BCC Products, Inc.
Blehm Plastics
Product selector guide

BCC Products, Inc./Blehm Plastics
2140 Earlywood Dr.
Franklin, IN 46131
800.556.0067
www.bccproducts.com
www.blehmplastics.com
At BCC we are dedicated to meeting your toughest tooling demands by offering superior innovative plastic compounds, along with the unique ability to custom formulate polymer systems for specific applications. For your application requirements, BCC offers a choice of epoxy formulated systems, urethane reproduction plastics and silicone mold making compounds, polyester repair materials and modeling tooling CNC boards/planks. As a single source for all your tooling needs, we are well equipped to offer the complete product solution.

As one of the most respected suppliers in the plastics industry, BCC Products, Inc. has served the industry for over 30 years specializing in the automotive, aerospace, foundry and marine industries with such well known products such as Proto-Kast, Kwik-Kast, Lik-Wood, Metal-Kast and Slo-Kast.

At BCC we understand the importance of commitment to customer satisfaction, and we strive to optimize your need for timeliness, quality and value. Our technical assistance department is always available to offer support in the use of our products.

Sincerely,
Roger Brunette, Jr.
President
BCC Products, Inc.
Blehm Plastics

BCC Products, Inc. / Blehm Plastics are leaders in plastic tooling technology. Visit us on-line at www.bccproducts.com and www.blehmplastics.com

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# Polyester Filler Pastes

**BC4544**
Carvable wood filler, the most amazing quickset filler ever developed for the pattern and model making industry. A lightweight thixotropic paste which when cured, exhibits unsurpassed carvability without dulling tools. Ideal for engineering changes as well as filling and buildups of patterns and models. Other uses include marine and furniture repairs. Available in mahogany and pine coloring.

**Features:**
- Mix ratio: 100:1 or 100:2
- Pot life: 6-12 minutes
- Viscosity: Thixotropic Paste
- Cure schedule: 20-60 minutes

**BC4553**
Instant Buildup Material, designed for repairing plastic surfaces and models. Recommended for SMC and FRP parts. Vacuum forming molds and a variety of surfaces. Produces a hard, strong chip resistant and tack free surface.

**Features:**
- Mix ratio: 100:1 or 100:2
- Pot life: 5-10 minutes
- Viscosity: Thixotropic Paste
- Cure schedule: 20-60 minutes

**BC4558**
FAR25.853 approved quickset repair putty ideal for aircraft repairs. Perfect for fast repairs in damaged non-critical areas. Able to be used in core filling of honeycomb panels that requires self-extinguishing specifications. BC 4558 offers extreme light bodied consistency, good vertical sag resistance and tack-free cure.

**Features:**
- Mix ratio: 100:2
- Pot life: 6-10 minutes
- Viscosity: Thixotropic Paste
- Cure schedule: 30 minutes
- Approvals: FAR 25.853, HLT-15

**BC4570**
A multi-purpose two part filler paste developed for making quick repairs to a variety of substrates where service temperature exceeds 400°F (204°C). It exhibits good adhesion to SMC, FRP, hi-heat Epoxy molds, many metals, etc. BC 4570 can be readily shaped by filing, grinding or machining after cure. Excellent for under the waterline repairs and fairing compound applications.

**Features:**
- Mix ratio: 100:1 or 100:2
- Pot life: 6-8 minutes
- Viscosity: Thixotropic Paste
- Cure schedule: 15-20 minutes
- Heat distortion Temp: 260°F (127°C)
- Approvals: Boeing XBMS 5-136

**BC4578**
Model board filler, developed for quick setting easy to use polyester. Developed specifically for repairs to MB 3000 modeling board. Its light weight characteristics and tack free cure makes for ease of finishing with simple wood working tools and NC systems.

**Features:**
- Mix ratio: 100:1 or 100:2
- Pot life: 5-10 minutes
- Viscosity: Thixotropic Paste
- Cure schedule: 45-75 minutes

All BCC polyester filler pastes are available in quarts, gallons and 3 gallon dispenser cartridge.

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<tr>
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<th>Color</th>
<th>Mix Ratio</th>
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<th>Cure Schedule (min)</th>
<th>Temperature (°F)</th>
<th>Viscosity</th>
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<td>Gray, White, Pine Mahogany</td>
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<tr>
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<td>Mahogany</td>
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<td>5-10</td>
<td>45-75</td>
<td>-</td>
<td>Thixotropic paste</td>
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</tbody>
</table>

Cream Hardener
A one part harding agent for polyester fillers. Available in 1oz and 4oz tubes. Color: White

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**POLYURETHANE MODELING/TOOLING BOARDS**

**MB3000**  
Model and Tooling Plank  
MB 3000 is a dense, highly machineable, dimensionally stable tooling plank for today’s CNC machining applications. As an advancement over similar products on the market, MB 3000 yields low dust emission during machining, less abrasiveness to CNC cutters, and affords the user a highly defined surface finish.

MB3000 has these great qualities:  
* Excellent machinability  
* Low dust emission  
* No shrinkage  
* Low moisture absorption  
* No grain  
* Excellent surface finish

**Features:**  
Density (lbs/ft³; gms/cm³): 45/72  
Hardness: 65D  
Tg (°F): 206  
Heat Distortion (°F): 179  
CTE (in/in/°F): 58.21x10^-6  
Color: Mahogany (Brown)  
Sizes: 2”-4”x16”x60” and 1”-4”x24”x60”*  
Adhesive: DP-11-88

**MB3500**  
Fixture Plank  
BCC Products now offers a revolutionary state-of-the-art machinable fixture plank for today’s demanding tooling requirements. MB 3500 is an extremely tough, high impact Urethane Plank, that can replace aluminum and other metals for many foundry applications.

MB3500 has these great qualities:  
* Excellent machinability  
* Low dust emission, mostly shavings  
* No shrinkage  
* Excellent impact and wear resistance  
* Excellent surface detail reproduction  
* Excellent surface finish

**Features:**  
Density (lbs/ft³; gms/cm³): 49/77  
Hardness: 73D  
Tg (°F): 215  
Heat Distortion (°F): 200  
CTE (in/in/°F): 29.00x10^-6  
Color: Lt. Gray  
Sizes: 2”-4”x16”x60” and 1”-6”x24”x60”*  
Adhesive: BC5003 Clear

**MB4000**  
Foundry Plank  
BCC Products now offers a revolutionary state-of-the-art machineable foundry plank for today’s demanding tooling requirements. MB 4000 Red is an extremely tough, high impact Urethane Plank, that can replace aluminum and other metals for many foundry applications.

MB4000 has these great qualities:  
* Excellent machinability  
* Low dust emission, mostly shavings  
* No shrinkage  
* Excellent impact and wear resistance  
* Excellent surface detail reproduction  
* Excellent surface finish  
* Polishable to a high gloss

**Features:**  
Density (lbs/ft³; gms/cm³): 71/1.14  
Hardness: 86D  
Tg (°F): 240  
Heat Distortion (°F): 214  
CTE (in/in/°F): 35.60x10^-6  
Color: Red  
Sizes: 2”-4”x16”x60” and 1”-6”x24”x60”*  
Repair material: DP-11-75  
Adhesive: BC5003 Red

**MB5000**  
High Density Tooling Plank  
BCC Products now offers a revolutionary state-of-the-art machinable high density board for today’s demanding tooling requirements. MB 5000 is an extremely tough, high impact Urethane Plank, that can be used for metal forming as well as nickel plating mandrels.

MB5000 has these great qualities:  
* Excellent machinability  
* Low dust emission, mostly shavings  
* No shrinkage  
* Excellent impact and wear resistance  
* Excellent surface detail reproduction  
* Excellent surface finish

**Features:**  
Density (lbs/ft³; gms/cm³): 100/1.6  
Hardness: 88D +2  
Heat Distortion (°F): 195  
Tg (°F): 215  
CTE (in/in/°F): 22.9x10^-6  
Color: White  
Sizes: 2”-4”x16”x60” and 2”-4”x24”x60”*  
Adhesive: BC5003 Clear

**MB8250**  
Aluminum Tooling Plank  
BCC Products now offers a truly metal-like machineable modeling plank for today’s demanding applications. MB 8250 is an aluminum filled product that is dimensionally stable and exhibits unsurpassed machinable properties. With the BC 8250 tooling plank you can see in some applications a significant savings on billet aluminum tooling materials.

MB8250 has these great qualities:  
* Excellent machineability  
* Low dust emission  
* No shrinkage  
* Low moisture absorption  
* Excellent surface detail reproduction  
* Excellent surface finish

**Features:**  
Density (lbs/ft³; gms/cm³): 100/1.6  
Hardness: 85D  
Heat Distortion (°F): 175  
CTE (in/in/°F): 39x10^-6  
Color: Dark Gray  
Sizes: 2”x3”x16”x60”  
Adhesive: BC5003 Clear

*Note: Adhesive may be required for certain applications.*

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All BCC Model and Tooling Boards create shavings when cutting saving on equipment costs and clean-up time.
EPOXY TOOLING BOARDS

BCC Products, Inc./Blehm Plastics is proud to announce the newest product to our tooling board line.

**Epoxy Tooling Boards**

Built to the exacting specifications BCC is known for, these New Epoxy Tooling boards will quickly become your favorite.

**EB6100**

(MEDIUM TEMPERATURE)

BCC Products EB6100 is a “grain-free” intermediate temperature epoxy modeling material known for its superior surface finish, dimensional stability and its ability to maintain tolerances even after being subjected to temperature variations. It is recommended for tooling use up to 250°F.

Features:
- Density (lbs/ft³; gms/cm³): 42/0.67
- Hardness: 68D
- Heat Deflection (°F): 250
- Tg (°F): 290
- CTE (in/in/°F): 18x10⁻⁶
- Color: Blue
- Sizes: 2", 4", 6"x24"x60"*
- Adhesive: BC5105 Clear

**EB6200**

(HIGH TEMPERATURE)

BCC Products EB6200 is a “grain-free” elevated temperature epoxy modeling material known for its superior surface finish, dimensional stability and its ability to maintain tolerances even after being subjected to temperature variations. The EB6200 has excellent dimensional stability results from its low coefficient of thermal expansion and its high glass transition temperature.

Features:
- Density (lbs/ft³; gms/cm³): 47/0.76
- Hardness: 72D
- Heat Deflection (°F): 300
- Tg (°F): >325
- CTE (in/in/°F): 21x10⁻⁶
- Color: Brown
- Sizes: 2", 4", 6"x24"x60"*
- Adhesive: BC5105 Clear

**EB6300**

(ROOM TEMPERATURE)

BCC Products EB6300 is a “grain-free” epoxy modeling material known for its superior surface finish, dimensional stability and its ability to maintain tolerances even after being subjected to temperature variations.

Features:
- Density (lbs/ft³; gms/cm³): 39/0.63
- Hardness: 68D (+/- 3)
- Heat Deflection (°F): 195
- Tg (°F): 215
- CTE (in/in/°F): 26x10⁻⁶
- Color: Tan
- Sizes: 2", 4", 6"x24"x60"*
- Adhesive: BC5003 Clear

**BC5003**

BC 5003 is a medium viscosity, unfiled laminating system. It is a room temperature curing resin with a relatively short pot life. BC 5003 is also considered an excellent general purpose adhesive for in-shop use. Recommended for use in gluing up BCC’s tooling plank series.

Features:
- Mix ratio: 100:20 by wt.
- Mix ratio: 100:22 by vol.
- Pot life: 14-15 minutes
- Viscosity (Mixed) @ 75°F: 3,500cps
- Cure schedule: 6-8 hours
- Color: Clear for all boards
- Red for MB4000

**Foundry Plank Repair Paste**

**DP-11-75**

(MB4000 Repair Paste)

DP-11-75 is a two component medium viscosity urethane patch system. A hybrid product which was designed specifically for making quick responsive repairs/buildups to the MB 4000 Foundry Plank. DP-11-75 is exceptionally tough, highly machinable after cure, and exhibits superior properties similar to MB 4000.

Features:
- Mix ratio: 1:1 by vol.
- Viscosity (Mixed): 1,400cps
- Pot Life: 1.5 minutes
- Cure time: 20-30 minutes
- Color: Red
- Packaging: 50ml tubes

BCC Products, Inc./Blehm Plastics is proud to announce the newest product to our tooling board line. Epoxy Tooling Boards

Built to the exacting specifications BCC is known for, these New Epoxy Tooling boards will quickly become your favorite.

**Epoxy Tooling Boards**

**EB6100**

(MEDIUM TEMPERATURE)

BCC Products EB6100 is a “grain-free” intermediate temperature epoxy modeling material known for its superior surface finish, dimensional stability and its ability to maintain tolerances even after being subjected to temperature variations. It is recommended for tooling use up to 250°F.

Features:
- Density (lbs/ft³; gms/cm³): 42/0.67
- Hardness: 68D
- Heat Deflection (°F): 250
- Tg (°F): 290
- CTE (in/in/°F): 18x10⁻⁶
- Color: Blue
- Sizes: 2", 4", 6"x24"x60"*
- Adhesive: BC5105 Clear

**EB6200**

(HIGH TEMPERATURE)

BCC Products EB6200 is a “grain-free” elevated temperature epoxy modeling material known for its superior surface finish, dimensional stability and its ability to maintain tolerances even after being subjected to temperature variations. The EB6200 has excellent dimensional stability results from its low coefficient of thermal expansion and its high glass transition temperature.

Features:
- Density (lbs/ft³; gms/cm³): 47/0.76
- Hardness: 72D
- Heat Deflection (°F): 300
- Tg (°F): >325
- CTE (in/in/°F): 21x10⁻⁶
- Color: Brown
- Sizes: 2", 4", 6"x24"x60"*
- Adhesive: BC5105 Clear

**EB6300**

(ROOM TEMPERATURE)

BCC Products EB6300 is a “grain-free” epoxy modeling material known for its superior surface finish, dimensional stability and its ability to maintain tolerances even after being subjected to temperature variations.

Features:
- Density (lbs/ft³; gms/cm³): 39/0.63
- Hardness: 68D (+/- 3)
- Heat Deflection (°F): 195
- Tg (°F): 215
- CTE (in/in/°F): 26x10⁻⁶
- Color: Tan
- Sizes: 2", 4", 6"x24"x60"*
- Adhesive: BC5003 Clear

**BC5003**

BC 5003 is a medium viscosity, unfiled laminating system. It is a room temperature curing resin with a relatively short pot life. BC 5003 is also considered an excellent general purpose adhesive for in-shop use. Recommended for use in gluing up BCC’s tooling plank series.

Features:
- Mix ratio: 100:20 by wt.
- Mix ratio: 100:22 by vol.
- Pot life: 14-15 minutes
- Viscosity (Mixed) @ 75°F: 3,500cps
- Cure schedule: 6-8 hours
- Color: Clear for all boards
- Red for MB4000

**Foundry Plank Repair Paste**

**DP-11-75**

(MB4000 Repair Paste)

DP-11-75 is a two component medium viscosity urethane patch system. A hybrid product which was designed specifically for making quick responsive repairs/buildups to the MB 4000 Foundry Plank. DP-11-75 is exceptionally tough, highly machinable after cure, and exhibits superior properties similar to MB 4000.

Features:
- Mix ratio: 1:1 by vol.
- Viscosity (Mixed): 1,400cps
- Pot Life: 1.5 minutes
- Cure time: 20-30 minutes
- Color: Red
- Packaging: 50ml tubes

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Epoxy Laminating Resins

BC5003
BC 5003 is a medium viscosity, unfilled laminating system. It is a room temperature curing resin with a relatively short pot life. BC 5003 is also considered an excellent general purpose adhesive for in-shop use. Recommended for use in gluing up BCC’s Tooling Board Series.

Features:
- Mix ratio: 100:20 by wt.
- Mix ratio: 100:22 by vol.
- Pot life: 14-15 minutes
- Viscosity (Mixed)@ 75°F: 3,500 cps
- Cure schedule: 6-8 hours
- Color: Clear or Red

BC5008-2
BC 5008-2 is a very low viscosity, modified, unfilled, room temperature curing, general purpose resin system. BC 5008-2 is a clear, amber, medium pot life material, with heat resistance to 175°F. BC 5008-2 is considered an excellent general purpose adhesive for in-shop use and will function as a laminating system for horizontal surfaces.

Features:
- Mix ratio: 100:25 by wt.
- Mix ratio: 100:26 by vol.
- Pot life: 25-30 minutes
- Viscosity (Mixed)@ 75°F: 500 cps
- Cure schedule: 8-12 hours
- Color: Translucent Amber

BC5010
BC 5010 is a high quality, low viscosity room temperature curing laminating resin. A Safety System for the production of a variety of dimensionally stable fiberglass tools. BC 5010 features low odor and rapid “wet-out” with no vertical drain off. An excellent general purpose laminating resin to meet the tooling requirements for automotive, aircraft and foundry.

Features:
- Mix ratio: 100:16 by wt.
- Mix ratio: 100:18 by vol.
- Pot life: 60 minutes
- Viscosity (Mixed)@ 75°F: 3,600 cps
- Cure schedule: 24 hours
- Color: Gray

BC5105
BC 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. BC 5105 can afford consistent use to 300°F if required. Excellent for carbon fiber laminating.

Does not contain VCHD or MDA. Useful for:
- Constructing vacuum form tools
- Injection and compression molds
- RTM and RIM molds
- Matched dies

Features:
- Mix ratio: 100:17 by wt.
- Mix ratio: 100:20 by vol.
- Pot life: 55 minutes
- Viscosity (Mixed)@ 75°F: 2,000 cps
- Cure schedule: 16-24 hours
- Color: Clear

BE290
BE 290 is a low viscosity, medium pot life, room temperature laminating system. BE 290 features low odor, reduced toxicity and adequate working life for constructing medium and large fabricated tools.

Features:
- Mix ratio: 100:33 by wt.
- Mix ratio: 100:40 by vol.
- Pot life: 65-70 minutes
- Viscosity (Mixed)@ 75°F: 2,700 cps
- Cure schedule: 24 hours
- Color: Clear

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<th>Product</th>
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<th>Mix ratio (by volume)</th>
<th>Pot Life (minutes)</th>
<th>Viscosity (cps) (mixed @ 75°F)</th>
<th>Cure Schedule (hours)</th>
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<td>2,700</td>
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**BC6004**

**Epoxy Surface Coat**

BC 6004 is a white thixotropic epoxy surface coat that has the ability to cure and bond to freshly poured wet plaster. This formulated resin compound can be applied with a brush or troweled to a thickness of 1/8" or less on vertical surfaces or over sharp radii without sag or fear of run-off. BC 6004 features moderate heat resistance and tracing hardness.

Features:
- Mix ratio: 100:8 by wt.
- Mix ratio: 100:14 by vol.
- Pot life: 15-20 minutes
- Viscosity (Mixed)@ 75F: Thixotropic paste
- Cure schedule: 8-12 hour
- Color: White

**BC6060**

**Epoxy Surface Coat**

BC 6060 is a blue epoxy, abrasion resistant surfacing resin. Commonly referred to as “die surface” material, this system may be applied by brush or if preferred, cast in thin sections to a maximum of ½”. Ideally suited for a variety of applications, BC 6060 is recommended for dies, foundry pattern and core boxes, router, trim and inspection fixtures.

Features:
- Mix ratio: 100:9 by wt.
- Mix ratio: 100:15 by vol.
- Pot life: 30-35 minutes
- Viscosity (Mixed)@ 77F: 25,000
- Cure schedule: 12-16 hours
- Color: Blue

**BC6126**

**Epoxy Surface Coat**

BC 6126 is a gray, low toxicity, aluminum filled, epoxy surfacing coat. This thixotropic resin system provides excellent surface duplication along with vertical coverage to 1/16 inch thickness. This heat resistant system may be used at room temperature without post-curing. For use above 150°F a post-cure is required. BC 6126 was engineered to replace VCHD and MDA systems while retaining excellent heat resistance. It is designed for consistent use up to 300°F.

BC 6126 was developed for:
- Constructing vacuum form tools
- RTM and RIM molds
- Injection and compression molds
- Matched dies

Features:
- Mix ratio: 100:7 by wt.
- Mix ratio: 100:15 by vol.
- Pot life: 45 minutes
- Viscosity (Mixed)@ 77F: Thixotropic paste
- Cure schedule: See Tech Datasheet
- Color: Black

**BC6128**

**Epoxy Surface Coat**

BC 6128 is a black, non-staining, silicon carbide filled, “die surface” surfacing resin. This thixotropic resin system provides excellent surface duplication along with good vertical coverage. Extended mold life due to superior wear resistance and hardness are the major benefits derived from its use. This heat resistant system may be used at room temperature without post-curing. For use above 150º F a post-cure is required. BC6128 can afford consistent use to 300º F if required. Does not contain VCHD or MDA.

Features:
- Mix ratio: 100:7 by wt.
- Mix ratio: 100:13 by vol.
- Pot life: 35-45 minutes
- Viscosity (Mixed)@ 75F: Thixotropic paste
- Cure schedule: See Tech Datasheet
- Color: Black

**BC8880**

**Polyurethane Elastomer Surface Coat**

BC8880 is a two-part urethane gel coat which exhibits excellent handling characteristics and very low moisture sensitivity. Its characteristics include a high modulus and a high hardness. It is a brushable room temperature curing urethane, which finds many general purpose applications such as foundry patterns, cure box liners, and abrasion resistant pads and bumpers. It may also be used as a urethane adhesive.

Features:
- Mix ratio: 100:60 by wt.
- Pot life: 12-15 minutes
- Viscosity (Mixed): Thixotropic
- Demold time: 8-12 hours
- Hardness (shore): 60D +3
- Color: Available in Amber, Black or Red

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**Product Mix Ratio (by weight)**

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<th>Product</th>
<th>Mix Ratio (by weight)</th>
<th>Mix ratio (by volume)</th>
<th>Pot Life (minutes)</th>
<th>Viscosity (cps) (mixed @ 75°F)</th>
<th>Cure Schedule (hours)</th>
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<td>Thixotropic Paste</td>
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<td>Black</td>
</tr>
<tr>
<td>BC8880</td>
<td>100:60</td>
<td>-</td>
<td>12-15</td>
<td>Thixotropic</td>
<td>8-12</td>
<td>Amber, Black or Red</td>
</tr>
</tbody>
</table>
Epoxy Casting Resins

**BC7009-1**
BC 7009-1 is an iron filled, low-cost mass casting system. Thicknesses up to two inches in non-conductive molds, and four inches in conductive molds can be achieved without foaming or yielding excessive shrinkage. Ideal for stretch forms, patterns, dies, molds, duplications, prototypes, etc.

Features:
- Mix ratio: 100:10 by wt.
- Mix ratio: 100:26 by vol.
- Pot life: 90 minutes
- Viscosity (Mixed)@ 75°F: 20,000
- Cure schedule: Overnight
- Color: Black

**BC7009-2**
BC 7009-2 is an iron oxide 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.

Features:
- Mix ratio: 100:8 by wt.
- Mix ratio: 100:22 by vol.
- Pot life: 4 hours
- Viscosity (Mixed)@ 77°F: 35,000
- Cure schedule: 24 hours
- Color: Black

**BC7020**
Backfill System
BC 7020 is a lightweight two component epoxy backfill system. Unlike BC 7010, the filler portion is pre-blended into the resin and hardener components for easier handling, thus simplifying the mixing process. BC 7020 is ideally suited for foundry applications involving mold and core construction.

BC 7020 features the following advantages:
- Low cost
- Simple mix ratio
- Long pot life
- Machineable
- Low shrinkage
- Color change to insure complete mix

Features:
- Mix ratio: 100:100 by wt.
- Pot life: 2-3 hours
- Viscosity (Mixed)@ 75°F: Paste
- Cure schedule: 24 hours
- Color: Green

**HPX-850**
Backfill System
HPX-850 is a light weight, heat resistant, two component epoxy backfill system. Like BC 7020, the filler portion is pre-blended into the resin and hardener components for easier handling, thus simplifying the mixing process. HPX-850 features advantages such as low cost, long pot life, machineability, and low shrinkage. HPX-850 is ideally suited for numerous applications involving mold and core construction.

Features:
- Mix ratio: 100:16 by wt.
- Pot life: 2-2.5 hours
- Viscosity (Mixed)@ 75°F: Paste
- Cure schedule: See Tech Datasheet
- Color: Gray

<table>
<thead>
<tr>
<th>Product</th>
<th>Mix Ratio (by weight)</th>
<th>Mix Ratio (by volume)</th>
<th>Pot Life (minutes)</th>
<th>Viscosity (cps) (mixed @75°F)</th>
<th>Color</th>
</tr>
</thead>
<tbody>
<tr>
<td>BC7009-1</td>
<td>100:10</td>
<td>100:26</td>
<td>90</td>
<td>20,000</td>
<td>Black</td>
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<tr>
<td>BC7009-2</td>
<td>100:8</td>
<td>100:22</td>
<td>240</td>
<td>35,000</td>
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<tr>
<td>BC7020</td>
<td>100:100</td>
<td>-</td>
<td>120-180</td>
<td>Paste</td>
<td>Green</td>
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<tr>
<td>HPX-850</td>
<td>100:16</td>
<td>-</td>
<td>120-150</td>
<td>Paste</td>
<td>Gray</td>
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<tr>
<td>BC7053</td>
<td>100:5</td>
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<td>55-60</td>
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<tr>
<td>BC7062-1</td>
<td>100:8</td>
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<td>50</td>
<td>5,400</td>
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<tr>
<td>BC7062-2</td>
<td>100:11</td>
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<td>7,000</td>
<td>Aluminum</td>
</tr>
<tr>
<td>BC7062-3</td>
<td>100:16</td>
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<td>240</td>
<td>3,800</td>
<td>Aluminum</td>
</tr>
<tr>
<td>BC7136</td>
<td>100:7</td>
<td>100:12</td>
<td>85</td>
<td>15,000</td>
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<td>BC7136-2</td>
<td>100:9</td>
<td>100:16</td>
<td>180</td>
<td>13,500</td>
<td>Grey</td>
</tr>
</tbody>
</table>

**BC7020**
Backfill System
BC 7020 is a lightweight two component epoxy backfill system. Unlike BC 7010, the filler portion is pre-blended into the resin and hardener components for easier handling, thus simplifying the mixing process. BC 7020 is ideally suited for foundry applications involving mold and core construction.

BC 7020 features the following advantages:
- Low cost
- Simple mix ratio
- Long pot life
- Machineable
- Low shrinkage
- Color change to insure complete mix

Features:
- Mix ratio: 100:100 by wt.
- Pot life: 2-3 hours
- Viscosity (Mixed)@ 75°F: Paste
- Cure schedule: 24 hours
- Color: Green

**BC7053**
BC 7053 is an iron filled epoxy casting system. This system is a high iron content material that provides unsurpassed wear resistance. BC7053 was designed for use in constructing core boxes, holding and trimming fixtures, foundry patterns, etc.

Features:
- Mix ratio: 100:5 by wt.
- Mix ratio: 100:6.5 by vol.
- Pot life: 55-60 minutes
- Viscosity (Mixed)@ 75°F: 10,000 cps
- Cure schedule: 12-18 hours
- Final cure: 7 days
- Color: Black

**BC7062-1**
BC 7062-1 are aluminum filled, low viscosity epoxy mass casting resins. These room temperature cure systems allow the user choice thicknesses of 1/8 inch to a maximum of 3/4 inches without foaming or yielding excessive shrinkage. Casting thicknesses may be increased by incorporating aluminum needles, puffs or granules. BC 7062-1, when properly cured, provides nearly perfect reproduction, resulting in a dimensionally stable, hard, tough surface. For use in constructing duplicate models, prototypes, patterns, facing dies, etc.

Features:
- Mix ratio: 100:8 by wt.
- Mix ratio: 100:15 by vol.
- Pot life: 50 minutes
- Viscosity (Mixed)@ 75°F: 5,400 cps
- Cure schedule: See Tech Datasheet
- Casting thickness: 1/8" - 3/4"
- Color: Aluminum
- Demold time (hours): 12-18 hours

<table>
<thead>
<tr>
<th>Product</th>
<th>Mix Ratio (by weight)</th>
<th>Mix Ratio (by volume)</th>
<th>Pot Life (minutes)</th>
<th>Viscosity (cps) (mixed @75°F)</th>
<th>Color</th>
</tr>
</thead>
<tbody>
<tr>
<td>BC7009-1</td>
<td>100:10</td>
<td>100:26</td>
<td>90</td>
<td>20,000</td>
<td>Black</td>
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<tr>
<td>BC7009-2</td>
<td>100:8</td>
<td>100:22</td>
<td>240</td>
<td>35,000</td>
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</tr>
<tr>
<td>BC7020</td>
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<td>-</td>
<td>120-180</td>
<td>Paste</td>
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<tr>
<td>HPX-850</td>
<td>100:16</td>
<td>-</td>
<td>120-150</td>
<td>Paste</td>
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<td>100:11</td>
<td>100:21</td>
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<tr>
<td>BC7062-3</td>
<td>100:16</td>
<td>100:34</td>
<td>240</td>
<td>3,800</td>
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<tr>
<td>BC7136</td>
<td>100:7</td>
<td>100:12</td>
<td>85</td>
<td>15,000</td>
<td>Grey</td>
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<tr>
<td>BC7136-2</td>
<td>100:9</td>
<td>100:16</td>
<td>180</td>
<td>13,500</td>
<td>Grey</td>
</tr>
</tbody>
</table>

**BC7062/BC7062-1**
BC 7062-1 are aluminum filled, low viscosity epoxy mass casting resins. These room temperature cure systems allow the user choice thicknesses of 1/8 inch to a maximum of 3/4 inches without foaming or yielding excessive shrinkage. Casting thicknesses may be increased by incorporating aluminum needles, puffs or granules. BC 7062-1, when properly cured, provides nearly perfect reproduction, resulting in a dimensionally stable, hard, tough surface. For use in constructing duplicate models, prototypes, patterns, facing dies, etc.

Features:
- Mix ratio: 100:8 by wt.
- Mix ratio: 100:15 by vol.
- Pot life: 50 minutes
- Viscosity (Mixed)@ 75°F: 5,400 cps
- Cure schedule: See Tech Datasheet
- Casting thickness: 1/8" - 3/4"
- Color: Aluminum
- Demold time (hours): 12-18 hours
**Epoxy Casting Resins (cont.)**

**BC7062/BC7062-2**
BC 7062-2 System is very similar to the BC 7062-1 both are aluminum filled, low viscosity epoxy mass casting resins. These room temperature cure systems allow the user choice thicknesses of 1/8 inch to a maximum of 2 inches without foaming or yielding excessive shrinkage. Casting thicknesses may be increased by incorporating aluminum needles, puffs or granules. BC 7062-2, when properly cured, provides nearly perfect reproduction, resulting in a dimensionally stable, hard, tough surface. For use in constructing duplicate models, prototypes, patterns, facing dies, etc.

Features:
- Mix ratio: 100:11 by wt.
- Mix ratio: 100:21 by vol.
- Pot life: 2 hours
- Viscosity (Mixed)@ 75F: 7,000 cps
- Cure schedule: See Tech Datasheet
- Casting thickness: 3/4" - 2"
- Color: Aluminum
- Demold time (hours): 24-30 hours

**BC7062/BC7062-3**
BC 7062-3 System is very similar to the BC 7062-1 & BC 7062-2, all are aluminum filled, low viscosity epoxy mass casting resins. These room temperature cure systems allow the user choice thicknesses maximum of 6 inches without foaming or yielding excessive shrinkage. Casting thicknesses may be increased by incorporating aluminum needles, puffs or granules. BC 7062-3, when properly cured, provides nearly perfect reproduction, resulting in a dimensionally stable, hard, tough surface. For use in constructing duplicate models, prototypes, patterns, facing dies, etc.

Features:
- Mix ratio: 100:16 by wt.
- Mix ratio: 100:34 by vol.
- Pot life: 4 hours
- Viscosity (Mixed)@ 75F: 3,800 cps
- Cure schedule: See Tech Datasheet
- Casting thickness: 2" - 6"
- Color: Gray
- Demold time (hours): 48+ hours

**BC7136**
BC7136 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 ¾ inch in non-conductive molds. For use above 150ºF a post-cure is required. This product was engineered to replace VCHD and MDA systems while retaining excellent heat resistance and low viscosity.

BC7136 is designed for consistent use up to 300ºF. Useful for:
- Heat resistant tooling
- Constructing vacuum form tools
- Injection and compression molds
- RTM and RIM molds
- Matched dies

Features:
- Mix ratio: 100:7 by wt.
- Mix ratio: 100:12 by vol.
- Pot life: 85 minutes
- Viscosity (Mixed)@ 75F: 15,000
- Cure schedule: See Tech Datasheet
- Color: Gray

**BC7136/BC7136-2H**
BC7136-2 is an aluminum filled thick section casting system with heat resistance to 300ºF. 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 150ºF a post-cure is required. Does not contain VCHD or MDA. See cure schedule.

BC7136 is designed for consistent use up to 300ºF. Useful for:
- Heat resistant tooling
- Constructing vacuum form tools
- Injection and compression molds
- RTM and RIM molds
- Matched dies

Features:
- Mix ratio: 100:9 by wt.
- Mix ratio: 100:16 by vol.
- Pot life: 3 hours
- Viscosity (Mixed)@ 75F: 13,500
- Cure schedule: See Tech Datasheet
- Color: Gray

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**DID YOU KNOW?**

Did you know that with **BC8250** tooling slab that you can stamp inconel and some light metals?

Did you know that with **BC7062** and the varied hardeners you can cast up to 6" thick?

Did you know that **BC5003** can also be used as a general purpose epoxy adhesive?

Did you know that **BC4570** polyester filler is water resistant and can be used for under the waterline on marine applications?

Did you know that **BC8782** is a hand castable clear urethane that has great impact strength?

Did you know that **BCC** has an excellent series of Epoxy casting resins for high performance tools and masters?

Did you know that **BCC** has one of the best series of fast casts in the industry?

Did you know that you can get all our Technical datasheets for these products on-line?
BC8001 Kwik-Kast
BC8001 is an advanced fast cast polyurethane tooling system. It features low viscosity, low exotherm and minimal shrinkage. It cures hard, yet more durable resulting in less brittle parts. Designed for constructing patterns, prototypes, duplications, negatives, low temperature vacuum form tools, tracing models, etc.

Features:
Mix ratio: 1:1 by wt.
Pot life (1lb. mass) @ 75F: 5-6 minutes
Viscosity (Mixed)@ 75F: 1,500cps
Demold time: 1-2 hours
Color: Black

BC8002 Kwik-Kast II
Kwik Kast II is an enhanced fast cast polyurethane tooling system. It has been reinvented for greater moisture resistance and improved filler suspension for easier premixing of the components. Kwik Kast II exhibits low viscosity, low odor and is color contrasted for uniform mix. It features low exotherm and minimal shrinkage. BC8002 is designed for constructing patterns, prototypes, duplications, negatives, low temperature vacuum form tools, tracing models, etc.

Features:
Mix ratio: 1:1 by wt.
Pot life (1lb. mass) @ 75F: 5-6 minutes
Viscosity (Mixed)@ 75F: 2,350cps
Demold time: 1-2 hours
Color: Gray

BC8007 Lik-Wood
BCC Lik-Wood is a low viscosity, quick setting, easy to use casting material. A model or tool cast from Lik-Wood will weigh 60% less than other filled urethane systems. Within 30 minutes after mixing and pouring, Lik-Wood is ready to be carved, sanded, filed, tapped etc... It's amazing wood-like characteristics make it ideal for light-weight backing of laminates and/or surface coats. Perfect for fast take offs, cores, engineering changes, temporary molds, patterns, models, prototypes and bases for die models.

Features:
Mix ratio: 1:1 by wt.
Pot life (1lb. mass) @ 75F: 5-6 minutes
Viscosity (Mixed)@ 75F: 700-800cps
Demold time: 1-2 hours
Color: Pine/Light yellow
*Longer pot life version available BC8007-2

BC8009 Slo-Kast
BCC Slo-Kast is a low viscosity, medium setting, easy to use casting material. This polyurethane system features extremely low shrinkage when properly cured. Unlike Kwik-Kast, BC 8009 offers the user longer working time for filling large closed mold cavities. Slo-Kast is ideal for casting large sections without having to stage pour. Uses include; tracing models, core boxes, keller aids, patterns, core sticks, vacuum form tools, prototypes and display parts.

Features:
Mix ratio: 1:1 by wt.
Pot life (1lb. mass) @ 75F: 14-18 minutes
Viscosity (Mixed)@ 75F: 2,250cps
Demold time: 3-4 hours*
Color: Black/Gray
*dependant on wall thickness of casting.

BC8010 Metal-Kast
BC8010 is a quick setting urethane reproduction plastic system that simulates many of the desirable characteristics of aluminum metal. A highly machinable tooling material that is now easier to premix due to less setting. New BC8010 exhibits good heat transfer properties, and is ideally suited for a multitude of applications, to include construction of short run low temperature vacuum form tools, prototypes, models, display parts, fixturing and bulk back fill.

Features:
Mix ratio: 1:1 by wt.
Pot life (1lb. mass) @ 75F: 6-7 minutes
Viscosity (Mixed)@ 75F: 2,250cps
Demold time: 1.5-2 hours
Color: Aluminum

Product Mix Ratio Pot-Life Viscosity Demold Time Color
BC8001 1:1 5 - 6 1,500 1 - 2 Black
BC8002 1:1 5 - 6 2,350 1 - 2 Gray
BC8007 1:1 5 - 6 700 - 800 1 - 2 Light Yellow
BC8007-2 1:1 8 - 10 700 - 800 1 - 3 Light Yellow
BC8009 1:1 14 - 18 2,250 3 - 4 Black/Gray
BC8010 1:1 6 - 7 2,250 1.5 - 2 Aluminum
BC8645 1:1 5 - 6 2,075 1 - 2 Gray
BC8650 1:1 5 - 6 2,120 1 - 2 Blue

BC8645 Kwik-Kast Gray
BCC Kwik Kast/Gray is a two component, fast setting polyurethane reproduction plastic. BC8645 sets to a demoldable hardness within 60 minutes @ 77ºF. Uses include; tracing models, core boxes, duplicating aids, patterns, prototypes, low temperature vacuum form tools, etc.

Features:
Mix ratio: 1:1 by wt.
Pot life (1lb. mass): 5-6 minutes
Viscosity (Mixed)@ 75F: 2.075cps
Working life (1lb. mass) @ 75F: 6 minutes
Demold time: 1-2 hours
Color: Grey
**URETHANE ELASTOMERS**

**BC8640E Urethane Elastomer**

BC8640E is an easy to use polyurethane elastomer that is suitable for many applications. Special product characteristics include: room temperature mixing and curing, excellent hydrolytic stability, produces durable products that are easily produced, does not contain MOCA, MDA or MDI.

BC8640E uses include:
- * Molds for plastic and concrete
- * Molds for epoxy, polyurethane and polyester castings or laminates
- * Fabricating parts such as protective shipping pads or skins for creatures

Features:
Mix ratio: 90:100 by wt.
Pot life: 30 minutes
Viscosity (Mixed) 850cps
Demold time: 12-16 hours*
Hardness (shore): 40A +2
Color: Amber
*See Tech Datasheet for more information

**BC8660E Urethane Elastomer**

BC8660E is a multi-purpose elastomer that can perform many functions. Special product characteristics are: excellent use for molds for casting of concrete and plaster, resists moisture absorption, does not contain MOCA, MDA, TDI or MDI, very easy to use and cures at room temperature.

Features:
Mix ratio: 100:55 by wt.
Pot life: 30 minutes
Viscosity (Mixed) 2,500cps
Demold time: 4-6 hours
Hardness (shore): 85-90A
Color: Amber

**BC8680 Urethane Elastomer**

BC8680 is a low viscosity two-component urethane casting compound that is specifically formulated for high abrasion and impact resistance. It is recommended for use for the production casting of highly wear-resistant parts and linings. This product is a safe, easy-to-handle, room temperature mixing and curing system that does not contain TDI, MDA or MOCA. BC8680 is formulated for high abrasion and impact resistance. It is recommended for use for the production casting of high abrasion and impact resistance parts and linings.

Features:
Mix ratio: 100:60 by wt.
Pot life: 18 minutes
Viscosity (Mixed) 1,400-1,500cps
Demold time: 6-8 hours
Hardness (shore): 62D +2
Color: Available in Light Amber, Black or Red

**BC8690E Urethane Elastomer**

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.

Features:
* 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

**BC8770 Urethane Elastomer**

BC8770 is a low viscosity two-component urethane casting compound that is specifically formulated for high abrasion and impact resistance. It is recommended for use for the production casting of highly wear-resistant parts and linings. This product is a safe, easy-to-handle, room temperature mixing and curing system that does not contain TDI, MDI, or MOCA. BC8770 is relatively insensitive to typical environmental moisture and will make good void-free parts without the problems that some conventional urethane systems exhibit.

Features:
Mix ratio: 100:60 by wt.
Pot life: 18-20 minutes
Viscosity (Mixed) 1,800-2,000cps
Demold time: 2-3 hours
Hardness (shore): 70D +2
Color: Available in Light Amber, Black or Red

**BC8860 Urethane Elastomer**

BC8860 is a low viscosity two-component urethane elastomer compound specifically designed for general purpose casting and casting of various shapes. This product is a safe, easy-to-handle, room temperature mixing and curing system that contains no TDI, MDA or MOCA. BC8860 may be used to provide abrasion resistant liners, pads and bumpers. The low shrinkage, low viscosity, superior toughness, and excellent detail reproduction makes this system ideal for general purpose castings and quality tooling operations. It may also be used in potting and encapsulating applications.

Features:
* 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

**BC8870 Urethane Elastomer**

BC8870 is a two-component urethane elastomer compound specifically designed for general purpose molding and casting of various shapes. This product is a safe, easy-to-handle, room temperature mixing and curing system that does not contain TDI, MDA or MOCA. BC8870 is formulated for high abrasion and impact resistance. It is recommended for use for the production casting of highly wear-resistant parts and linings. This product is a safe, easy-to-handle, room temperature mixing and curing system that does not contain TDI, MDI, or MOCA. BC8870 is relatively insensitive to typical environmental moisture and will make good void-free parts without the problems that some conventional urethane systems exhibit.

Features:
Mix ratio: 100:25 by wt.
Pot life: 25 minutes
Viscosity (Mixed) 3,600cps
Demold time: 16-24 hours
Hardness (shore): 82-85D
Color: Amber
**PROTOTYPING URETHANES**

**BC8086**
BC 8086 is a rapid setting, low viscosity, polyurethane casting system. It exhibits a working life of 45 seconds and obtains a demoldable hardness at 7 - 10 minutes.

Some of the outstanding features include:
- *Non-sensitive to moisture after cure*
- *Paintable (non oil base)*
- *Will readily bond to itself*
- *Excellent machinability and surface scribing*
- *No settling components, no premixing required*
- *Different curing schedule give different heat distortion temps*

**Features:**
- Mix ratio: 100:88 by wt.
- Mix ratio: 100:100 by vol.
- Pot life: 45 seconds
- Viscosity (Mixed): 200-400 cps
- Demold time: 7-10 minutes
- Hardness (shore): 79D
- Color: Tan

**BC8165**
BC 8165 is a low viscosity, rapid setting, rigid urethane compound. Similar to BC 8163, however exhibits an 8 to 10 minute working time. This system will cure quickly to a hard, tough, impact resistant casting. BC 8165 is non-sensitive to moisture after cure and will readily bond to itself if stage pours are required. BC 8165 is recommended for thin wall model and prototype applications where a “thermoplastic feel” is desired. The heat resistance for BC8165 is 135°F, a heat resistance of 150°F can be achieved by post cure at 150°F for about 2 hours.

Features:
- Mix ratio: 100:80 by wt.
- Mix ratio: 100:87 by vol.
- Pot life: 8-10 minutes
- Viscosity (Mixed): 230 cps
- Demold time: 1-2 hours
- Final Cure: 7 days
- Hardness (shore): 83D +2
- Color: White

**BC8163 Proto-Kast**
BC 8163 is a very low viscosity, rapid setting, rigid urethane compound. This system will cure quickly to a hard, tough, impact resistant casting. BC 8163 is non-sensitive to moisture after cure and will readily bond to itself if stage pours are required. The one-to-one volume mix ratio makes the system readily adaptable for machine mixing and dispensing. BC 8163 is recommended in applications where a “thermoplastic feel” is desired.

Features:
- Mix ratio: 100:96 by wt.
- Mix ratio: 100:100 by vol.
- Pot life: 2-2.5 minutes
- Viscosity (Mixed): 100-150 cps
- Demold time: 20-60 minutes
- Final Cure: 7 days
- Hardness (shore): 78D +5
- Color: White

**BC8405**
BC8405 is an unfilled, low viscosity, quick setting two component urethane system. An easy to use 1 to 1 mix ratio (Part A/Part B), BC8405 offers the user a reasonable working time with parts demoldable in as little as 2 hours. When properly cured, BC 8405 will exhibit high impact strength and yield thermoplastic-like parts.

Some outstanding features include the following:
- *Mercury free*
- *High impact strength*
- *Moderate heat resistance*
- *No objectionable odor*
- *1 to 1 mix ratio*
- *Excellent finishing properties*
- *Turns white upon cure*
- *Thermoplastic appearance*
- *Longer mold life*
- *More parts per day*

Features:
- Mix ratio: 100:100 by wt.
- Mix ratio: 100:100 by vol.
- Pot life: 15 minutes
- Viscosity (Mixed): 190 cps
- Demold time: 2-4 hours
- Hardness (shore): 75D +3
- Color: White

**BC8400**
BC8400 is an unfilled, low viscosity, quick setting two component urethane system. An easy to use 1 to 1 mix ratio (Part A/Part B), BC8400 offers the user a 3 minute working time with parts demoldable in as little as 30 minutes. When properly cured, BC 8400 will exhibit high impact strength and yield thermoplastic-like parts.

Some outstanding features include the following:
- *Mercury free*
- *High impact strength*
- *Moderate heat resistance*
- *No objectionable odor*
- *1 to 1 mix ratio*
- *Excellent finishing properties*
- *Turns white upon cure*
- *Thermoplastic appearance*
- *Longer mold life*
- *More parts per day*

Features:
- Mix ratio: 100:100 by wt.
- Mix ratio: 100:100 by vol.
- Pot life: 3 minutes
- Viscosity (Mixed): 190 cps
- Demold time: 30-60 minutes
- Hardness (shore): 75D +3
- Color: White

**BC8782 Ultra Clear**
BC 8782 produces a high impact rigid 82 Shore D material that is commonly used to make clear or tinted castings of all kinds. When used at room temperature castings 1/8” thick or larger can be readily cast. Castings that are less than 1/8” thick generally require a mild post-cure. Easily tintable using BCC color tints. This system is not recommended for use with tin cure silicones.

Features:
- Mix ratio: 100:86 by wt.
- Mix ratio: 100:86 by vol.
- Pot life: 12-14 minutes
- Viscosity (Mixed): 650 cps
- Demold time: 6-8 hours
- Hardness (shore): 82D
- Color: Clear
**PROTOTYPING URETHANES**

**DP-11-90 Urethane Casting System**

DP-11-90 is an unfilled, low viscosity, quick setting two component urethane system. An easy to use 1 to 1 mix ratio (Part A/Part B), DP-11-90 offers the user a 3 minute working time with parts demoldable in as little as 30 minutes. When properly cured, DP-11-90 will exhibit high impact strength and yield thermoplastic-like parts.

Some outstanding features include the following:
- Mercury free
- High impact strength
- Moderate heat resistance
- No objectionable odor
- 1 to 1 mix ratio
- Excellent finishing properties
- Turns tan color upon cure
- Thermoplastic appearance
- Longer mold life
- More parts per day
- Ideal for figurines and small detailed parts

Features:
- Mix ratio: 100:100 by wt.
- Pot life: 3 minutes
- Viscosity (Mixed): 300cps
- Demold time: 30-60 minutes
- Hardness (shore): 75D +3
- Color: Tan

<table>
<thead>
<tr>
<th>Product</th>
<th>Mix Ratio (by wt.)</th>
<th>Viscosity (Mixed)</th>
<th>Demold Time</th>
<th>Hardness (shore D)</th>
<th>Color</th>
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<tbody>
<tr>
<td>BC8086</td>
<td>100:88</td>
<td>200 - 400</td>
<td>7-10 min</td>
<td>79</td>
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<tr>
<td>BC8163</td>
<td>100:96</td>
<td>100 - 150</td>
<td>20-60</td>
<td>78+</td>
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<tr>
<td>BC8165</td>
<td>100:80</td>
<td>100:87</td>
<td>1-2 hours*</td>
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<tr>
<td>BC8400</td>
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<td>100:100</td>
<td>3</td>
<td>190</td>
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<tr>
<td>BC8405</td>
<td>100:100</td>
<td>100:100</td>
<td>15</td>
<td>2 - 4 hours</td>
<td>75+</td>
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<tr>
<td>BC8782</td>
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<td>100:88</td>
<td>12 - 14</td>
<td>650</td>
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<tr>
<td>DP-11-90</td>
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<td>-</td>
<td>13</td>
<td>1,800 - 2,000</td>
<td>70</td>
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</tbody>
</table>

*Dependant on thickness of casted part

**BC9020 Silicone RTV Rubber**

BC 9020 is a violet colored, two-component, flowable compound that regardless of thickness or confinement, cures at room temperature. The cured rubber is high strength and high tear with good elongation. In addition, BC9020 features low viscosity, low durometer and resistance to sulfur clays.

Features:
- Mix ratio: 10:1
- Pot life: 1 hour
- Viscosity (mixed): 31,000cps
- Time for 90% cure: 24hour
- Full cure: 1-2days
- Hardness (shore): 20-25A
- Color: Violet

**BC9040T Clear Silicone**

BC 9040T is a clear, addition/platinum cure, two-component, flowable compound that, regardless of thickness or confinement, cures at room temperature or by application heat. The cured rubber is high strength and high tear with good elongation. BC9040T is a mold-making material recommended for repetitive production of intricate shapes cast in epoxy or urethane resins. It is also used in the potting of electronic components and in protecting sensitive assemblies against thermal shock and vibration. Must be used with BC8782 Ultra Clear Prototyping urethane.

Features:
- Mix ratio: 10:1
- Pot life: 1.5 hour
- Viscosity (mixed): 38,000cps
- Hardness (shore): 40A
- Color: Translucent

**BC9060**

BC 9060 is a blue colored, two-component, flowable compound that, regardless of thickness or confinement, cures at room temperature or by application heat. The cured rubber is high strength and high tear with good elongation. BC 9060 is a mold-making material recommended for repetitive production of intricate shapes cast in epoxy or urethane resins. It is also used in the potting of electronic components and in protecting sensitive assemblies against thermal shock and vibration.

Features:
- Mix ratio: 10:1
- Pot life: 2 hour
- Viscosity (mixed): 100,000cps
- Hardness (shore): 60A
- Color: Blue

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**ADHESIVES**

**BC5003**
*Foundry Red Board Adhesive*

BC 5003 is a medium viscosity, unfilled epoxy system. It is a room temperature curing resin with a relatively short pot life. BC 5003 is considered an excellent general purpose adhesive for in-shop use. Recommended for use in gluing up BCC’s Tooling Board Series.

Features:
- Mix ratio: 100:20 by wt.
- Mix ratio: 100:22 by vol.
- Pot life: 14-15 minutes
- Viscosity (Mixed)@ 75°F: 3,500cps
- Cure schedule: 6-8 hours
- Color: Clear or Red

**BC5105**
*300° F Adhesive*

BC 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. BC 5105 can afford consistent use to 300°F if required. Ideal for bonding tooling boards requiring high temperature resistance.

Does not contain VCHD or MDA. Useful for:
- *Constructing vacuum form tools
- *Injection and compression molds
- *RTM and RIM molds
- *Matched dies

Features:
- Mix ratio: 100:17 by wt.
- Mix ratio: 100:20 by vol.
- Pot life: 55 minutes
- Viscosity (Mixed)@ 75°F: 2,000cps
- Cure schedule: 8-12 hours
- Color: Clear

**BC5200**
*Kwik-Set Epoxy Adhesive*

BC5200 is a medium viscosity fast setting two part Epoxy Adhesive System. With an easy to use 1 to 1 mix ratio, BC5200 is considered an excellent general purpose adhesive for in-shop use. BC5200 will bond to wood, concrete, select plastics and most metal surfaces.

Features:
- Mix ratio: 100:100 by wt.
- Mix ratio: 100:100 by vol.
- Pot life: 4-4.5 minutes
- Viscosity (Mixed)@ 75°F: 13,000cps
- Color: Clear

**DP-11-83**
*Urethane Adhesive Slo*

DP-11-83 is a low viscosity, quick setting, easy to use adhesive and/or casting material. This product was designed to bond together the obomodulan 302 foam board to create desired dimensions in length, width and height. DP-11-83 has a working life of up to 13 minutes for casting applications. If used as an adhesive, it is workable for up to 16 minutes.

Specifications:
- Mix ratio: 100:100
- Viscosity (Mixed): 2,200cps
- Pot Life: 14-16 minutes
- Cure time: 6-8 hours
- Color: Pink

**DP-11-88 (MB3000)**
*Urethane Adhesive*

DP-11-88 is a medium viscosity quick setting easy to use urethane adhesive. This system was specifically designed to bond together the MB3000 Model/Tooling Board to create desired dimensions in length, width, and height. DP-11-88 offers a working life of 10 to 12 minutes in 1/4 pound mass, and 20 + minutes in a 1/16 inch film.

Specifications:
- Mix ratio: 100:100
- Viscosity (Mixed): 3,750cps
- Hardness: 62D
- Pot Life: 10-12 minutes
- Gel time: 12-14 minutes

**DP-11-75**
*Foundry Plank Repair Paste*

DP-11-75 is a two component medium viscosity urethane paste system. A hybrid product which was designed specifically for making quick responsive repairs/buildups to the MB 4000 Foundry Plank. DP-11-75 is exceptionally tough, highly machinable after cure, and exhibits superior properties similar to MB 4000.

Specifications:
- Mix ratio: 100:100
- Viscosity (Mixed): 1,600cps
- Pot Life: 1.5 minutes
- Cure time: 20-30 minutes
- Color: Red
- Packaging: 50ml tubes

**ACCESSORIES**

**BC32 Glass fibers**

BC 32, microglass milled fibers will increase the mechanical strengths, such as impact strength, tensile strength, compressive strength, and flexural strength in plastic tooling compounds. They are used as a reinforcement to both improve dimensional stability as well as increase heat distortion at elevated temperatures.

**BC35 Flock/White**

BC 35 Flock/White is used as a thickening agent with laminating resin to achieve heavy paste consistencies.

**BC37 Holow Microspheres (Ceramic)**

BC 37 are hollow microspheres, which are ceramic in nature. They are an efficient lightweight filler material to be used in applications with most resins.

**Fumed Silica**

Available in 10lb. bags

**Calcium Carbonate**

Available in 50lb. bags

**BCC Release Agents**

**BC83 Liquid Wax - Parting**

BC83 Liquid Wax Parting/White is an excellent low viscosity, easy to use release agent for two component epoxy and polyurethane systems.

**BC84 PVA - Parting**

(Water Soluble)

BC 84 PVA Parting/Green is a water/alcohol solution of water soluble, film forming materials. It is particularly recommended as a parting layer for separation between polyester or epoxy resins and various mold surfaces. BC 84 is normally applied by spraying on the mold surface and dries at room temperature to form a smooth, very glossy film. It will not shrink and pull away from corners or curved surfaces. After drying of the resin the film parts easily from the mold and is readily dissolved from the molded parts with water.

**BC87 Urethane Parting**

BC 87 Urethane Parting/Yellow is an excellent low viscosity, easy to use release agent for two component polyurethane systems. Rigid, semi-rigid and flexible parts release from molds easily and is achieved.

**Krytox(Mold Release)**

Available in 1oz spray cans.

**Miscellaneous Accessories**

- Brushes, Hand Cleaner, Fabrics, Gloves,
- Mixing Cups, Mixing Sticks, Paint shaker

Order-line: 800-556-0067 • Fax: 317-736-4872 • www.bccproducts.com
Epoxy Clay

Blehm epoxy clay compounds are two part systems, which when mixed together form into a soft, dough-like consistency and cure to a hard solid with excellent toughness and dimensional stability. The gray resin and a colored hardener provide visual assistance to obtain thorough mixing. The mixed clay compounds cure at room temperature and can be carved with wood working tools, or easily machined.

BP5001
Mix Ratio(by wt.): 70:10
Working Time: 45 minutes
Cure Time: 16 hours
Coverage (cu. in/gal): >250
Density (cu. in/lb.): 22.4
Hardness (Shore D): 70
Color: Gray

BP5002
Mix Ratio(by wt.): 70:10
Working Time: 10 minutes
Cure Time: 1 hours
Coverage (cu. in/gal): >250
Density (cu. in/lb.): 22.4
Hardness (Shore D): 70
Color: Gray

BP5003
Mix Ratio(by wt.): 70:10
Working Time: 130 minutes
Cure Time: 24 hours
Coverage (cu. in/gal): >240
Density (cu. in/lb.): 21.4
Hardness (Shore D): 70
Color: Gray

BP5323
Mix Ratio(by wt.): 100:50
Working Time: 40 minutes
Cure Time: 16 hours
Coverage (cu. in/gal): >280
Density (cu. in/lb.): 62.3
Hardness (Shore D): 50
Color: Brown

BP5401
Mix Ratio(by wt.): 100:20
Working Time: 45 minutes
Cure Time: 16 hours
Coverage (cu. in/gal): >285
Density (cu. in/lb.): 26.5
Hardness (Shore D): 68
Color: Gray

BP5403
Mix Ratio(by wt.): 100:20
Working Time: 70 minutes
Cure Time: 16 hours
Coverage (cu. in/gal): >285
Density (cu. in/lb.): 26.5
Hardness (Shore D): 68
Color: Gray

BP5700
Mix Ratio(by wt.): 100:100
Working Time: 120 minutes
Cure Time: 24 hours
Coverage (cu. in/gal): 235
Density (cu. in/lb.): 46.9
Hardness (Shore D): 55
Color: Gray

BP5750
Mix Ratio(by wt.): 100:100
Working Time: 70 minutes
Cure Time: 16 hours
Coverage (cu. in/gal): 235
Density (cu. in/lb.): 25.1
Hardness (Shore D): 70
Color: Gray

BP5601
BP5601 is an Epoxy laminating paste for constructing negative molds from models and masters. BP5601 has a strong and yet not highly abrasive property which allows for quick, large tool construction. With a 2 hour working time BP5601 allows enough time to build large tools.

*Easy to use
*Negatives
*Foundry molds
*Quick splash molds
*Ceramic molds

Features:
Mix ratio: 100:15
Pot life: 1 hour
Working time: 2 hours
Hardness (shore D): 73 (+/−5)
Cure time: 16 hours
Compressive strength: 6,500psi
Density (lbs/gal): 7.7 (+/−2)
Tg: 160°F
Color: Gray

For over 50 years Blehm Plastics has been a leader in epoxy chemistries. Known globally for their 5-minute epoxy adhesive and their epoxy 2-part clay, Blehm is continuing their years of success. Blehm became an integral part of BCC Products in 2006 and is a flagship now among some of the best tooling products in the automotive, foundry, marine and aerospace industries.

Order-line: 800-556-0067 • Fax: 317-736-4872 • www.blehmplastics.com
### Epoxy Laminating Resins

**BP2014**
BP 2014 is a white epoxy laminating resin which provides quick wet-out of fiberglass cloth with easy brushing characteristics, while keeping run-off from vertical surfaces to a minimum. The resin is color indicated (green) and will turn white as the hardener is mixed into the resin. This indicator system promotes fast and efficient mixing of the resin and hardener, insuring that they are thoroughly mixed yet wasting no time overmixing. Fiberglass laminates made with BP 2014 will have excellent physical properties when used for structural parts.

**Features:**
- Mix ratio (by wt.): 100:20
- Viscosity (mixed): 2,700 cps
- Pot life (min): 35
- Cure time (hrs)(72°F): 16
- Tensile strength (psi): 31,500
- Flexural strength (psi): 52,500
- Compressive strength (psi): 4,100
- Heat Deflection (°F): 160
- Color: White

**BP2022**
BP 2022 is a white epoxy laminating resin which provides a laminate of exceptional dimensional stability. The resin is color indicated (green) and will turn white as the hardener is mixed into the resin. This indicator system promotes fast and efficient mixing of the resin and hardener, insuring that they are thoroughly mixed yet wasting no time overmixing. BP 2022 provides quick wet-out of fiberglass cloth with easy brushing characteristics, while keeping run-off from vertical surfaces to a minimum.

**Features:**
- Mix ratio (by wt.): 100:20
- Viscosity (mixed): 1,900 cps
- Pot life (min): 35
- Cure time (hrs)(72°F): 16
- Tensile strength (psi): 52,500
- Flexural strength (psi): 41,500
- Compressive strength (psi): 70
- Hardness (shore D): 85D
- Color: White

**BP2186**
BP 2186 is a high-temperature, aluminum-filled epoxy laminating resin which provides easy brushing characteristics and quick wet-out of fiberglass cloth, while at the same time limiting run-off from vertical surfaces to a minimum. BP 2186 is formulated to have minimum skin irritation potential and avoids all carcinogenic materials in both the resin and hardener.

**Features:**
- Mix ratio (by wt.): 100:14
- Viscosity (mixed): 4,100 cps
- Pot life (min): 55
- Cure time (hrs)(72°F): 16
- Heat Deflection (°F): 240
- Hardness (shore D): 85D
- Color: Gray

*note: different cure schedule in the case of high temperature tools*

**BP2191**
BP 2191 is a high-temperature, aluminum-filled epoxy laminating resin which provides easy brushing characteristics and quick wet-out of fiberglass cloth, while at the same time limiting run-off from vertical surfaces to a minimum. BP 2191 is formulated to have minimum skin irritation potential and avoids all carcinogenic materials in both the resin and hardener.

**Features:**
- Mix ratio (by wt.): 100:15
- Viscosity (mixed): 4,100 cps
- Pot life (min): 140
- Cure time (hrs)(72°F): See Datasheet
- Heat Deflection (°F): 315
- Hardness (shore D): 85D
- Color: Gray

*note: different cure schedule in the case of high temperature tools*

### Epoxy Surface Coats

**BP3042**
BP 3042 and BP 3044 are white, medium set-time epoxy surface coats. BP 3042 resin is color indicated (green) and will turn white as the hardener is mixed into the resin. This indicator system promotes fast and efficient mixing of the resin and hardener, insuring that they are thoroughly mixed yet wasting no time overmixing. BP 3044 does not contain this indicator system. BP 3042 and BP 3044 are formulated to have minimum skin irritation potential and avoid all carcinogenic materials in both the resin and hardener.

**Features:**
- Mix ratio (by wt.): 100:15
- Viscosity (mixed): Thixotropic (brushable)
- Pot life (min): 30
- Cure time (hrs)(72°F): 16
- Hardness (shore D): 85D
- Color: White

**BP3046**
BP 3046 is a medium set-time, white epoxy surface coat formulated especially to be machine dispensable. It is formulated to have minimum skin irritation potential and avoids all carcinogenic materials in both the resin and hardener.

**Features:**
- Mix ratio (by wt.): 100:15
- Viscosity (mixed): Thixotropic (machine dispensable)
- Pot life (min): 30
- Cure time (hrs)(72°F): 16
- Hardness (shore D): 85D
- Color: White

<table>
<thead>
<tr>
<th>Product</th>
<th>Mix Ratio (by wt.)</th>
<th>Viscosity (mixed / cps)</th>
<th>Pot life (min)</th>
<th>Cure time (hours)</th>
<th>Tensile Strength (psi)</th>
<th>Flexural Strength (psi)</th>
<th>Compressive Strength (psi)</th>
<th>Hardness (shore D)</th>
<th>Color</th>
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<td>16</td>
<td>52,500</td>
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<td>BP2186</td>
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<td>4,100</td>
<td>55</td>
<td>16</td>
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<td>BP2191</td>
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<td>4,100</td>
<td>140</td>
<td>See tech sheet</td>
<td>See tech sheet</td>
<td>See tech sheet</td>
<td>See tech sheet</td>
<td>See tech sheet</td>
<td>85</td>
</tr>
</tbody>
</table>

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**BP3176**
BP 3176 is a high-temperature, aluminum-filled epoxy surface coat. It has a thixotropic consistency which allows successive coats to be brushed on to any desired thickness without sagging on vertical surfaces. BP 3176 is formulated to have minimum skin irritation potential and avoids all carcinogenic materials in both the resin and hardener.

Features:
- Mix ratio (by wt.): 100:14
- Viscosity (mixed): Thixotropic (brushable)
- Pot life (min): 55
- *Cure time (hrs)(72°F):* See datasheet
- Heat Deflection (°F): 235
- Hardness (shore): 85D
- Color: Gray

*note: different cure schedule in the case of high temperature tools*

**BP3180**
BP 3180 is a high-temperature, aluminum-filled epoxy surface coat which has an excellent spraying consistency. BP 3180 is formulated to have minimum skin irritation potential and avoids all carcinogenic materials in both the resin and hardener.

Features:
- Mix ratio (by wt.): 100:12
- Viscosity (mixed): Sprayable
- Pot life (min): 70
- *Cure time (hrs)(72°F):* See datasheet
- Heat Deflection (°F): 235
- Hardness (shore): 85D
- Color: Gray

*note: different cure schedule in the case of high temperature tools*

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**Epoxy Surface Coats**

<table>
<thead>
<tr>
<th>Product</th>
<th>Mix Ratio (by weight)</th>
<th>Viscosity (mixed / cps)</th>
<th>Pot life (min)</th>
<th>Cure time (hours)</th>
<th>Heat Deflection (°F)</th>
<th>Hardness (shore D)</th>
<th>Color</th>
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<tbody>
<tr>
<td>BP3042</td>
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<td>BP3176</td>
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**Epoxy Casting Resins**

<table>
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<th>Mix Ratio (by weight)</th>
<th>Viscosity (mixed / cps)</th>
<th>Pot life (hours)</th>
<th>Cure time (hours)</th>
<th>Heat Deflection (°F)</th>
<th>Hardness (shore D)</th>
<th>Color</th>
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<tr>
<td>BP4122</td>
<td>100:9.5</td>
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<td>2</td>
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<td>BP4123</td>
<td>100:8</td>
<td>23,750</td>
<td>3</td>
<td>16</td>
<td>300</td>
<td>82</td>
<td>Gray</td>
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<tr>
<td>BP4124</td>
<td>100:7</td>
<td>11,250</td>
<td>5</td>
<td>16</td>
<td>280</td>
<td>85</td>
<td>Gray</td>
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</tbody>
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---

**Epoxy Casting Resins**

BP 4122 is a fast-set, high-temperature, aluminum filled epoxy casting resin. It will cure rigid overnight but requires a post-cure to achieve optimum properties. The filler in the resin will not settle into a hard-pack even after prolonged standing. BP 4122 is formulated to have minimum skin irritation potential and avoids all carcinogenic materials in both the resin and hardener.

Features:
- Mix ratio (by wt.): 100:9.5
- Viscosity (mixed): 26,500cps
- Pot life (hrs): 2
- *Cure time (hrs)(72°F):* 16
- Hardness (shore): 82D
- Heat Deflection (°F): 315
- Color: Gray

*note: different cure schedule in the case of high temperature tools*

BP 4124 is a slow-set, high-temperature, aluminum-filled epoxy casting resin. It will cure rigid overnight but requires a post-cure to achieve optimum properties. The filler in the resin will not settle into a hard-pack even after prolonged standing. BP 4124 is formulated to have minimum skin irritation potential and avoids all carcinogenic materials in both the resin and hardener.

Features:
- Mix ratio (by wt.): 100:7
- Viscosity (mixed): 11,250cps
- Pot life (hrs): 5
- *Cure time (hrs)(72°F):* 16
- Hardness (shore): 85D
- Heat Deflection (°F): 280
- Color: Gray

*note: different cure schedule in the case of high temperature tools*
**ADHESIVES**

### Epoxy Adhesives

**BP2019**
BP 2019 is a clear-amber epoxy adhesive formulated especially for the bonding of wood and urethane model board. It may be also used as a laminating resin. The resin is color indicated (green) and will turn to a clear amber color as the hardener is mixed into the resin. This indicator system promotes fast and efficient mixing of the resin and hardener, insuring that they are thoroughly mixed yet wasting no time overmixing.

**Features:**
- Mix ratio (by wt.): 100:25
- Viscosity (mixed): 2,100 cps
- Pot life (min): 30
- Cure time (hrs, 72°F): 16
- Hardness (shore): 80D
- Heat Deflection (°F): 160
- Color: Gray

**BP9024**
**The 5-minute Epoxy Adhesive**
BP 9024 is a fast-set epoxy adhesive specially formulated for the bonding of wood and urethane model board. It can also be used for making quick patches and fast laminates. The resin is color indicated (green) and will turn to a clear amber color as the hardener is mixed into the resin. This indicator system promotes fast and efficient mixing of the resin and hardener, insuring that they are thoroughly mixed yet wasting no time overmixing.

**Features:**
- Mix ratio (by wt.): 100:100
- Viscosity (mixed): See datasheet
- Pot life (min): 5
- Set time (min, 72°F): 15
- Hardness (shore): 60D
- Color: Lt Amber

### Styrofoam Pattern Adhesive

**BP8002**
Styrofoam Pattern Adhesive
BP 8002 is a water-based latex-rubber adhesive used for the rapid build-up of styrofoam foundry patterns. BP 8002 contains a green dye for easier visibility. BP8002 has been specially formulated and fully approved for the “Full Mold Foundry Process” of direct metal casting using styrofoam patterns.

**Features:**
- Viscosity: Brushable thixotropic
- Weight (per gal.): 7.6 lbs
- Base: Liquid Latex dispersed in water
- Color: Green

**BP8003**
Styrofoam Pattern Adhesive
BP 8003 is a water-based latex-rubber adhesive used for the rapid build-up of styrofoam foundry patterns. BP 8003 contains a natural cream color to blend with styrofoam. BP8003 has been specially formulated and fully approved for the “Full Mold Foundry Process” of direct metal casting using styrofoam patterns.

**Features:**
- Viscosity: Brushable thixotropic
- Weight (per gal.): 7.6 lbs
- Base: Latex rubber dispersed in water
- Color: Cream

### Polysulfide Rubber Adhesive

**BP6118**
BP 6118 is a two-component polysulfide adhesive formulated especially for the bonding of Blehm Cold Setting Rubber (CSR) to plaster casings. It may also be used for the bonding of CSR to other backing materials such as metal or wood.

**Features:**
- Mix ratio (by wt.): 100:10
- Viscosity (mixed): 6,500 cps
- Pot life (min): 5
- Set time (min, 72°F): 30
- Color: Black

### Foundry Pattern Sealers

**BP8004**
BP 8004 has a soft paste-like consistency which spreads and fills easily and smoothly. BP 8004 dries with very little shrinkage and no surface cracking so that one application is usually sufficient to fill most irregularities and form filet-radii. After application, a firm skin will form within minutes, and it will be thoroughly dry overnight. The sealer on a completed styrofoam pattern will withstand all normal storage and transportation conditions.

**Features:**
- Base: Water based emulsion
- Thinner: Use water only
- Weight (per gal.): 6.6 lbs
- Color: Green

**BP8005**
BP 8005 is a water-based paste-wax compound used for the filling of surface irregularities and the forming of filet-radii on styrofoam foundry patterns. BP 8005 contains a green dye for easier visibility. BP8005 has been specially formulated and its fully approved for the “Full Mold Foundry Process” of direct metal casting using styrofoam patterns.

**Features:**
- Base: Water based emulsion
- Thinner: Use water only
- Weight (per gal.): 6.6 lbs
- Color: Green

**BP9024 Plaster Sealer**
BP 9024 adhesive can also be used to seal wet or dry plaster models against moisture-vapor transmission. BP 9024 resin and hardener, when mixed, will gel in approximately five minutes but when a solvent is added to both the resin and hardener before mixing, the gel-time may be extended to about one hour. The solvent facilitates good penetration of the plaster as well as giving the mixture adequate pot life for use. Use equal parts by weight or volume of resin and hardener and add an equal volume of solvent, which should be split, half being added to the resin and half to the hardener.

**Features:**
- Mix ratio (by wt.): 100:100
- Viscosity (mixed): See datasheet
- Pot life (min): 5
- Set time (min, 72°F): 15
- Hardness (shore): 60D
- Color: Lt Amber
POLYSULFIDE RUBBER

BP6007
BP 6007 is a fast-setting, three component polysulfide that will cure at room temperature into a very flexible rubber mold with excellent dimensional accuracy and stability. When a mold is to be used to cast epoxy, polyester, or to make a negative rubber mold, a release film will be required. A diluted PVA solution is recommended.

Features:
Mix ratio by wt.(resin : hardener+accelerator): 100:20+4 (10-15min gel)
100:15+4 (25-35min gel)
100:15+0 (90min gel)
Viscosity (mixed): 6,500cps
*Cure time (hrs):(72°F): Dependent on mix ratio
Hardness (shore): 4A
Color: Black
*note: less than 15 parts hardener will not cure product

BP6008
BP 6008 Cold Setting Rubber (CSR) is a slow-set, two component polysulfide molding system specially formulated for casting that will cure at room temperature into a very flexible rubber mold with excellent dimensional accuracy and stability. BP 6008 will bond to itself so that changes or additions to a CSR mold may be made at any time. When a CSR mold is to be used to cast epoxy, polyester, or to make a CSR negative mold, a release film will be required. A diluted PVA solution is recommended. CSR will soften lacquered surfaces if left in contact with these surfaces for more than two hours.

Features:
*Mix ratio(by wt.): 100:20(2hr gel)
*Mix ratio(by wt.): 100:15 (3hr gel)
*Mix ratio(by wt.): 100:12 (5hr gel)
Viscosity (mixed): 6,500cps
*Cure time (hrs):(72°F): 16
Hardness (shore): 4A
Color: Black
*note: less than 12 parts hardener will not cure product

BP6604
BP 6604 Cold Setting Rubber (CSR) is a two component polysulfide molding system specially formulated for casting that will cure at room temperature into a very flexible rubber mold with excellent dimensional accuracy and stability. Before pouring the freshly mixed CSR into a mold, allow 3-4 minutes for the air to rise to the surface. A full cure will take place overnight (16 hours).

Features:
*Mix ratio(by wt.): 100:20(2hr gel)
*Mix ratio(by wt.): 100:15 (3hr gel)
*Mix ratio(by wt.): 100:12 (5hr gel)
Viscosity (mixed): 6,500cps
*Cure time (hrs):(72°F): 16
Hardness (shore): 15A
Color: Black
*note: less than 12 parts hardener will not cure product

BP6920
BP 6920 is a two component polysulfide molding system utilizing a low toxicity manganese dioxide hardener, formulated especially for casting tire foundry molds. It has a low viscosity with excellent flow characteristics enabling it to duplicate fine mold detail, while allowing entrapped air to escape. After curing, BP 6920 may be easily stretched to release from delicate porous plasters and still maintain excellent Total Indicated Run-out (TIR).

Features:
Mix ratio: See Tech Datasheet for multiple ratios
Viscosity (mixed): 6,500cps
*Cure time (hrs): 3 (complete 16 hrs)
*Hardness (shore): Dependant on mix ratio
Color: Black
*note: less than 15 parts hardener will not cure product

Did you Know?
Did you know that BP9024 was one of the first 5-minute epoxy adhesives on the market.

Did you know BP5700 is an excellent 1:1 ratio clay for tool building and can be easily CNC’d after tool construction is done.

BP6008 is one of the favorite cold setting rubber compounds of the racing industry.

Blehm’s BP2014 is a great white laminating resin on vertical tool surfaces has a color-indicated system for perfect mixing.

Did you know that BP2019 adhesive is an all-purpose quick setting epoxy for all substrate materials like wood, composites and plastics.