



BCC PRODUCTS, INC.

BLEHM PLASTICS

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

URETHANE ELASTOMER

(Ultra Clear)

BC8782

Urethane

BC 8782 produces a high impact rigid 82 Shore D material that is commonly used to make clear or tinted castings of all kinds. When used at room temperature castings 1/8" thick or larger can be readily cast. Castings that are less than 1/8" thick generally require a mild post-cure. This system is not recommended for use with tin cure silicones.

Handling Properties

Mix Ratio (By weight)	
Resin Part A	100 parts by Weight
Curative Part B	85 parts by Weight
Mix Ratio (By Volume)	
Resin Part A	100 parts by Volume
Curative Part B	88 parts by Volume
Viscosity, Centipoise (cps) @ 77°F (Ratio by Volume)	
Viscosity, Part A	600
Viscosity, Part B	550
Mixed Viscosity	650
Color	
Resin Part A	Clear/Colorless
Curative Part B	Clear/Colorless
Work Life @ 75°F (mass dependent)	12-14 minutes
Demold Time @ 75°F	6-8 hours
Cure Schedule:	
	5-7 days at RT, or 16 hours at 150-180°F. See heat cure below. Product is sufficiently cured after one day, ambient, for general handling.

Cured Properties

Hardness Shore D, ASTM D 2240-68	82
Specific Gravity (gm/cc) Density	1.04
Cu. in. per pound	26.7
Color	Water Clear/Colorless
Tensile Strength (psi) ASTM 638-82	4,700
Elongation (%) ASTM D 638-82	7-10
Shrinkage (in./in.) ASTM D 2566-79	.0003
Tensile Modulus, 5% strain, ASTM D-790	>90,000
Heat Deflection Temp. °F (66 psi load)	165

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Heat Curing

Generally, for most applications, ambient temperature curing is adequate; however, maximum physical properties and heat resistance is obtained by post curing for 16 hours at 150°-180°f, or 6-8 hours at 180°-210°F. Parts may require some support during heat cure. A suggested cure schedule is: 3-5 days at room temperature (to minimize any softening during heating), followed by 4-6 hours at 130°-150°F, and an additional 16 hours at 160°-180°F. This cure schedule minimizes part distortion and shrinkage, while affording maximum toughness and heat sag resistance.

Product Uses

Prototype computer parts.
Models of all kinds.
Artwork components.
Architectural models.
Gears, wheels, fans.
Transportation cases.
Miniatures and movie props.

Product Highlights

Exceptional clarity.
Very high impact rigid material.
12-14 minute working time provides the option for large pours.
No odor.
Cures in most silicone rubber molds.
Good weatherability, non-yellowing.

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