# BCC Resins BC 8009

Polyurethane

BCC Products Inc.

## Message:

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 (15 minutes for filling closed mold cavities and up to 25 minutes when casting into open molds). Slo-Kast is ideal for casting large sections without having to stage pour. Uses included; tracing models, core boxes, keller aids, patterns, core sticks, vacuum form tools, prototypes and display parts.
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. Precaution should be taken to prevent any 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 a spatula or mechanical stirrer for 1 minute for quart size batches or 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 3.5-4 hours, but should be properly 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.

| General Information | | | |
|---|---|---|---|
| Features | Low Shrinkage<br>Low Viscosity | | |
| Uses | Prototyping | | |
| Appearance | Black<br>Grey | | |
| Forms | Liquid | | |
| Processing Method | Casting | | |
| **Physical** | **Nominal Value** | **Unit** | **Test Method** |
| Specific Gravity | 1.67 | g/cm³ | ASTM D792 |
| Molding Shrinkage - Flow | 0.020 | % | ASTM D955 |
| **Hardness** | **Nominal Value** | **Unit** | **Test Method** |
| Durometer Hardness (Shore D) | 83 | | ASTM D2240 |
| **Mechanical** | **Nominal Value** | **Unit** | **Test Method** |
| Tensile Strength (Break) | 40.3 | MPa | ASTM D638 |
| Compressive Strength | 60.7 | MPa | ASTM D695 |
| **Thermal** | **Nominal Value** | **Unit** | **Test Method** |
| Deflection Temperature Under Load (1.8 MPa, Unannealed) | 78.3 | °C | ASTM D648 |
| **Thermoset** | **Nominal Value** | **Unit** | **Test Method** |

| | | | |
|---|---|---|---|
| Thermoset Components | | | |
| Hardener | Mix Ratio by Weight: 1.0, Mix Ratio by Volume: 1.0 | | |
| Resin | Mix Ratio by Weight: 1.0, Mix Ratio by Volume: 1.0 | | |
| Pot Life (25°C) | 15 to 25 | min | |
| Thermoset Mix Viscosity | 2250 | cP | ASTM D2393 |
| Demold Time (24°C) | 210 to 240 | min | |



## Recommended distributors for this material

### Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

WECHAT