



BCC PRODUCTS, INC.

BLEHM PLASTICS

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

**BP 6920
LEAD-FREE
POLYSULFIDE RUBBER**

DESCRIPTION:

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).

USE PROCEDURE:

Mix the resin and hardener in the ratio of 100 parts resin to 20 parts hardener, by weight. Varying the resin/hardener ratio will have an adverse effect on the physical properties of the rubber. Since the hardener is heavier than the resin and will settle to the bottom of the mixing container, care must be taken to ensure that any hardener on the bottom of the mixing container is blended into the resin. The gel-time of the mixed resin/hardener is approximately 3 hours with a full cure overnight (16 hours) at 72°F/22°C. Temperatures lower than 72°F/22°C will lengthen the cure time required. If a shorter cure-time is desired, BP 6901 Accelerator may be added to the resin just prior to adding the hardener. A maximum of 2 parts BP 6901 Accelerator to 100 parts resin will reduce gel-time by half.

If a softer rubber is desired, BP 6920 Plasticizer may be added to the mix as follows:

Resin	Hardener	Plasticizer	Shore A Hardness
100	20	0	4
100	20	7	2
100	20	10	1

PROPERTIES:

Viscosity - mixed:	5,600 Brookfield cps @ 72°F
Gel-time:	XXXX
Cure-time:	XXXX
Specific gravity - cured:	1.375
Density - cured:	0.050 lbs./cu. in.
Hardness:	Shore A 4
Shelf life:	One year or longer

PRECAUTIONS:

For safety information, please see the MSDS.

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