



TC-886 A/B FR
RIGID 78 SHORE D POLYURETHANE CASTING SYSTEM
FIRE RETARDANT

PRODUCT DESCRIPTION:

TC-886 A/B FR produces a high impact rigid 78 Shore D material that is commonly used to make computer housings, models of all kinds, artwork, and can also be used for electronic component enclosures. It provides a working time of 15 minutes.

PRODUCT HIGHLIGHTS:

- Non-mercury based catalyst system
Odorless, clean white color
Three to four hour demold time
Excellent for vacuum or pressure casting
Low viscosity
UL 94 V0 Flammability Rating at 0.125" thickness

PHYSICAL PROPERTIES:

Table with physical properties: Hardness, Density, Cubic Inches per Pound, Color/Appearance, Tensile Strength, Tensile Modulus, Elongation, Flexural Strength, Flexural Modulus, Shrinkage, Izod Impact, Heat Deflection Temperature, Ball Pressure Test.

Note: Reported physical properties based on elevated temperature cured test specimens.

HANDLING PROPERTIES:

Table with handling properties: Mix Ratio (by weight), Mix Ratio (by volume), Specific Gravity.

HANDLING PROPERTIES (continued):

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

Part A	75
Part B	3,500
Mixed	350

Color:

Part A	Pale yellow
Part B	White

Work Time, (100 gram mass) @ 77°F (25°C) 15 minutes
Gel Time 18 minutes
Demold Time @ 77°F (25°C)..... 3 - 4 hours

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 heat cure.

VACUUM DE-GASSING/ DE-AIRING:

It is advisable to evacuate entrapped air prior to casting this system. The use of a de-airing agent, (BJB’s AF-7) will aid in this process when either de-airing the combined A/B mixture or when de-airing the “A” and “B” components separately.

NOTE:

TC-886 A/B FR with its non-mercury catalyst system does exhibit greater sensitivity to moisture than do similar products that use mercury-containing catalysts. If further information is required, please contact BJB’s technical staff for assistance.

STORAGE:

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

PACKAGING:

Gallon Kits.....	8 lbs. A, 6.8 lbs. B
5 Gallon Kits.....	40 lbs. A, 34 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."