



BCC PRODUCTS, INC.

BLEHM PLASTICS

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

EPOXY CASTING SYSTEM

(Heat Resistant) Gray

BC7136

Epoxy

BC7136 is a gray, low toxicity, aluminum filled, epoxy casting resin. This heat resistant system may be used at room temperature without post-curing. May be cast to a thickness of 3/4 inch in non-conductive molds. For use above 150°F a post-cure is required. This product was engineered to replace VCHD and MDA systems while retaining excellent heat resistance and low viscosity. **BC7136** is designed for consistent use up to 300°F. Useful for:

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

Working Properties

Mix Ratio (Resin/Hardener)	100 to 7 by wt. 100 to 12 by vol.
Viscosity (Brookfield @ 75°F) Mixed	15,000 cps
Pot Life (1 lb. mass) @ 75°F	85 Minutes

Cure Schedule

BC7136 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)	1.69
Weight/cu.in. (lbs.)	0.061
Hardness (Shore D) @ 75°F	90
Ultimate Tensile Strength (psi)	7,800
Ultimate Flexural Strength (psi)	8,600
Ultimate Compressive Strength (psi)	29,000
Heat Distortion Point (264 psi) °F	305
Shrinkage, Linear (ASTM-D-2566-69)	0.0011 in./in.
Thermal Coefficient of Expansion (in./in. °F) x 10 ⁻⁵	1.9

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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