



BCC PRODUCTS, INC.

BLEHM PLASTICS

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

EPOXY LAMINATING SYSTEM

(Heat Resistant)

BC5105

Epoxy

BC 5105 is a clear, unfilled, low viscosity laminating system. This heat resistant resin exhibits excellent wet out, reasonable working time and may be used at room temperature without post-curing. For use above 150°F a post-cure may be required. **BC 5105** can afford consistent use to 300°F if required. Does not contain VCHD or MDA.

Useful for:

- *Constructing vacuum form tools
- *Injection and compression molds
- *RTM and RIM molds
- *Matched dies

Working Properties

Mix Ratio (Resin/Hardener)	100 to 17 by wt. 100 to 20 by vol.
Viscosity (Brookfield @ 75°F)	2,000 cps
Pot Life (1 lb. mass) 75°F	55 Minutes

Cured Schedule

BC 5105 can be removed from the mold after allowing to set 24 hours @ room temperature (75°F). Post cure for applications requiring temperatures above 150°F can be accomplished in an oven or in use by a gradual heat rise; 2 hours @ 150°F plus 2 hours @ 250°F plus 2 hours at 300°F.

Physical Properties

Specific Gravity (gms/cc)	1.15
Weight/cu.in. (lbs.)	0.041
Hardness (Shore D) @ 75°F	90
Shrinkage (in./in.)	---
*Ultimate Tensile Strength (psi)	29,000
*Ultimate Flexural Strength (psi)	34,000
*Ultimate Compressive Strength (psi)	58,600
*Thermal Coefficient of Expansion (in./in./°F) x 10 ⁻⁵	0.90
HDT (°F) 264 psi	293

*Properties obtained from a 10 oz. glass cloth laminate. Not intended for use in preparing specifications.

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