



## **SLO-KAST**

(Black/Gray)

**BC8009**

Urethane

New BCC Slo-Kast is a low viscosity, medium setting, easy to use casting material. This polyurethane system features extremely low shrinkage when properly cured. Unlike Kwik-Kast, BC 8009 offers the user longer working time for filling large closed mold cavities. Slo-Kast is ideal for casting large sections without having to stage pour. Uses include; tracing models, core boxes, keller aids, patterns, core sticks, vacuum form tools, prototypes and display parts.

### **Working Properties**

Mix Ratio (by weight or volume)	1 to 1
Mixed Viscosity ASTM-D 2393 Brookfield (#3 spindle @ 20 rpm)	2,950 cps
Working Life, 25° C (77° F), 1 lb. mass	14 - 17 minutes
Demold Time 24° C (75° F)	3 1/2 - 4 hours *

### **Physical Properties**

Specific Gravity, Cured (ASTM D-792)	1.8 – 1.9
Lbs/cu. in. (average)	0.067
Cu. in./lb (average)	15
Hardness, Shore D ASTM D-2240	85
Tensile Strength ASTM D-638-69	5,850 psi
Compressive Strength ASTM-D-695	8,800 psi
Linear Shrinkage ASTM D-2566	0.0002 in/in **

\*Dependant upon wall thickness of casting

\*\* Results obtained from a 24 hour demold

### Handling Properties

BCC's Slo-Kast is a moderately fast-setting, two part casting system (Part A & Part B). If settling from long storage has occurred, re-mix contents of each container on a mechanical Paint shaker, Jiffy Mixer or other suitable mixing equipment. Precautions should be taken to avoid moisture contamination. Use dry equipment and containers and keep covered when not in use. 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

Pour weighed or measured amounts of Part A & B into a separate dry container by pouring Part A into Part B. Mix with spatula or mechanical stirrer for one (1) minute for quart size batches or two (2) minutes for gallon batches. After mixing both parts allow container to sit undisturbed 3-4 minutes before pouring. This "induction time" will result in superior surface qualities of the cast piece. Pour mixed resin uninterrupted from a convenient height above the mold cavity to resist air bubble entrapment. 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 in as little as 3 1/2-4 hours, but should be supported while "green". If partially cured casting is disturbed, a surface film may result. This is easily removed by wiping with mineral spirits or lacquer thinner. Under normal conditions, maximum hardness or cure will be achieved in 24-48 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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