



**BCC PRODUCTS, INC.**

**BLEHM PLASTICS**

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

## URETHANE ELASTOMER

(AMBER)

**BC8660E**

Urethane

**BC8660E** is a multi-purpose elastomer that can perform many functions. Special product characteristics are: excellent use for molds for casting of concrete and plaster, resists moisture absorption, does not contain MOCA, MDA, TDI or MDI, very easy to use and cures at room temperature.

### Handling Properties

#### Mix Ratio:

Resin Part A	100 parts by Weight
Hardener Part B	55 parts by Weight
Initial Mixed Viscosity, 77° F (cps)	2500

#### Color

Resin Part A	Clear
Hardener Part B	Amber

Work Life @ 77° F 25 minutes

Demold Time 8 - 14 hrs at room temperature  
4 hrs or less at elevated temperatures

#### Cure Schedule

1 day at ambient temperature for general use

After demolding it is recommended that this product be allowed to cure at ambient temperature conditions for a minimum of 3 days for development of full properties. Mold prep and releasing: When **BC8660E** 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.

**NOTE:** 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.

### Cured Properties

Hardness, Shore A	60+/-2A
Specific Gravity (gm/cc)	
Resin Part A	1.07
Hardener Part B	1.02
Cured Density, specific gravity (gm/cc)	1.05
Shrinkage (in./in. linear)	.001
Tensile Strength (psi)	1625
Ultimate Elongation (%)	700
Tear Strength (pli)	200

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