



TC-800 A/B

75 SHORE D POLYURETHANE CASTING SYSTEM

WHITE

PRODUCT DESCRIPTION:

TC-800 A/B is an easy to use rigid urethane casting material. TC-800 A/B exhibits excellent physical properties, very low viscosity, high heat capability and quick demold times. In addition, this system is economically priced. The one-to-one volume ratio makes it perfect for use with dispensing equipment. TC-800 A/B is a great product when ABS-type parts with a quick turnaround are required. Features a non-mercury based catalyst system.

PHYSICAL PROPERTIES:

Hardness, Shore D ASTM D2240	75 ± 2
Density, (g/cc) ASTM D792	1.11
Color/Appearance.....	Opaque White
Cubic Inches per Pound	25.7
Tensile Strength, (psi) ASTM D638.....	6,100
Tensile Modulus, (psi) ASTM D638	1.9 x 10 ⁵
Elongation, (%) ASTM D638	8
Flexural Strength, (psi) ASTM D790	9,250
Flexural Modulus, ASTM D790.....	2.3 x 10 ⁵
Shrinkage, (in/in) linear 12" x 1/2" x 1/2"	0.007
Izod Impact, (ft-lb/in) notched ASTM D256.....	0.5
Heat Deflection Temperature ASTM D648:	
@ 66 psi.....	185°± 5°F (85°± 3°C)
@ 264 psi.....	160°± 5°F (71°± 3°C)

HANDLING PROPERTIES:

Mix Ratio (by weight):	
Part A	100 parts by weight
Part B	88 parts by weight
Mix Ratio (by volume):	
Part A	100 parts by volume
Part B	100 parts by volume
Specific Gravity:	
Part A	1.15
Part B	1.01
Viscosity, (cps) @ 77°F (25°C) Brookfield:	
Part A	60
Part B	375
Mixed.....	200

HANDLING PROPERTIES (continued):

Color:

Part A	Clear pale yellow
Part B	Clear/colorless
Work Time, (100-gram mass) @ 77°F (25°C).....	2 minutes
Demold Time @ 77°F (25°C).....	60 minutes

CURE SCHEDULE/HEAT CURING:

Most of the physical properties can be achieved in 5-7 days at ambient temperature, 77°F (25°C). In order to achieve maximum physical properties, a post cure with heat is required. BJB recommends 24 hours at ambient temperature, 77°F (25°C), followed by 16 hours at 180°F (82°C). Support of the part may be required to prevent part deformation during the heat curing process.

STORAGE:

Store in a cool dry place. Unopened containers will have a shelf life of 6 months from date of shipment when properly stored at room temperature. Purge opened containers with dry nitrogen before re-sealing.

PACKAGING:

Gallon kits.....	8 lbs. A, 7.1 lbs. B
5 Gallon kits.....	40 lbs. A, 35.2 lbs. B
Drum kits	400 lbs. A, 352 lbs. B

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."