



BCC PRODUCTS, INC.

BLEHM PLASTICS

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

POLYURETHANE ELASTOMER

(AMBER)

BC8640E

Urethane

BC8640E is an easy to use polyurethane elastomer that is suitable for many applications. Special product characteristics include: room temperature mixing and curing, excellent hydrolytic stability, produces durable products that are easily produced, does not contain MOCA, MDA or MDI.

BC8640E uses include:

- * molds for plaster and concrete
- * molds for epoxy, polyurethane and polyester castings or laminates
- * fabricating parts such as protective shipping pads or skins for creatures

Handling Properties

Mix Ratio:

Resin Part A	90 parts by Weight
Hardener Part B	100 parts by Weight
Initial Mixed Viscosity, 77° F (cps)	850

Color

Resin Part A	Faint yellow
Hardener Part B	Yellow

Work Life @ 77° F 30 minutes

Gel Time (180 gram mass) 45 minutes

Demold Time 12 to 16 hours @ room temperature

Demold times will advance with either pre-heating the Part A and Part B or by post curing. A post cure is most effective at 150° F.

Cure Schedule

Satisfactory cure is in general achieved in 24 hours.

Please note: After demolding it is recommended that this product be allowed to cure at ambient temperature conditions for a minimum of 5 – 7 days for development of full properties. Mold prep and releasing: When **BC8640E** is used to reproduce molds from plaster, wood or other porous substrates, it is recommended that they be sealed with sealer. Release agents may then be applied over the sealed surface. Prolonged direct exposure to sunlight can affect the surface of this product. Cover molds or other products when storing them outdoors. The cure will be inhibited if cast against a tin catalyzed silicone RTV.

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Cured Properties

Hardness, Shore A	40 ± 2
Specific Gravity (gm/cc) Density	1.03
Shrinkage (in./in. linear)	.0005
Tensile Strength (psi)	490
Ultimate Elongation (%)	800
Tear Strength (pli)	200

Mixing

Mix thoroughly being sure to scrape sides and corners of containers so no mixed material remains. Vacuum degassing is important in order to achieve a product free of air. To aid in the evacuation of air the use of a surface tension reducing agent is necessary.