



TC-1618 A/B

ALUMINUM FILLED HI-TEMP EPOXY SURFACE COAT

DESCRIPTION:

TC-1618 A/B is an aluminum filled hi-temp epoxy surface coat that provides a tough 90 Shore D surface. This resin compound can be applied with a brush, to a thickness of 1/16" on vertical surfaces or over sharp corners without sag or run-off. TC-1618 A/B features excellent heat resistance with ability to handle constant use at temperatures up to 300°F (149°C). This system does not contain "MDA" or "VCHD".

PHYSICAL PROPERTIES:

Hardness, Shore D ASTM D-2240	90
Density, (g/cc) ASTM D-792	1.7
Cubic Inches per Pound	16.6
Color/Appearance.....	Gray/Opaque
Tensile Strength, (psi) ASTM D-638	7,200
Tensile Modulus, (psi) ASTM D-638	5.4 x 10 ⁵
Flexural Strength, (psi) ASTM D-790	14,100
Flexural Modulus, (psi) ASTM D-790.....	7.4 x 10 ⁵
Heat Deflection Temp @ 264 (psi) ASTM D-648	245°F (118°C)
Compressive Strength, (psi) ASTM D-695.....	28,000
Coefficient of Thermal Expansion, (in/in°F) ASTM D-696	2.36 x 10 ⁻⁵

HANDLING PROPERTIES:

Mix Ratio (by weight):

Part A	100 parts by weight
Part B	10 parts by weight

Mix Ratio (by volume):

Part A	100 parts by volume
Part B	18 parts by volume

Specific Gravity:

Part A	1.74
Part B	0.98

Viscosity, (cps) @ 77°F (25°C) Brookfield:

Part A.....	155,000
Part B	150
Mixed.....	54,000

Color:

Part A	Gray
Part B	Amber

Work Time, (1 lb. mass) @ 77°F (25°C)..... 45 minutes

Gel Time

Demold Time @ 75°F (24°C)..... 12 - 20 hours

POST CURE:

All physical properties are based upon post-curing this system. The following procedure provides the best results:

- 1) 150°F (66°C) for 1.5 to 2 Hours
- 2) 250°F (121°C) for 2 Hours
- 3) 300°F (149°C) for 2 Hours

Allow to cool in the oven. This procedure further stabilizes and eliminates possible thermal shocks for cavity tools that are temporarily clamped together for curing purposes. Rapid heat up and cooling can effectively be used after the initial post-cure process is completed.

PACKAGING:

Quart Kits.....2 lbs. A, 3.2 oz.B
 Gallon Kits..... 10 lbs. A, 1 lb. B
 5 Gallon Kits.....50 lbs. A, 5 lbs. B

STORAGE

Store at 55° - 90°F (13° - 32°C) in a dry location. Unopened containers will have a shelf life of 12 months from shipping date when properly stored at room temperature. Keep containers tightly sealed after use.

SAFETY PRECAUTIONS:

Use in a well-ventilated area. Avoid contact with skin using protective gloves and protective clothing. Repeated or prolonged contact on the skin may cause an allergic reaction.

Eye protection is extremely important. Always use approved safety glasses or goggles when handling this product.

IF CONTACT OCCURS:

Skin: Immediately wash with soap and water. Remove contaminated clothing and launder before reuse. It is *not* recommended to remove resin from skin with solvents. Solvents only increase contact and dry skin. Seek qualified medical attention if allergic reactions occur.

Eyes: Immediately flush with water for at least 15 minutes. Call a physician

Ingestion: If swallowed, call a physician immediately. Remove stomach contents by gastric suction or induce vomiting only as directed by medical personnel. Never give anything by mouth to an unconscious person.

Refer to the Material Safety Data Sheet before using this product.

NON-WARRANTY "Except for a warranty that materials substantially comply with the data presented in Manufacturer's latest bulletin describing the product (the basis for this substantial compliance is to be determined by the standard quality control tests generally performed by Manufacturer), all materials are sold "AS IS" and without any warranty express or implied as to merchantability, fitness for a particular purpose, patent, trademark or copyright infringement, or as to any other matter. In no event shall Manufacturer's liability for damages exceed Manufacturer's sale price of the particular quantity with respect to which damages are claimed."