



BCC PRODUCTS, INC.

BLEHM PLASTICS

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

URETHANE CASTING SYSTEM

(Tan)

DP-11-90

DP-11-90 is an unfilled, low viscosity, quick setting two component urethane system. An easy to use 1 to 1 mix ratio (Part A/Part B), DP-11-90 offers the user a 3 minute working time with parts demoldable in as little as 30 minutes. When properly cured, DP-11-90 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 tan color upon cure
- * Longer mold life
- * High impact strength
- * No objectionable odor
- * Excellent finishing properties
- * Thermoplastic appearance
- * More parts per day

WORKING PROPERTIES

Ratio (Part A/Part B)	110 to 100 by wt. 100 to 100 by vol.
Viscosity (ASTM D 2393-71)	
Part A	176 cps
Part B	450 cps
Mixed	300 cps
Color	
Part A	Dark Amber
Part B	Opaque
Gel Time (200 gms) ASTM D 2471-71	3 Minutes
Demold time (@ 77 ⁰ F (25 ⁰ C)	30 - 60 Minutes

PHYSICAL PROPERTIES

Specific Gravity (ASTM D 792-66)	1.10
Cubic Inches Per Pound	25.2
Hardness (Shore D) ASTM D 2240-66	75±3
Color (Cured)	Tan
Linear Shrinkage (ASTM D 2566) in./in.	.0025
Heat Distortion Temperature	
@ 24 hr room temperature cure	145 ⁰ F
@ room temperature cure + 1 hr @ 150 ⁰ F	174 ⁰ F
@ room temperature cure + 1 hr @ 200 ⁰ F	190 ⁰ F
Elongation % (ASTM D638)	11.2
Flexural Modulus	296,200

Physical properties are based upon 100 to 100 mix ratio by weight.

2140 Earlywood Drive, P.O. Box 327, Franklin, IN 46131

Ph (317) 736-4090 Fax (317) 736-4872

Web: www.bccproducts.com & www.blehmplastics.com