



**BCC PRODUCTS, INC.**

**BLEHM PLASTICS**

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

## EPOXY HI-HEAT ABRASION RESISTANT

SURFACE COAT/CASTING

**BC6128**

Epoxy

**BC 6128** is a black, non-staining, silicon carbide filled, “die surface” surfacing resin. This thixotropic resin system provides excellent surface duplication along with good vertical coverage. Extended mold life due to superior wear resistance and hardness are the major benefits derived from its use. This heat resistant system may be used at room temperature without post-curing. For use above 150° F a post-cure is required. **BC6128** can afford consistent use to 300° F if required. Does not contain VCHD or MDA. Designed for uses in:

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

### Working Properties

Mix Ratio (Resin/Hardener)	100 to 7 by wt. 100 to 13 by vol.
Viscosity (Brookfield) @ 75°F	Thixotropic Paste
Pot Life (1 lb. mass) @ 75°F	35-45 Minutes

### Cure Schedule

**BC 6128** can be removed from the mold after allowing to cure overnight at room temperature. Post-cure for applications requiring temperatures above 250°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)	1.84
Weight/cu.in. (lbs.)	0.066
Hardness (Shore D) @ 75°F	92
Shrinkage (in./in.)	--
Tensile Strength (Ultimate) psi	7,450
Flexural Strength (Ultimate) psi	11,800
Compressive Strength (Ultimate) psi	28,800
Thermal Coefficient of Expansion (in./in./°F)	2.10 x 10 <sup>-5</sup>

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