



BCC PRODUCTS, INC.

BLEHM PLASTICS

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

EPOXY SURFACE COAT

(* for use with wet plaster) (White)

BC6004

Epoxy

BC 6004 is a white thixotropic epoxy surface coat that has the ability to cure and bond to freshly poured wet plaster. This formulated resin compound can be applied with a brush or troweled to a thickness of 1/8” or less on vertical surfaces or over sharp radii without sag or fear of run-off.

BC 6004 features moderate heat resistance and tracing hardness.

Working Properties

Mix Ratio (Resin/Hardener)	12 to 1 by wt. 7 to 1 by vol.
Viscosity (Brookfield @ 75°F) Mixed	Thixotropic Paste
Pot Life (4 oz. mass) @75°F	15-20 Minutes
Cure Schedule @ 77°F	8-12 Hours

Physical Properties

Specific Gravity (gms/cc)	1.58
Weight/cu.in. (lbs.)	0.057
Hardness (Shore D) @ 75°F	89
*Ultimate Tensile Strength (psi)	6,800
*Ultimate Flexural Strength (psi)	8,600
*Ultimate Compressive Strength (psi)	13,800
*Flexural Modulus (psi)	0.98 x 10 ⁶
Heat Distortion Temperature (°F)	174

2140 Earlywood Drive, P.O. Box 327, Franklin, IN 46131

Ph (317) 736-4090 Fax (317) 736-4872

Web: www.bccproducts.com & www.blehmplastics.com

PROCEDURE FOR PLASTIC FACED PLASTER APPLICATION

BC 6004 should be applied over a properly mold-released surface so that positive removal of the surface coated plaster casting is assured. For best results, two coats approximately 1/16" thick should be used. The first coat should be brushed over the entire surface and then be allowed to cure to a gelled or very tacky state. The second coat should be applied over the first. If hemp, glass or other fibrous plaster reinforcements are to be used, they should be placed in the freshly applied second coat immediately. Plaster can then be poured against the wet, second coat of **BC 6004**. To achieve good adhesion of the epoxy to the plaster, it is recommended that the plaster be poured immediately. The application of two coats of **BC 6004** will eliminate surface porosity that sometimes occurs when fast setting, "hot" plaster compounds are cast over a single coat of epoxy.

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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