



POLYTEK® DEVELOPMENT CORP.
BCC PRODUCTS, INC.

Product Technical Datasheet PolyPoxy® 5105 Laminating Epoxy System

PolyPoxy® 5105 is a clear, unfilled, low viscosity laminating system. This heat resistant resin exhibits excellent wet out, reasonable working time and may be used at room temperature without post-curing. For use above 150°F a post-cure may be required. PolyPoxy® 5105 can afford consistent use to 300°F if required. Does not contain VCHD or MDA. Useful for:

- *Constructing vacuum form tools
- *Injection and compression molds
- *RTM and RIM molds
- *Matched dies

Working Properties

Mix Ratio (Resin/Hardener)	100 to 17 by wt. 100 to 20 by vol.
Viscosity (Brookfield @ 75°F)	2,000 cps
Pot Life (1 lb. mass) 75°F	55 Minutes

Cured Schedule

PolyPoxy® 5105 can be removed from the mold after allowing to set 24 hours @ room temperature (75°F). Post cure for applications requiring temperatures above 150°F can be accomplished in an oven or in use by a gradual heat rise; 2 hours @ 150°F plus 2 hours @ 250°F plus 2 hours at 300°F.

Physical Properties

Specific Gravity (gms/cc)	1.15
Weight/cu.in. (lbs.)	0.041
Hardness (Shore D) @ 75°F	90
Shrinkage (in./in.)	---
*Ultimate Tensile Strength (psi)	29,000
*Ultimate Flexural Strength (psi)	34,000
*Ultimate Compressive Strength (psi)	58,600
*Thermal Coefficient of Expansion (in./in./°F) x 10 ⁻⁵	0.90
HDT (°F) 264 psi	293

*Properties obtained from a 10 oz. glass cloth laminate. Not intended for use in preparing specifications.

DISCLAIMER: The information in this bulletin and otherwise provided by Polytek® Development Corp. is considered accurate. However, no warranty is expressed or implied regarding the accuracy of the data, the results to be obtained by the use thereof, or that any such use will not infringe any patent. Before using, the user shall determine the suitability of the product for the intended use and user assumes all risk and liability whatsoever in connection therewith.

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