



BCC PRODUCTS, INC.

BLEHM PLASTICS

FAST CAST – EPOXIES – URETHANES – POLYESTER PASTES – TOOLING BOARDS – RELEASE AGENTS – SILICONES

**BP 4124 "SLOW - SET"
HIGH TEMPERATURE - ALUMINUM FILLED
EPOXY CASTING RESIN**

DESCRIPTION:

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.

USE PROCEDURE:

Mix the resin and hardener in the ratio of 100 parts resin to 7 parts hardener, by weight. Minimum viscosity will be achieved a few minutes after mixing. Additional aluminum shot can be added to improve the thermal conductivity of the casting. When the casting is to be used at elevated temperatures, it should be given a post-cure. A suggested cure schedule is:

4 Hrs. @ 130°F
4 Hrs. @ 200°F
4 Hrs. @ 300°F

PROPERTIES:

Mix ratio - resin/hardener:	100/7 by weight
Viscosity - mixed:	11,250 cps
Pot-life:	5 hours @ 72°F
Cure time:	16 hours - overnight
Specific gravity - resin:	1.71
Specific gravity - hardener:	1.01
Volume/lb:	16.9 cu. in./lb.
Hardness:	Shore D 85
Heat deflection temperature:	280°F

PRECAUTIONS:

Skin contact should be avoided. After using, clean hands with alcohol followed by soap and water. For eye contact, flush with water and consult a physician immediately. For further safety information, please see the MSDS.

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