



TC-865 A/B

65 SHORE D URETHANE CASTING SYSTEM

PRODUCT DESCRIPTION:

TC-865 A/B is a medium viscosity, economical and easy to handle two component urethane compound. This system cures relatively fast at room temperature producing tough, impact resistant castings. TC-865 A/B is recommended in applications where a resilient surface hardness is desired while maintaining good flexibility.

PHYSICAL PROPERTIES:

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|---|--------|
| Hardness, Shore D ASTM D2240 | 65 ± 2 |
| Density, (g/cc) ASTM D792 | 1.15 |
| Cubic Inches per Pound | 24 |
| Tensile Strength, (psi) ASTM D638 | 2,475 |
| Tensile Modulus, (psi) ASTM D638 | 99,000 |
| Elongation, (%) ASTM D638 | 70 |
| Flexural Strength, (psi) ASTM D790 | 2,875 |
| Flexural Modulus, (psi) ASTM D790 | 92,850 |
| Tear Strength, (pli) ASTM D624 | 585 |
| Izod Impact, notched (ft-lb/in) ASTM D256 | 0.85 |
| Shrinkage, (in/in) linear (12" X ½" X ½") | 0.005 |

HANDLING PROPERTIES:

Mix Ratio (by weight):

| | |
|--------------|---------------------|
| Part A | 100 parts by weight |
| Part B | 100 parts by weight |

Mix Ratio (by volume):

| | |
|--------------|---------------------|
| Part A | 100 parts by volume |
| Part B | 95 parts by volume |

Specific Gravity:

| | |
|--------------|------|
| Part A | 1.13 |
| Part B | 1.18 |

Viscosity, (cps) @ 77°F (25°C) Brookfield:

| | |
|--------------|-------|
| Part A | 1,350 |
| Part B | 1,500 |
| Mixed | 1,400 |

Color:

| | |
|--------------|-------------|
| Part A | Pale yellow |
| Part B | Cream |

HANDLING PROPERTIES (continued):

Work Time, (100-gram mass) @ 77°F (25°C).....10 minutes
Demold Time @ 77°F (25°C)..... 3 hour minimum, ½” thick sections; 2 hours or less in mass castings

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 160°F (71°C).

PIGMENTING:

TC-865 A/B naturally produces light cream colored parts, but may be easily tinted to any color from light pastels to deep tones using BJB's 6000 Series pigments. The 6000 Series pigments are dispersions which can be used to a maximum of 2% to the total weight of the TC-865 A/B. Dry pigments, such as fluorescent colors, may also be used. Recommended levels of dry pigments are 5 - 10% to the total weight of the TC-865 A/B system.

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..... 8 lbs. A, 8 lbs. B
5 Gallon Kits..... 40 lbs. A, 40 lbs. B
55-Gallon Drum Kits 400 lbs. A, 400 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 emergency 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."