

# BCC Resins BC 6128

Epoxy; Epoxide

BCC Products Inc.

## Message:

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 150°F a post-cure is required. Post cure for applications requiring temperatures above 250°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. BC 6128 can afford consistent use to 300°F if required. Does not contain VCHD or MDA. Typical uses include constructing vacuum form tools, Injection and compression molds, RTM and RIM molds, and matched dies.

General Information			
Filler / Reinforcement	Silicon Carbide		
Features	Good Wear Resistance		
	High Hardness		
	High Heat Resistance		
	Stain Resistant		
Uses	Coating Applications		
Appearance	Black		
Forms	Paste		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.84	g/cm <sup>3</sup>	ASTM D792
--	1.83	g/cm <sup>3</sup>	ASTM D1505
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	92		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Ultimate)	51.4	MPa	ASTM D638
Flexural Strength (Break)	81.4	MPa	ASTM D790
Compressive Strength	199	MPa	ASTM D695
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	121	°C	ASTM D648
CLTE - Flow	3.8E-5	cm/cm/°C	ASTM D696
Thermoset	Nominal Value	Unit	
Thermoset Components			
Hardener	Mix Ratio by Weight: 7.0, Mix Ratio by Volume: 13		
Resin	Mix Ratio by Weight: 100, Mix Ratio by Volume: 100		
Pot Life (24°C)	35 to 45	min	
Demold Time (24°C)	720 to 960	min	

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