



Polytek® Urethane Resins

Technical Reference Chart

Series	Product	Mix Ratio by Volume	Mix Ratio by Weight	Shore Hard- ness	Pot Life (1- lb mix)	Demold Time* @ 73°F unless otherwise noted	Cured Color	Mixed Viscosity (cP)	Specific Volume (in ³ /lb)	Specific Gravity	Linear Shrinkage (in/in)	Elonga- tion (%)	Max Exotherm (°F)	Heat De- flection Temp. (°F)	Tensile Strength (psi)	Elastic Modulus (psi)	Flexural Modulus (psi)	Flexural Strength, 5% Strain (psi)
EASYFLO SERIES Fast-Setting, Low- Viscosity Polyurethane Resins	EasyFlo 60	1A:1B	100A:90B	D65	2-2.5 min.	15-30 min.	White	60	26.9	1.03	0.0041	13.9	230	149	2,936	72,627	93,112	3,915
	EasyFlo 90	1A:1B	100A:90B	D70	5 min.	60-120 min.	White	200	26.1	1.06	<0.001	5.1	175	164	4,387	134,685	157,356	6,125
	EasyFlo 120	1A:1B	100A:90B	D65	2-2.5 min.	15-30 min.	Off- White	120	26.9	1.03	0.0065	10.3	200	146	3,534	85,149	133,765	4,845
	EasyFlo Black	1A:1B	1A:1B	D70	1.5-2 min.	10-15 min.	Black	200	26.4	1.05	0.008	6.3	245	197	3,835	76,056	120,904	5,521
	EasyFlo Clear	1A:1B	100A:85B	D72	2-2.5 min.	15-30 min.	Amber	110	25.5	1.08	0.0154	7.7	208	133	4,091	97,532	165,733	6,007
	EasyFlo 100 FR	1A:1B	1A:1B	D65	2-2.5 min.	15-30 min.	Off- White/ Tan	120	25.2	1.10	0.0065	9	200	165	3,170	85,928	117,878	4,284
POLY 15- SERIES High-Strength Resins	Poly 15-3	N/A	1A:1B	D80	15 min.	12-16 hr.	Tan	2,000	18	1.53	0.0006	2.6	125	ND	3,509	202,276	479,648	5,232
	Poly 1511	N/A	1A:1B	D71	10 min.	1-16 hr.	White	400	25.1	1.10	0.0044	5.4	251	142	6,712	118,352	241,223	10,046
	Poly 1512	N/A	1A:1B	D71	22 min.	1-16 hr.	White	400	25.1	1.10	0.0034	5.4	251	142	6,712	118,352	241,223	10,046
	Poly 1512X	N/A	1A:1B	D71	5 min.	0.5-4 hr.	White	400	25.1	1.10	0.0048	5.4	251	142	6,712	118,352	241,223	10,046
KAST-SERIES High- Performance Tooling Resins	BC-8002 Kwik-Kast	1A:1B	1A:1B	D85	5-6 min.	1-2 hr.	Gray	2,350	15	1.8-1.9	0.0008	ND	ND	179	4,900	ND	ND	6,700
	BC-8655 Kwik-Kast	1A:1B	1A:1B	D83	8-10 min.	1-2 hr.	Blue	2,120	14.6	1.9	0.0008	ND	ND	177	4,120	ND	ND	6,250
	BC-8009 Slo-Kast	1A:1B	1A:1B	D85	14-18 min.	3-4 hr.	Gray	2,250	15	1.8-1.9	0.0002	ND	ND	173	5,850	ND	ND	6,900
POLY-OPTIC® 14- SERIES Water-Clear Resins	Poly-Optic 1411	1A:1B	100A:90B	D80	9 min.	30 min. (0.5" thick)	Water Clear	600	25.8	1.07	0.0018	7	228	138	6,083	133,956	250,992	8,478
	Poly-Optic 1412	1A:1B	1A:1B	D80	8 min.	30 min. @ 175°F	Water Clear	750	25.8	1.07	0.0019	11.1	235	227	9,825	179,886	295,101	12,261
	Poly-Optic 1420	N/A	2A:1B	D85	15 min.	8 hr @ 150°F 30 min. @ 175°F	Water Clear	250	26.3	1.05	ND	5.3	311	168	7,900	171,500	250,000	12,600
	Poly-Optic1430 RTV	1A:1B	1A:1B	A35	200 min.	24 Hrs	Water Clear	300	27.4	1.01	ND	ND	79	ND	ND	ND	ND	ND
SPECIALTY	Poly Plasti-Flex (FLEXIBLE RESIN)	N/A	35A:100B	A90	3 min.	15 min.	Tan	3,000	34	0.81	ND	81	190	N/A	1,330	29,450	N/A	N/A

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*Demold time varies with thickness of casting and the amount of accelerator used.

ND = Not Determined | N/A = Not Applicable