



RIGID FILLED & UNFILLED URETHANES

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

**TC-816 A/B
GRAY FAST CAST URETHANE
FOR TOOLING AND PARTS**

PRODUCT DESCRIPTION:

TC-816 A/B is a durable, filled polyurethane system that offers excellent duplication properties. TC-816 A/B exhibits low shrink, low exotherm and quick demold times.

PRODUCT HIGHLIGHTS:

- Exceptionally low viscosity
- Workable in semi-gel stage as a paste if desired
- Low exotherm contributing to low shrinkage
- Will readily bond to itself
- Greater settling resistance
- Integrates well with epoxy surface coats for polishable tools
- Safe to use with platinum based silicones

PHYSICAL PROPERTIES:

Hardness, Shore D ASTM D2240	85±2
Density, (g/cc) cured ASTM D792.....	1.62
Cubic Inches per Pound.....	17.2
Color/Appearance.....	Gray/Opaque
Shrinkage, (in/in) linear ASTM D2566.....	0.004
Compressive Strength, (psi) ASTM D695.....	9,200

HANDLING PROPERTIES:

Mix Ratio (by weight or volume):	
Part A	100 parts by weight or volume
Part B	100 parts by weight or volume
Specific Gravity:	
Part A	1.6
Part B	1.6
Mixed Viscosity, (cps) @ 77°F (25°C) Brookfield.....	1,000
Color:	
Part A	Black
Part B	White
Work Time, (1-lb. mass) @ 77°F (25°C)	5 minutes
Demold Time, (mass dependent) @ 77°F (25°C).....	1 - 2 hours

MIXING INSTRUCTIONS:

TC-816 A/B settles on standing but is easily remixed. Thoroughly mix cans A and B separately, preferably with a Jiffy Mixer. Then combine equal parts of A and B by weight or volume. Mix thoroughly for not more than 30 seconds and pour promptly. Do not mix in the original containers. Polyethylene mixing pails are excellent and may be reused. Be sure all material on the sides and bottom are well mixed. After each use, cans should be purged with dry nitrogen and tightly sealed to prevent moisture in the air from reacting with the contents.

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 temperatures. Purge opened containers with dry nitrogen before re-sealing.

PACKAGING:

Gallon Kits..... 10 lbs. A, 10 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.