



BCC PRODUCTS, INC.

BLEHM PLASTICS

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

URETHANE CASTING SYSTEM

(TAN)

BC8086

Urethane

BC 8086 is a rapid setting, low viscosity, polyurethane casting system. It exhibits a working life of 45 seconds and obtains a demoldable hardness at 7 - 10 minutes. Some of the outstanding features include:

- *Non-sensitive to moisture after cure
- *Paintable (non oil base)
- *Will readily bond to itself
- *Moderate heat resistance
- *Excellent machinability and surface scribing
- *No settling components, no premixing required

Working Properties

Mix Ratio (Part A/Part B)	100 to 88 by wt. 100 to 100 by vol.
Viscosity (ASTM D 2393-71)	Mixed: 200-400 cps
Color	Part A: Brown Part B: Clear
Gel Time (4 fl.oz.) ASTM D 2471-71	45 Seconds

Physical Properties

Demold Time, 77°F (25°C)	7-10 Minutes
Specific Gravity (ASTM D 792-66), Cured	1.05
Hardness (Shore D) ASTM D 2240-66	79
Tensile Strength (ASTM D 638-72)	5,980 psi
Tensile Elongation (ASTM D 638-72)	6.4%
Flexural Strength (ASTM D 790-70)	8,810 psi
Compression Strength (ASTM D 695-69)	6,460 psi
Shrinkage (Volumetric)	1%

Cure Schedule vs. Heat Distortion

24 Hours @ 75°F	HDT 137°F
7 Days @ 75°F	HDT 145°F
1 HR. @ 75°F + 2 HRS. @ 150°F	HDT 192°F
1 HR. @ 75°F + 1 HR. @ 200°F	HDT 221°F
1 HR. @ 75°F + 1/2 HR. @ 300°F	HDT 252°F

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