



**BCC PRODUCTS, INC.**

**BLEHM PLASTICS**

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

## URETHANE CASTING SYSTEM

*Living Hinge Material*

(LIGHT AMBER)

**BC8160**

Urethane

**BC8160** is a low viscosity two-component urethane casting compound that is specifically formulated for its flexural and impact strength. It is recommended for use for the production casting of highly wear-resistant parts and prototypes. BC8160 can be used to develop thermoplastics type prototypes. This product is a safe, easy-to-handle, room temperature mixing and curing system that does not contain TDI, MDI, or MOCA. **BC8160** is relatively insensitive to typical environmental moisture and will make good void-free parts without the problems that some conventional urethane systems exhibit.

### Working Properties

Mix Ratio:

Resin Part A	100 parts by Weight
Curative Part B	60 parts by Weight
Mix Ratio (Resin/Hardener) by Volume	100 to 60
Viscosity, Centipoise (cps) @ 75EF	
Mixed, @ 1.5 Min.	1400 - 1500
Work Life @ 75EF	18 ± 2 minutes
Color, Part A	Clear
Part B	Light Amber
Demold Time:	Normally 6 to 8 hours at ambient; can be reduced to 1 hour with moderately elevated temperatures and/or molds.

Cure Schedule: Full cure in 3 to 5 days at room temperature or 16 hours @ 150Φ to 180F.

### Physical Properties

Specific Gravity (gm/cc) density	1.10
Cu. in./lb.	25.2
Hardness, Shore D	62 ± 2
Tensile Strength (psi) ASTM D-412	3,800 psi
Tensile Modulus (psi)	36,000
Shrinkage (in./in.)	0.0025
Color	Light Amber
Elongation (%) ASTM D-624	400
Tear Strength (pli) ASTM D-412	650
Flexural Strength (psi) ASTM D-790	3,700
Flexural Modulus (psi) ASTM D-790	78,000

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