



**BCC PRODUCTS, INC.**

**BLEHM PLASTICS**

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

**KWIK-KAST/GRAY**

(GRAY)

**BC8645**

Urethane

NEW

BCC Kwik Kast/Gray is a two component, fast setting polyurethane reproduction plastic. **BC8645** has been reformulated to enhance filler suspension and avoid hard packing @ 77°F. Uses include; tracing models, core boxes, duplicating aids, patterns, prototypes, low temperature vacuum form tools, etc.

**Working Properties**

Mix Ratio (by weight or volume)	1 to 1
Color: Part A	Tan
Part B	Gray
Mixed	Gray
Mixed Viscosity (ASTM-D-2393)	2,075 cps
Brookfield (#3 spindle @ 20 rpm)	
Working Life, 25°C (77°F), 1lb. mass	5 - 6 minutes
Demold Time 25°C (77°F)	1 – 2 Hours

**Physical Properties**

Specific Gravity, Cured (ASTM D-792)	1.8-1.9
Cu. in./lb	15
Lbs/cu. in.	0.067
Hardness, Shore D (ASTM D-2240)	85
Flexural Strength (ASTM)	6,250
Tensile Strength (ASTM D-638)	4,875 psi
Compressive Strength (ASTM D-695)	9,600 psi
Linear shrinkage (ASTM D-2566)	0.0008 in/in
Wear Resistance (Tabor Method)	Very Good
Deflection Temp °F	174

**Handling Properties**

BCC's Kwik Kast/Gray is a fast-setting, two part casting system which requires careful preparation prior to mixing parts A and B. Because Kwik Kast/Gray contains components of high density there will be some separation at the bottom of each container. Using a paint shaker, jiffy mixer, or mixing spatula, re-suspension of the ingredients is easily accomplished. Precaution should be taken to prevent any moisture contamination from containers or utensils. It is recommended that the work area be well ventilated and normal cleanliness and safety rules be observed. Avoid prolonged exposure to vapors and contact with skin.

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**KWIK KAST/GRAY**

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Preparation of Mold Surface

Clean the surface from dust and possible presence of moisture. Apply **BC87** Parting Agent and polish to a uniform high gloss finish (usually 2-3 coats are recommended). For plaster or wood surfaces seal with PVC sealer to ensure complete absence of moisture, followed by 2-3 coats of **BC87** Parting Agent.

Mixing and Pouring

Although not necessary, best results are obtained by evacuation of each component under 29 inches of vacuum which removes entrapped air prior to blending the two components. Pour weighed or measured amounts of Part A & B into a separate dry container by pouring Part A into Part B. Mix with a spatula or mechanical stirrer for 30-40 seconds for quart size batches or 40-50 seconds for gallon batches while avoiding air entrapment. Immediately pour mixed resin uninterrupted from a convenient height above the mold cavity. Clean your mixing tools by rinsing in an alcohol type solvent. Larger masses (2 feet or more) may be built-up with successive pours. Castings may be demolded within 1 – 2 hours but should be properly supported while "green". Under normal conditions, maximum hardness or cure will be achieved in 12-18 hours.

**NOTE:** The information contained herein is believed to be reliable. All recommendations are made without guarantee inasmuch as conditions and methods of commercial use are beyond our control. Properties given are typical values and are not intended for use in preparing specifications.

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