



POLYTEK® DEVELOPMENT CORP.
BCC PRODUCTS, INC.

Technical Data Sheet

BC-7009-2 Epoxy Casting Black Hardener

BC-7009-2 is an iron filled, low-cost mass casting system. Recommended for use in casting a minimum of two inches and a maximum of six inches in non-conductive molds. Thicknesses to nine inches in metal or conductive-type molds can successfully be achieved as well. Ideal for stretch forms, patterns, dies, molds, duplications, prototypes, etc.

Working Properties

Mix Ratio (Resin/Hardener)	12 to 1 by wt. 4.5 to 1 by vol.
Viscosity (Brookfield @ 75°F) Mixed	35,000 cps
Pot Life (15 lb. mass) @75°F	240 Minutes
Cure Schedule @ 75°F	24 Hours

Physical Properties

Specific Gravity (gms/cc)	2.27
Weight/cu.in. (lbs.)	0.082
Hardness (Shore D) @ 75°F	85
Ultimate Tensile Strength (psi)	5,400
Ultimate Flexural Strength (psi)	7,400
Ultimate Compressive Strength (psi)	12,600
Heat Distortion Temperature (°F)	123
Flexural Modulus (psi)	0.81 x 10 ⁶
Shrinkage	0.0009 in./in.
Machinability	Good

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