



BCC PRODUCTS, INC.

BLEHM PLASTICS

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

**BP 6604
POLYSULFIDE RUBBER
FOR FOUNDRY PATTERNS**

DESCRIPTION:

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.

USE PROCEDURE:

Mix the resin and hardener thoroughly in the ratios listed below. Gel-time may be adjusted from 2 to 5 hours by varying the amount of hardener. Thorough mixing is necessary to insure a uniform mix as the hardener will settle rapidly to the bottom of the mixing container when added to the CSR resin. 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).

Use the following mix-ratios, by weight, as a guide:

	Resin	Hardener
2 hour gel @ 72°F	100	20
3 hour gel @ 72°F	100	15
5 hour gel @ 72°F	100	12

Note: Less than 12 parts hardener will not cure the rubber.

PROPERTIES:

Viscosity - mixed:	6,500 Brookfield cps @ 72°F
Specific gravity - cured:	1.375
Density - cured:	0.050 lbs./cu. in.
Hardness:	Shore A 4
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.

2140 Earlywood Drive, P.O. Box 327, Franklin, IN 46131
Ph (317) 736-4090 Fax (317) 736-4872
Web: www.bccproducts.com & www.blehmplastics.com