



BCC PRODUCTS, INC.

BLEHM PLASTICS

FAST CAST – EPOXIES – ADHESIVES - POLYSULFIDES - URETHANES – POLYESTER PASTES – TOOLING BOARDS – RELEASE AGENTS – SILICONES

BC100 Medium

Cyanoacrylate Adhesive

BC100 Medium, like its name in the medium viscosity version of cyanoacrylate adhesive that has become most popular in the super bonding applications. A 12 second fixture bond makes the BC100 the fastest in our family of cyanoacrylates. Excellent for bonding rough and porous surfaces BC100 meets Military specification MLLA 46050 Type II Class II. Perfect for industrial manufacturing and repair applications, you can bond with speed.

BONDING SCHEDULES

Plastics: 2-5 seconds
Wood: 1-5 seconds
Metals: < 5 seconds

Rubber: <3 seconds
Leather: 5-15 seconds
Ceramics: 10-20 seconds

PHYSICAL PROPERTIES

Composition:	Surface Insensitive Ethyl Cyanoacrylate
Appearance:	Colorless liquid
Viscosity@ 25°C (Brookfield LVF, Spindle 1-60 rpm):	80-120cps
Glass Transition Temperature, (ASTM E228, °C):	122
Dielectric Strength, (ASTM D149):	625 v/mil
Coefficient of thermal expansion, (ASTM D696): K ⁻¹	90 x 10 ⁻⁶
Coefficient of thermal conductivity, (ASTM C177, W.m ⁻¹ K ⁻¹):	0.1

Cured Adhesive

Gap Filling:	0.2 mm
Tensile Shear Strength:	18-28 n/mm ²
Service Temperature Range:	-60 to +80oC
Full Cure:	24 hours
Melting Point Temperature:	160 to 170oC

Shear Strength, ASTM D1002/DIN 53283

Grit Blasted Steel:	>20 N/mm ²
Etched Aluminum:	>18 N/mm ²
Rubbers:	>22 N/mm ²
Wood:	>25 N/mm ²
Polycarbonate:	>12 N/mm ²
ABS:	>10 N/mm ²

Application Instructions

- All surfaces must be clean, dry, dust and grease free. Best result will be achieved with surfaces that have been lightly abraded immediately prior to bonding.
- If using accelerator apply to one component surface only. Apply thin film of adhesive to the other surface and bring the pieces together immediately. Hold for few seconds without disturbing the joints.
- Thin bond lines favor high cure speed. Increasing the bond gap will slow down the rate of cure.

NOTE: The information contained herein is believed to be reliable. All recommendations are made without guarantee inasmuch as conditions and methods of commercial use are beyond our control. Properties given are typical values and are not intended for use in preparing specifications.

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