



BCC PRODUCTS, INC.

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



BLEHM PLASTICS

SILICONE RTV RUBBER

(High Strength, Molding
(Potting, Encapsulating))

BC9020

Silicone

BC 9020 is a violet colored, two-component, flowable compound that regardless of thickness or confinement, cures at room temperature. The cured rubber is high strength and high tear with good elongation. In addition, BC9020 features low viscosity, low durometer and resistance to sulfur clays.

Application

BC 9020 is a mold making material designed for the manufacture of flexible molds. These rubber molds are recommended for the use in repetitive production of intricate shapes cast from epoxy or urethane resins. These molds are also used in the potting of electronic components and in protecting sensitive assemblies against thermal shock and vibration.

Instruction for Use

Temperatures above 80° F in the modeling and encapsulating area should be avoided to prevent premature expiration of pot life. BC9020 should be thoroughly stirred before mixing, since pigments settle during storage. Mixing containers should be clean and dry before use and then should be filled to 1/4 capacity to allow room for mixing and deaeration. It is recommended that separate tools be used for mixing the catalyst and the compound to avoid cross contamination.

BC 9020 compound is mixed with catalyst-BC 9020 in a 10:1 ratio by weight. Mixing may be done by hand with a spatula or by machine. When mixing by hand, material clinging to sides and bottom should be folded into main contents twice. When mixing is done with a power mixer, two fifteensecond cycles are generally sufficient for thorough mixing. Avoid prolonged mixing at high speeds as this will generate heat and decrease the pot life of the material.

Deaeration

Air entrapped during the mixing cycle must be removed to eliminate voids in the cured compound. Place the mixture in a vacuum of 29 inches of mercury. The mixture will expand to 3-5 times its original volume, crest and recede approximately to its original level. Continue the deaeration for an additional 1-2 minutes and the material will be ready to use.

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Pouring

Pour the silicone material in a continuous stream from approximately 3 inches above the pattern and allow to settle for 5 minutes.

Storage and Handling

BC9020 compound and catalyst-BC 9020 will remain useful for six (6) months from date of shipment when stored in their original unopened containers in a dry place at or below 80 F. Avoid contact of Catalyst-BC 9020 with acidic bases and oxidizing materials as such contact can generate flammable gas. Keep containers covered, since BC9020 is sensitive to moisture.

General Properties

BEFORE CURE

Appearance	Violet
Viscosity, 25° C, Poise	
Compound	70,000
Catalyst	100
Mixed	31,000
Work Time @ 25° C	1 Hour
Time for sufficient cure to be handled	8 hours @ room temp.
Time for 90% Cure	24 hours @ room temp.
Full Cure	an additional 1-2 days @ room temp.

AFTER CURE (7 days @ 25°C)

Specific Gravity @ 25°C	1.1
Cubic Inches/#	25.2
Lbs per cubic inch	0.04
Hardness, Shore A	20 - 25
Elongation %	500
Tensile Strength (psi)	600
Tear Strength, ppi	120
Curing Agent	Catalyst-9020
Mix Ratio	10 to 1 by wt.
Linear Shrinkage (%)	0.3 - 0.4

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