



EPOXY RESIN SYSTEMS

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

TC-4410 A/B
HI IMPACT FILLED CASTING EPOXY SYSTEM

PRODUCT DESCRIPTION:

TC-4410 A/B is an 82 - 87 Shore D hardness, non-metallic filled epoxy casting system that features excellent surface lubricity and impact resistance. TC-4410 A/B is generally used at ratio of 100 PBW "A" to 40 PBW "B" to develop the ultimate hardness. For applications requiring a lower hardness, the mix ratio of components can be changed which in turn will change hardness. (See Ratio Range Chart, Page 2)

TYPICAL APPLICATIONS:

- Cold metal forming dies
Non-galling stretch form die faces
Drop hammer die bases-drop hammer die cores
Core boxes
Tracing pattern surface
N/C machine proofing medium

PHYSICAL PROPERTIES: (Using a ratio of 100 PBW A to 40 PBW B)

Table with 2 columns: Property and Value. Properties include Hardness, Tensile Strength, Modulus, Flexural Strength, Shrinkage, Heat Deflection Temperature, and Compressive Strength.

HANDLING PROPERTIES:

Mix Ratio (See Ratio Range Chart, Page 2):

Table with 2 columns: Component and Ratio/Time. Components include Part A, Part B, Mixed Viscosity, Work Time, and Cure Time.

RATIO RANGE SHORE D HARDNESS:

<u>RATIOS</u>	<u>18 HRS</u>	<u>24 HRS</u>	<u>3 WKS</u>
100/40 PBW	78	81	87
100/50 PBW	80	80	85
100/60 PBW	77	79	82

PACKAGING:

Packaging is set-up for a ratio of 100/50.

5-Gallon kits40 lbs. A, 20 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.