



BCC PRODUCTS, INC.



BLEHM PLASTICS

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

BP 6118 ADHESIVE FOR POLYSULFIDE RUBBER

DESCRIPTION:

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.

USE PROCEDURE:

Mix the resin and hardener in the ratio of 100 parts resin to 10 parts hardener, by weight. Mix thoroughly to blend the cream colored adhesive resin with the brown hardener until a uniform color is obtained. Spread or paint the adhesive onto the plaster surface to which the CSR is to be bonded. Working time of the mixed adhesive will be about 5 minutes, and it will be tack-free in approximately 30 minutes or less.

Cold Setting Rubber may be cast immediately after application of the adhesive, or the adhesive may be allowed to cure for several days. In either case, the bond will be just as good. The best procedure is to allow the adhesive to at least gel or slightly cure before handling to prevent scraping or washing off the adhesive during assembly of the part in the mold or pouring of the CSR.

Special instructions for adhesion to plaster: If the plaster casing has been cast against clay or a mold release such as petroleum jelly or wax, the surface should be wiped with a cloth saturated with toluene and then coated with orange shellac. Allow the shellac to dry before applying BP 6118 adhesive.

PROPERTIES:

Mix ratio:	100/10 by weight
Viscosity - mixed:	6,500 Brookfield cps @ 72°F
Gel-time:	5 minutes @ 72°F
Set-time:	30 minutes @ 72°F
Specific gravity - cured:	1.375
Shelf life:	One year or longer

PRECAUTIONS:

The hardener contains a lead compound which is toxic if taken internally. Wash hands after use. Wipe-up all spills and dispose of properly. For further safety information, please see the MSDS.

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