



POLYTEK® DEVELOPMENT CORP.  
BCC PRODUCTS, INC.

## Technical Data Sheet BC-8405 Urethane Casting

White/Blue

**BC-8405** is an unfilled, low viscosity, quick setting two component urethane system. An easy to use 1 to 1 mix ratio (Part A/Part B), BC-8405 offers the user a rationable working time with parts demoldable in as little as 2 hours. When properly cured, BC-8405 will exhibit high impact strength and yield thermoplastic-like parts. Some outstanding features include the following:

- |                          |                                |
|--------------------------|--------------------------------|
| Mercury free             | High impact strength           |
| Moderate heat resistance | No objectionable odor          |
| 1 to 1 mix ratio         | Excellent finishing properties |
| Turns white upon cure    | Thermoplastic appearance       |
| Longer mold life         | More parts per day             |

### Working Properties

Mix Ratio (Part A/Part B)	100 to 100 by wt. 100 to 100 by vol.
Viscosity (ASTM D 2393-71)	
Part A	64 cps
Part B	480 cps
Mixed	190 cps
Color	
Part A	Amber
Part B	Opaque
Gel Time (200 gms) ASTM D 2471-71	15 Minutes
Demold Time @ 77°F (25° C)	2 – 4 Hours

### Physical Properties

Specific Gravity (ASTM D 792-66)	1.09
Cu. in./lb.	25.4
Hardness Shore D ASTM D 2240-66	75 ± 3
Color (Cured)	White
Ultimate Tensile Strength (ASTM D 638)	5,401 psi
Elongation (%) ASTM D 638	11.6

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Ultimate Flexural Strength ASTM D 790	9,011
Flexural Modulus ASTM 790	264,890
Impact Strength ASTM D 256 Izod Notched (ft. lbs./in.)	1.32
Deflection Temperature ASTM D 648	141°F
Linear Shrinkage ASTM D 2566	0.001

**DISCLAIMER:** The information contained herein is considered accurate; however, Polytek® Development Corp. makes no warranty regarding its accuracy. The user must determine the suitability of the product for the intended use and accepts all risk and liability associated with that use. For further details, review our standard Terms & Conditions of Sale.

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