



KWIK-KAST

(BLUE)

BC8650

Urethane

BC 8650 is an advanced fast cast polyurethane tooling system. BC 8650 features low viscosity, low exotherm and minimal shrinkage. Kwik Kast Blue cures hard, yet more durable resulting in less brittle parts. Designed for constructing patterns, prototypes, duplications, negatives, low temperature vacuum form tools, tracing models, etc.

Working Properties

Mix Ratio (by weight or volume)	1 to 1
Mixed Viscosity (1 minute)	2,360 cps
Brookfield (#2 spindle @ 20 rpm)	
Working Life, 24°C (75°F), 1 lb. mass	5 – 6 minutes
Color: Part A	Tan
Part B	Blue
Cured	Blue
Demold Time 24°C (75°F)	1 to 2 hours *

Physical Properties

Specific Gravity (cured) gms/cc	1.90
Lbs./cu.in.	0.069
Cu. In./lb.	14.6
Hardness, Shore D (ultimate)	83 ± 2
Flexural Strength	6,250 psi
Tensile Strength	4,120 psi
Compressive Strength	9,200 psi
Linear Shrinkage	0.0008 in/in

*Dependant upon size of casting

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Handling Properties

BCC's Kwik Kast Blue is a fast-setting, two part casting system which requires careful preparation prior to mixing parts A and B. Because Kwik Kast Blue 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.

Preparation of Mold Surface

Clean the surface from dust and possible presence of moisture. Apply BC 87 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 87 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 60-90 minutes 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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