



BCC PRODUCTS, INC.

BLEHM PLASTICS

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

BC100 Thick

Cyanoacrylate Adhesive

BC100 Thick is the slow and thickest member of the BCC Products line of cyanoacrylate adhesive. Excellent for gap filling the BC100 Thick has a 30 second fixture time allowing for the material to fill voids and bonding areas. Bonds well to a variety of substrates and materials, formulated especially to plastics, metals and elastomers. Perfect for bonding rough and irregular surfaces and applications requiring up to 15 seconds of alignment and work time.

BONDING SCHEDULES

Steel: 25-35 seconds	ABS: 10-30 seconds
Neoprene: <5 seconds	PVC: 10-30 seconds
Aluminum: 10-20 seconds	Phenolics: 10-15 seconds
Polycarbonate: 15-20 seconds	Nitrile Rubber: 5-7 seconds

PHYSICAL PROPERTIES

Composition:	Ethyl Cyanoacrylate
Appearance:	Colorless liquid
Viscosity @ 25°C (Brookfield LVF, Spindle 1-60 rpm):	1,500 cps
Glass Transition Temperature, (ASTM E228, °C):	125
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:	0.45 mm
Tensile Shear Strength:	15-22 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

Neoprene Rubbers:	10-15 N/mm ²
Acrylics:	10-15 N/mm ²
PVC:	6-9 N/mm ²
Polycarbonate:	5-10 N/mm ²
ABS:	8-14 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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