



BCC PRODUCTS, INC.

BLEHM PLASTICS

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

EPOXY CASTING SYSTEM

(Heat Resistant)

BC7136R/BC7136-2H

Epoxy

BC7136-2 is an aluminum filled thick section casting system with heat resistance to 300°F. May be cast to a thickness of 2 inches in non-conductive molds, 3 inches in conductive molds and thicker sections with the addition of bulk fill. For service temperature above 150°F a post-cure is required. Does not contain VCHD or MDA. See cure schedule.

Working Properties

Mix Ratio (Resin/Hardener)	100 to 9 by wt. 100 to 16 by vol.
Viscosity (Brookfield @ 75°F) Mixed	13,500 cps
Pot Life (1 lb. mass) @ 75°F	180 Minutes

Cure Schedule

BC7136-2 can be removed from the mold after allowing to set 24 hours at 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 @ 300°F.

Physical Properties

Specific Gravity (gms/cc)	1.67
Weight/cu.in. (lbs.)	0.060
Cubic in./lb.	16.6
Hardness (Shore D) @ 75°F	90
Ultimate Tensile Strength (psi)	7,900
Ultimate Flexural Strength (psi)	8,900
Ultimate Compressive Strength (psi)	27,600
Heat Distortion Point (264 psi) °F	314
Shrinkage, Linear (ASTM-D-2566-69)	0.001 in./in.
Thermal Coefficient of Expansion (in./in. °F) x 10 ⁻⁵	2.02

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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