



**BCC PRODUCTS, INC.**

**BLEHM PLASTICS**

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

## **URETHANE CASTING SYSTEM**

(WHITE)

**BC8165**

Urethane

**BC 8165** is a low viscosity, rapid setting, rigid urethane compound. Similar to BC 8163, however exhibits an 8 to 10 minute working time. This system will cure quickly to a hard, tough, impact resistant casting. **BC 8165** is non-sensitive to moisture after cure and will readily bond to itself if stage pours are required. **BC 8165** is recommended for thin wall model and prototype applications where a "thermoplastic feel" is desired. The heat resistance for BC8165 is 135°F, a heat resistance of 150°F can be achieved by post cure at 150°F for about 2 hours.

### **Working Properties**

Mix Ratio (Part A/Part B)	100 to 80 by wt. 100 to 87 by vol.
Viscosity (Brookfield @ 75°F)	Part A: 36 cps Part B: 640 cps Mixed: 230 cps
Color	Part A: Light Amber Part B: Translucent
Pot Life (1 lb. mass) @ 75°F	8-10 minutes
Demold time, 75°F	1 - 2 hours*
Final Cure, 75°F	7 days

### **Physical Properties**

Specific Gravity (gms/cc), Cured	1.07
Cubic Inches per Pound	26
Hardness (Shore D) @ 75°F	83±2
Linear Shrinkage (ASTM D2566)	0.001 in./in.
Ultimate Tensile Strength (ASTM D638)	5,800 psi
Ultimate Flexural Strength (ASTM D790)	7,650 psi
Elongation % (ASTM D 638)	2.4 %
Flexural Modulus (ASTM 790)	0.21 x 10 <sup>6</sup>

\*Dependent upon thickness of casting.

The above figures are averages and are not intended for specification purposes.

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