



BCC PRODUCTS, INC.

BLEHM PLASTICS

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

URETHANE ELASTOMER

(Amber)

BC8690E

Urethane

BC 8690E is a two-component urethane elastomer compound specifically designed for casting applications. This product is a safe, easy-to-handle, room temperature mixing and curing system that contains no TDI, MDA or MOCA. **BC 8690E** is insensitive to moisture during storage and normal handling; hence, this system will make dependably good void-free parts without the foaming problems that some conventional urethane systems exhibit. The low shrinkage, low viscosity, superior toughness, and excellent detail reproduction of **BC 8690E** makes this system ideal for general purpose castings and quality tooling operations.

Product Highlights

- Excellent for molds for casting of concrete and plaster
- Resists oil and moisture absorption
- Room temperature cure
- High tear strength and toughness
- Hardness/durability comparable to high grade vulcanized rubber

Product Uses

- Mold Fabrication
- Shock absorbent pads & liners
- Adhesive for high strength and resilient bonds
- Many types of urethane rubber parts

Working Properties

Mix Ratio:

Resin Part A	100 parts by weight
Curative Part B	55 parts by weight

Mix Ratio (Resin/Hardener):

1.85 to 1 by volume

Viscosity, Centipoise (cps) @ 75°F

Initial Mixed Viscosity (cps)	2500
-------------------------------	------

Work Life at 77°F (100 gm mass)

20 minutes

Gel Time (180 gm mass)

30 minutes

Demold Time:

4 - 6 hours

Cure Schedule:

Full cure at room temperature requires 3-5 days. Or post cure @ 150 °F - 180 °F for 4 - 6 hours.

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

URETHANE ELASTOMER

BC8690E

page 2

Physical Properties

Specific Gravity (gm/cc) density	1.07
Hardness, Shore A	85-90
Tensile Strength (psi)	2700
Shrinkage (in./in.)	.0025
Tear Strength (pli)	390
Elongation (%)	550
Displacement (cu. in./lb)	26

Mold Preparation and Mold Release

When **BC8690E** is used with plaster models, wood models, or other porous substrates, it is recommended that the substrate surfaces first be sealed. Release agents such as **BC87** Urethane Parting Wax (yellow) or **BC84** PVA Parting (green) may then be applied over the sealed surface.

Storage and Safety

Store in a dry, cool place. Unopened containers of **BC8690E** have a shelf life of 6 months when stored inside under normal conditions ($75^{\circ}\text{F} \pm 15^{\circ}\text{F}$). In order to prevent moisture contamination, once containers have been opened, they should be purged with dry nitrogen prior to replacing lids or caps. This material should be used in a well ventilated area. Avoid contact with skin using protective gloves as well as protective clothing. Always use approved safety glasses or goggles when handling this product. Note: Before using this product, please refer to the Material Safety Data Sheet.

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