



BCC PRODUCTS, INC.

BLEHM PLASTICS

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

URETHANE CASTING SYSTEM

WHITE
BC8400
Urethane

BC8400 is an unfilled, low viscosity, quick setting two component urethane system. An easy to use 1 to 1 mix ratio (Part A/Part B), **BC8400** offers the user a 3 minute working time with parts demoldable in as little as 30 minutes. When properly cured, BC 8400 will exhibit high impact strength and yield thermoplastic-like parts. Some outstanding features include the following:

- *Mercury free
- *Moderate heat resistance
- *1 to 1 mix ratio
- *Turns white upon cure
- *Longer mold life
- *High impact strength
- *No objectionable odor
- *Excellent finishing properties
- *Thermoplastic appearance
- *More parts per day

Working Properties

Mix Ratio (Part A/Part B)	100 to 100 by wt. 100 to 100 by vol.
Viscosity (ASTM D 2393-71)	
Part A	64 cps
Part B	480 cps
Mixed	190 cps
Color	
Part A	Amber
Part B	Opaque
Gel Time (200 gms) ASTM D 2471-71	3 Minutes
Demold Time @ 77°F (25° C)	30 – 60 Minutes

Physical Properties

Specific Gravity (ASTM D 792-66)	1.09
Cu. in./lb.	25.4
Hardness Shore D ASTM D 2240-66	75 ± 3
Color (Cured)	White
Ultimate Tensile Strength (ASTM D 638)	5,326 psi
Elongation (%) ASTM D 638	13.1
Ultimate Flexural Strength ASTM D 790	8,770
Flexural Modulus ASTM 790	250,900
Impact Strength ASTM D 256 Izod Notched (ft. lbs./in.)	1.34
Deflection Temperature ASTM D 648	
7 days @ room temp.	145°F
24 hrs @ room temp. + 1 hr @ 150°F	166°F
Linear Shrinkage ASTM D 2566 (in./in.)	.0025

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