(lbs/ft<sup>3</sup>; gms/cm<sup>3</sup>): 71/1.14  
 Hardness: 86D  
 Tg (°F): 240  
 Heat Distortion (°F): 214  
 CTE (in/in/°F): 35.60x10<sup>-6</sup>  
 Color: Red  
 Sizes: 2"-4"x16"x60" and 1"-6"x24"x60"  
 Repair material: DP-11-75  
 Adhesive: BC5003 Red

### BC8860

#### Casting Urethane

BC8860 is a low viscosity two-component urethane casting compound that is specifically formulated for high abrasion and impact resistance.

#### Features:

Mix ratio: 100:60 by wt.  
 Pot life: 18 minutes  
 Viscosity (Mixed)@ 75F: 1,400-1,500  
 Cure schedule: See Tech Datasheet  
 Color: Amber, Black, Red



## Pattern Materials

### HPX-850

#### Backfill System

HPX-850 is a light weight, heat resistant, two component epoxy backfill system. Like BC 7020, the filler portion is pre-blended into the resin and hardener components for easier handling, thus simplifying the mixing process. HPX-850 features advantages such as low cost, long pot life, machinability, and low shrinkage. HPX-850 is ideally suited for numerous applications involving mold and core construction.

#### Features:

Mix ratio: 100:16 by wt.  
 Pot life: 2-2.5 hours  
 Viscosity (Mixed)@ 75F: Paste  
 Cure schedule: See Tech Datasheet  
 Color: Gray

### BC8650 Kwik-Kast Blue

BC 8650 is an advanced fast cast polyurethane tooling system. BC 8650 features low viscosity, low exotherm and minimal shrinkage. Kwik Kast Blue cures hard, yet more durable resulting in less brittle parts. Designed for constructing patterns, prototypes, duplications, negatives, low temperature vacuum form tools, tracing models, etc.

#### Features:

Mix ratio: 1:1 by wt.  
 Pot life (1lb. mass) @ 75F: 5-6 minutes  
 Viscosity (Mixed)@ 75F: 2,120cps  
 Demold time: 1-2 hours  
 Color: Blue



## Styrofoam Pattern Glue

### BP8002

#### Styrofoam Pattern Adhesive

BP 8002 is a water-based latex-rubber adhesive used for the rapid build-up of styrofoam foundry patterns. BP 8002 contains a green dye for easier visibility. BP8002 has been specially formulated and fully approved for the "Full Mold Foundry Process" of direct metal casting using styrofoam patterns.

#### Features:

Viscosity: Brushable thixotropic  
 Weight (per gal.): 7.6lbs  
 Base: Liquid Latex dispersed in water  
 Color: Green

### BP8003

#### Styrofoam Pattern Adhesive

BP 8003 is a water-based latex-rubber adhesive used for the rapid build-up of styrofoam foundry patterns. BP 8003 contains a natural cream color to blend with styrofoam. BP8003 has been specially formulated and fully approved for the "Full Mold Foundry Process" of direct metal casting using styrofoam patterns.

#### Features:

Viscosity: Brushable thixotropic  
 Weight (per gal.): 7.6lbs  
 Base: Latex rubber dispersed in water  
 Color: Cream