



**BCC PRODUCTS, INC.
PLASTICS**



BLEHM

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

Fast-Set Polyurethane Adhesive

(Black)

BC110

BC110 is a two-component, very fast setting, room temperature cure polyurethane adhesive system. This sand able adhesive system has an excellent adhesion to wide variety of surfaces.

Features:

- Fast setting time with convenient 1:1 mix ratio
- Excellent adhesion to wide variety of surfaces such as Aluminum, Stainless steel, ABS, PVC, Polyurethane, Composites, Thermoplastics, Thermosetting Plastics, Wood, Glass, Concrete without any use of primer.

Working Properties

	<u>Part A</u>	<u>Part B</u>	<u>Mixed</u>
Color	Beige	Black	Black
Viscosity @ 25 ⁰ C	30,000	30,000	30,000
Brookfield, cps			
Weight per Gallon	11	11	11
Mix Ratio by Volume			1:1
Mix Ratio by Weight			1:1
Working Time			60 – 100 seconds
Fixture Time			10 – 14 Minutes
Functional Cure			2 hours
Full Cure			24 hours
Service Temperature			-40 ⁰ F to 250 ⁰ F
Coverage per lb @ 1/4"			94 sq. inch per lb @

Typical Cured Properties

T-Peel Strength	65 – 75 Pli	ASTM D1876
Tensile Elongation	170%	ASTM D638
Shore Hardness	70D	ASTM D 2240
Dielectric Strength	350	volts/mil ASTM D 149
Cure Shrinkage	0.0020 in./in.	ASTM D 2566
Tear Resistance	450 Pli	ASTM D 624
Tensile Strength	2,850 psi	ASTM D 638

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Other Information

Lap Shear Strength after 7 days at 25 °C:

ABS to ABS	925 psi	Aluminum to Aluminum	2,650 psi
Steel to Steel	1975 psi	Concrete to Concrete	1945 psi
Glass to Glass	4050 psi	GBS to GBS	2550 psi
SMC to SMC	1280 psi	Galvanized Metal to Metal	2850 psi

Surface Preparation:

Clean surface by solvent-wiping any deposits of heavy grease, oil, dirt, or other contaminants. Surface can also be cleaned with industrial cleaning equipment such as vapor phase degreasers or hot aqueous baths. If working with metal, abrade or roughen the surface to significantly increase the microscopic bond area and increase the bond strength.

Mixing Procedure:

Proper homogenous mixing of resin and hardener is essential for the curing and development of stated strengths.

1. Attach cartridge to 50ml or 400ml manual or pneumatic dispensing systems.
2. Open tip.
3. Burp cartridge by squeezing out some material until both sides are uniform (ensures no air bubbles are present during mixing).
4. Attach mix nozzle to end of cartridge.
5. Apply to surface and attach other substrate quickly, as you have 2 minutes of working time to use the product. Substrates can be clamped with a bond line thickness as small as 0.007".

Storage: Store in cool, dry place.

Packaging:

Available in 50 ml syringe, 50 ml / 400 ml dispensing cartridge system. Bulk packing in 5 gallon and 55-gallon drum.

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.