



Description GTP *KastStone* is a two component, ceramic filled, rapid setting urethane molding compound. When fully cured, GTP *KastStone* attains high compression and heat distortion characteristics, which makes it ideal for patterns, or prototype models. GTP *KastStone*'s high ceramic filler loading also adds some unusual insulation qualities.

Application Mold surfaces should be clean and free of dust and moisture. An even coat of silicone mold release (Ease Release 2251) is applied taking care to avoid puddling or drips. Porous surfaces (plaster or wood) must be completely sealed using sand and sealer or Johnson's Paste Wax.

GTP *KastStone* is a rapid setting, two components having high ceramic filler loading and requires special preparation before using. Component A and B typically must be premixed prior to combining for final mixing.

Mix Ratio Proper mixing can be made using a spatula or jiffy mixer. Mixing of the ceramic filler and liquid resin should be done by carefully scraping the sides and bottom of the container to attain an even mixture. Components A and B should be used immediately to avoid separation or moisture contamination. Measure out equal portions by volume of Component A and Component B. Mix with spatula or jiffy mixer (for larger batches). Pour mixed resin into prepared mold. Allow curing 30 to 45 minutes before demolding. GTP *KastStone* is fully cured in 24 hours.

Typical Properties	Viscosity	Specific Gravity	Weight Per Gallon
Component A	1000 cps	0.80	6.67 lb.
Component B	2100 cps	0.70	5.81 lb.
Mixed	1500 cps	0.75	6.24 lb.
Mixing Ratio	By volume		1 part A to 1 part B
	By weight		100 parts A to 87 parts B
Work life			3-5 minutes @ 72° F
Demold time			1 hour-thin walled parts, 10-20 minutes-thicker cross section
			Set time and Demold depend on temperature and relative humidity

Physical Properties	Test Method	Value
Hardness	ASTM 2240	65 Shore D
Tensile strength	N/A	3500
Elongation	N/A	1 %
Density		0.88
Weight (cubic inch)		0.032 lb. (14.53 gram)
Shrinkage (thicker cross section may be more)		0.125 %
Color		Light Gray

Shelf Life GTP *KastStone* is shipped from the factory in sealed containers. The containers should be stored in a cool, dry area that is protected from direct sunlight and moisture. Storage temperatures should not exceed 80° F. The shelf life of factory sealed containers stored under these conditions is six months. Containers that have been opened should be resealed immediately after material has been removed in order to prevent solvent evaporation.

Packaging GTP *KastStone* is available in convenient 2-quart, 2-gallon, 8-gallon and 96-gallon kits. GTP *KastStone* has a non-hazardous rating for shipping.