



EPOXY RESIN SYSTEMS

"Dedicated to QUALITY, SERVICE, SAFETY, and INNOVATION"

TC-1622 A/B
LOW VISCOSITY HIGH TEMPERATURE
EPOXY LAMINATING RESIN

PRODUCT DESCRIPTION:

TC-1622 A/B is an unfilled laminating resin for high temperature mold and part fabrication formulated to provide superior wet-out and adhesion to a variety of substrates. It is a great material for Vacuum Assisted Resin Transfer Molding (VARTM) as well as other wet lay-up methods due to its low viscosity and long working time. When properly cured TC-1622 A/B can be used for prolonged periods at 350°F (177°C) and can be used at temperatures to 400°F (204°C) intermittently.

PRODUCT HIGHLIGHTS:

- Ideal for VARTM lay-up method
• Easy to use for lay-ups requiring vacuum bagging
• Withstands temperatures to 350° F (177° C)
• Seals porous surfaces with excellent adhesion

PHYSICAL PROPERTIES:

Table with 2 columns: Property and Value. Properties include Hardness, Density, Cubic Inches per Pound, Color/Appearance, Tensile Strength, Tensile Modulus, Elongation, Flexural Strength, Flexural Modulus, Shrinkage, and Izod Impact.

Note: Reported physical properties based on elevated temperature cured test specimens.

HANDLING PROPERTIES:

Mix Ratio (by weight):

Table with 2 columns: Part and Ratio. Part A: 100 parts by weight, Part B: 20 parts by weight.

Mix Ratio (by volume):

Table with 2 columns: Part and Ratio. Part A: 100 parts by volume, Part B: 23 parts by volume.

HANDLING PROPERTIES (continued):

Specific Gravity @ 77°F (25°C):	
Part A	1.13
Part B	0.98
Viscosity, (cps) @ 77°F (25°C) Brookfield:	
Part A	550
Part B	250
Mixed.....	600
Work Time, (100-gram mass) @ 77°F (25°C).....	2 hours
Gel Time	2.5 hours
Demold Time @ 77°F (25°C).....	24 hours

POST CURING:

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

- 150° F (66° C) for 1.5 to 2 hours
- 250° F (121° C) for 2 hours
- 300° F (149° C) for 1 hour
- 350° F (177° C) for 1 hour

Allow to cool in the oven. This procedure provides further stabilization and eliminates possible thermal shocks for cavity tools that are temporarily clamped together for curing purposes.

PACKAGING:

Gallon Kits	9 lbs. A, 1.8 lbs. B
5-Gallon Kits.....	40 lbs. A, 8 lbs. B
Drum Kits	400 lbs. A, 80 lbs. B

STORAGE:

Store in a cool dry place. Unopened containers will have a shelf life of 12 months from date of shipment when properly stored at room temperatures. Purge opened containers with dry nitrogen before re-sealing.

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."