



BCC PRODUCTS, INC.



BLEHM PLASTICS

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

BC 6250 ADHESIVE AND PATCH

COLOR AND CTE MATCHED ADHESIVE FOR HIGH TEMPERATURE EPOXY TOOLING BOARD

BCC Products BC6250 R/H is a use temperature, color and CTE matched adhesive especially formulated for bonding EB 6200 Blue High Temperature Epoxy Tooling Board.

Applications

BC6250 Adhesive is designed for bonding EB 6200 Blue High Temperature Board. BC 6250 can also be used as a patch material for this board.

Working Properties

Mix Ratio (Resin/Hardener)	100 to 14 by wt.
Gel Time (114 g. mass) @75°F	90 - 110 Minutes
Cure Schedule @ 75°F	12-18 Hours
Full Cure @ 75°F	7 Days

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

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EPOXY ADHESIVE

BC 6250

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Typical Properties

	VALUE	TEST METHOD
Color	Blue	Visual
Hardness, Shore D	72	ASTM D-2240
Density, g/cm ³ (lbs/ft ³)	0.76 (47)	ASTM D-792
Heat Deflection Temperature, °F	300	ASTM D-648
Glass Transition Temperature, °F	>325	ASTM D-3418
Coefficient of Thermal Expansion, in/in/°F	2.1 x 10 ⁻⁵	TMA
Izod Impact, Notched (Unnotched), ft-lbs/in	0.56 (1.05)	ASTM D-256
Tensile Strength, psi	4,400	ASTM D-638
Flexural Strength, psi	5,150	ASTM D-790
Flexural Modulus, psi	349,000	ASTM D-790
Compressive Strength, psi	4,800	ASTM D-695
Compressive Modulus, psi	342,000	ASTM D-695

Quart, gallon and pail kits available.

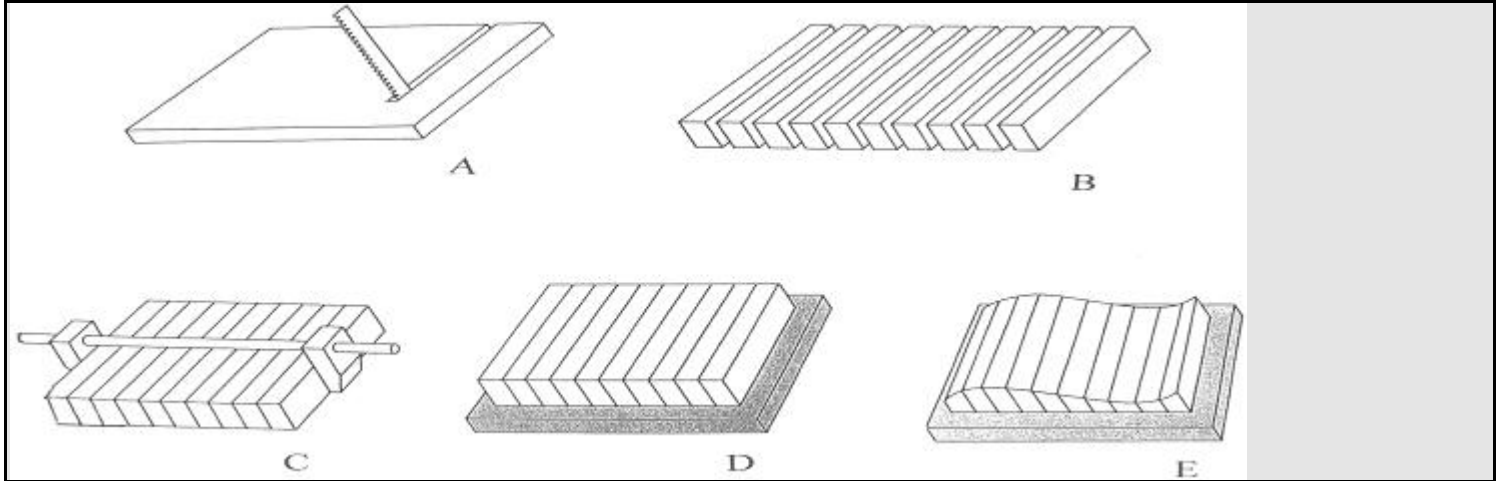
Application

Boards should be wet out on both sides of the stack. Boards should be held in position by light clamping or placing a weighted object over the entire top surface of the stack to ensure equal pressure throughout the board. Over-clamping will cause the adhesive to spread unevenly, which may result in stress build up in the board and lead to stress micro cracking and/or warping. Always allow adequate time for the adhesive to further machining or processing. Always use an adhesive that is capable of meeting the mechanical properties of the board. Precautions should be taken when post curing to ensure that the temperature is ramped up and down slowly. This will prevent thermal shock from occurring to the board and the adhesive, which will result in a poor bond and stress cracking in the board.

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Construction of EB6200 Blue Board Using BC 6250 Adhesive

- A) Sawing: Cut **EB6200 Blue** side to side on a band saw to form the required dimension. Use of carbide or diamond coated saw blades or cutting wheels is recommended.
- B) Bonding: Laminate the cut pieces together using **BC 6250** matched adhesive system. Apply adhesive to both sides of the glue joint.
- C) Clamping: Clamp the board together and cure overnight at room temperature. Excessive clamping pressure will induce stress into the board and produce negative results.

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. It is expressly understood and agreed that customer assumes and hereby expressly releases Bcc Products from all liability, in tort, contract or otherwise, incurred in connection with the use of our products, technical assistance and information