



POLYTEK® DEVELOPMENT CORP.
BCC PRODUCTS, INC.

Product Technical Datasheet PolyPoxy® 7136-2 Epoxy Casting System

PolyPoxy® 7136-2 is an aluminum filled thick section casting system with heat resistance to 300°F. May be cast to a thickness of 2 inches in non-conductive molds, 3 inches in conductive molds and thicker sections with the addition of bulk fill. For service temperature above 150°F a post-cure is required. Does not contain VCHD or MDA. See cure schedule.

Working Properties

Mix Ratio (Resin/Hardener)	100 to 9 by wt. 100 to 16 by vol.
Viscosity (Brookfield @ 75°F) Mixed	13,500 cps
Pot Life (1 lb. mass) @ 75°F	180 Minutes

Cure Schedule

PolyPoxy® 7136-2 can be removed from the mold after allowing to set 24 hours at 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 @ 300°F.

Physical Properties

Specific Gravity (gms/cc)	1.67
Weight/cu.in. (lbs.)	0.060
Cubic in./lb.	16.6
Hardness (Shore D) @ 75°F	90
Ultimate Tensile Strength (psi)	7,900
Ultimate Flexural Strength (psi)	8,900
Ultimate Compressive Strength (psi)	27,600
Heat Distortion Point (264 psi) °F	314
Shrinkage, Linear (ASTM-D-2566-69)	0.001 in./in.
Thermal Coefficient of Expansion (in./in. °F) x 10 ⁻⁵	2.02

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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