



## Product Datasheet BC 809 Series General Molding & Casting Systems

### Physical Properties of series with BC 809 Iso

Property	XP2017-029	XP2016-046	XP2016-047	XP2016-048
Shore A Hardness,	80A	85A	90A	95A
Ultimate Tensile, PSI	2034	2600	2100	2900
Elongation, %	800	700	600	775
Tear, Die C, PLI	330	390	400	450
Split Tear PLI	66	90	100	125
Gel Time, Minutes	20	20	20	20
Mix Ratio by Weight (Polyol:Prepolymer)	53:100	47:100	42:100	25:100
Color	Amber	Amber	Amber	Amber

### Preparation of Materials for Use

#### Prepare Master and Mold Housing

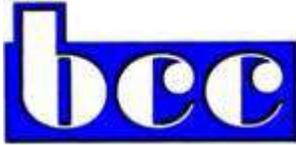
First, clean and dry your master thoroughly. If the master has a porous surface (clay, concrete, plaster, etc.) or is made of sulfur-based clay, you must seal it. You can use polyurethane varnish, polyurethane sealant, or paste wax to seal your master. Next, anchor your master and seal the base so that BC 809 does not leak under your master. A hot glue gun works to anchor and seal the base at the same time. Also, you should seal all of your mold housing connections with sulfur-free clay or hot glue. Then, apply an appropriate release agent to the master and interior of the mold housing. A silicone-based release is recommended, but always test before use. Apply release agent sparingly, while coating all surfaces of the master. Too much release agent may cover the details of the master or pool in low spots. You should allow the release agent to dry thoroughly before pouring your mold.

#### Measure Iso Side A and Curative Side B

Make sure that Iso and Curative are at room temperature before mixing them. Please note that in cold weather it may take up to 24 hours for the Iso and Curative to reach room temperature. Using two clean, dry, plastic containers, measure correct amount of the Iso Side A and Curative Side B.

#### Mix Iso and Curative

After you prepare the master and mold housing and measure the Iso and Curative, you are ready to pour the Iso and Curative into another clean, dry, plastic mixing container. Scrape the Iso and Curative containers to move all of the material into the mixing container. Combine the two ingredients until no color striations are visible. Be sure to scrape the sides and bottom of the mixing container while mixing the two ingredients. You must mix the Iso and Curative completely so that BC 809 will cure correctly. If air bubbles form during mixing, you should vacuum degas the mixture for 2 to 3 minutes to remove them.



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#### Pour Mold

To ensure that no air bubbles form over the details of your master, you can brush a thin base coat onto the master and then pour the rest of the mixed BC 809. The best way to pour a mold is to tilt your mold slightly and pour into one spot at the corner of the mold, allowing the material to cover your master slowly like the flow of lava. When you have finished pouring the mold, you may lightly spray release agent on the top of BC 809 to break any air bubbles that have risen to the surface.

#### Demold and Cure Mold

Once you have poured your mold, allow the mold to cure 16 hours before demolding. To prolong the life of the mold, allow it to cure for 3–5 days before use.

#### Storage and Handling

Keep the BC 809 Side A and Side B containers tightly closed when not in use and store at temperatures between 70–80° F (21–26° C). Do not expose the Iso or Curative to moisture! If moisture contaminates BC 809 components, it will not cure properly. If these storage requirements are met, BC 809 carries a shelf life warranty of six months in original unopened containers.

**Be sure to read the *Material Safety Data Sheets* that come with BX-Amber.**

When working with this material please observe the following safety precautions.

- Wear safety glasses, chemical-resistant rubber or plastic gloves and an apron.
- Avoid contact with skin.
- In the case of skin contact, wipe affected area with isopropyl alcohol, followed by thorough washing with soap and water.
- In the case of eye contact, flush eyes with water for 15 minutes and consult a physician.
- If swallowed, drink one to two glasses of water and seek medical attention immediately.

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The conditions for your use and application of our products, technical assistance and information (whether verbal, written or by way of production evaluations), including any suggested formulations and recommendations, are beyond our control. Therefore, it is imperative that you test our products, technical assistance and information to determine to your own satisfaction whether they are suitable for your intended uses and applications. This application-specific analysis at least must include testing to determine suitability from a technical as well as health, safety, and environmental standpoint. BCC Products has not necessarily done such testing. All information is given without warranty or guarantee. It is expressly understood and agreed that customer assumes and hereby expressly releases BCC Products from all liability, in tort, contract or otherwise, incurred in connection with the use of our products, technical assistance and information. Any statement or recommendation not contained herein is unauthorized and shall not bind BCC Products. Nothing herein shall be construed as a recommendation to use any product in conflict with patents covering any material or its use. No license is implied or in fact granted under the claims of any patent.

