



POLYTEK® DEVELOPMENT CORP.  
BCC PRODUCTS, INC.

## Product Technical Datasheet PolyPoxy® 7136 Epoxy Casting System

**PolyPoxy® 7136** is a gray, low toxicity, aluminum filled, epoxy casting resin. This heat resistant system may be used at room temperature without post-curing. May be cast to a thickness of 3/4 inch in non-conductive molds. For use above 150°F a post-cure is required. This product was engineered to replace VCHD and MDA systems while retaining excellent heat resistance and low viscosity.

PolyPoxy® 7136 is designed for consistent use up to 300°F. Useful for:

- \*Heat resistant tooling
- \*Constructing vacuum form tools
- \*Injection and compression molds
- \*RTM and RIM molds
- \*Matched dies

### Working Properties

Mix Ratio (Resin/Hardener)	100 to 7 by wt.
	100 to 12 by vol.
Viscosity (Brookfield @ 75°F) Mixed	15,000 cps
Pot Life (1 lb. mass) @ 75°F	85 Minutes

### Cure Schedule

PolyPoxy® 7136 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)	1.69
Weight/cu.in. (lbs.)	0.061
Hardness (Shore D) @ 75°F	90
Ultimate Tensile Strength (psi)	7,800
Ultimate Flexural Strength (psi)	8,600
Ultimate Compressive Strength (psi)	29,000
Heat Distortion Point (264 psi) °F	305
Shrinkage, Linear (ASTM-D-2566-69)	0.0011 in./in.
Thermal Coefficient of Expansion (in./in. °F) x 10 <sup>-5</sup>	1.9

**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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