



BCC PRODUCTS, INC.

BLEHM PLASTICS

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

URETHANE CASTING SYSTEM

WHITE

BC8405

Urethane

BC8405 is an unfilled, low viscosity, quick setting two component urethane system. An easy to use 1 to 1 mix ratio (Part A/Part B), **BC8405** offers the user a reasonable working time with parts demoldable in as little as 2 hours. When properly cured, **BC 8405** 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 | 15 Minutes |
| Demold Time @ 77°F (25° C) | 2 – 4 Hours |

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) | 5,401 psi |
| Elongation (%) ASTM D 638 | 11.6 |
| Ultimate Flexural Strength ASTM D 790 | 9,011 |
| Flexural Modulus ASTM 790 | 264,890 |
| Impact Strength ASTM D 256 Izod Notched (ft. lbs./in.) | 1.32 |
| Deflection Temperature ASTM D 648 | 141°F |
| Linear Shrinkage ASTM D 2566 | 0.001 |

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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