



# TC-4485 A/B

## IRON-FILLED EPOXY MASS CASTING SYSTEM

### PRODUCT DESCRIPTION:

TC-4485 A/B is a room temperature curing, mass castable epoxy resin system that produces a tough, dense, low shrink solid material with fine detail reproduction. TC-4485 A/B is designed for single-pour castings up to 3" thick, or for thicker castings up to 8" using a stage pour procedure.

### TYPICAL PRODUCT USES:

- Molds
- Patterns
- Cast Parts
- Form Dies

### PRODUCT HIGHLIGHTS:

- Slower reacting system designed for thicker casts
- Improved viscosity for easier pouring

### PHYSICAL PROPERTIES:

Hardness, Shore D ASTM D-2240 .....	85
Specific Gravity, ASTM D-792.....	2.1
Density, (lb./cu.ft.) ASTM D-792 .....	130
Displacement, (cu.in. /lb.) ASTM D-792 .....	13.1
Compressive Strength, (psi) ASTM D-695.....	13,320
Flexural Strength, (psi) ASTM D-790.....	9,450
Flexural Modulus, (psi) ASTM D-790.....	$3.2 \times 10^5$
Tensile Modulus, (psi) ASTM D-638 .....	$5.2 \times 10^7$
Izod Impact, (ft.-lb./in.) ASTM D-256.....	2.0
Shrinkage, (in./in.) ASTM D-2566.....	<0.001
Coefficient of Thermal Expansion (in./in./°F) .....	$3.0 \times 10^{-5}$

### HANDLING PROPERTIES:

Mix Ratio (by weight):	
Part A .....	100 parts by weight
Part B.....	8 parts by weight
Viscosity (cps):	
Part A .....	278,000
Part B.....	71
Initial Mixed Viscosity .....	42,500
Mixed Viscosity, (centistokes) .....	20,240
Gel Time @ 77°F (25°C) .....	3 ± ½ hour
Demold Time @ 77°F (25°C).....	16-24 hours
Cure Time @ 77°F (25°C) .....	3-5 days

**PACKAGING:**

5 Gallon Kit (pre-weighed)..... 60 lbs. A, 5 lbs. B

**STORAGE:**

Store at 55°-90°F (13°-32°C) in a dry location. Unopened containers will have shelf life of 12 months 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. 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.**