



# TC-895 A/B BLACK

## RIGID 84 SHORE D HIGH HEAT RESISTANT POLYURETHANE CASTING SYSTEM

### PRODUCT DESCRIPTION:

TC-895 A/B BLACK is a RoHS compliant, non-mercury based catalyst polyurethane system that produces a tough 84 shore D material. This system has an extremely high heat deflection temperature which in some cases can be post cured without having to use fixtures.

### PRODUCT HIGHLIGHTS:

- High heat resistance
- Non-mercury
- RoHS compliant
- Working time of 6 - 7 minutes

### PHYSICAL PROPERTIES:

Hardness, Shore D ASTM D2240-04e1 .....	84 ± 2
Density, (g/cc) ASTM D792-00 .....	1.22
Cubic Inches per Pound .....	24
Color/Appearance.....	Black

### Cure Schedule 1 (see page 2):

Tensile Strength, (psi) ASTM D638-03 .....	10,300
Tensile Modulus, (psi) ASTM D638-03.....	2.93 x 10 <sup>5</sup>
Elongation, (%) ASTM D638-03.....	9.1
Flexural Strength, (psi) ASTM D790-03.....	12,700
Flexural Modulus, (psi) ASTM D790-03 .....	3.17 x 10 <sup>5</sup>
Shrinkage, (in/in) linear 12"x 1/2"x 1/2" .....	0.008
Izod Impact, notched (ft-lb/in) ASTM D256-05 .....	0.88
Heat Deflection Temperature, ASTM D648-04:	
66 psi.....	340°F (171°C)
264 psi.....	218°F (103°C)
Coefficient of Thermal Expansion, (in/in/°F) ASTM E831-06.....	73.1 x 10 <sup>-6</sup>

### Cure Schedule 2 (see page 2):

Tensile Strength, (psi) ASTM D638-03 .....	10,400
Tensile Modulus, (psi) ASTM D638-03.....	2.87 x 10 <sup>5</sup>
Elongation, (%) ASTM D638-03.....	9.8
Flexural Strength, (psi) ASTM D790-03.....	12,200
Flexural Modulus, (psi) ASTM D790-03 .....	3.03 x 10 <sup>5</sup>
Shrinkage, (in/in) linear 12"x 1/2"x 1/2" .....	0.005
Izod Impact, notched (ft-lb/in) ASTM D256-05 .....	0.95
Heat Deflection Temperature, ASTM D648-04:	
66 psi.....	290°F (143°C)
264 psi.....	213°F (101°C)

**HANDLING PROPERTIES:**

Mix Ratio (by weight or volume):

Part A ..... 100 parts by weight or volume  
Part B ..... 50 parts by weight or volume

Specific Gravity:

Part A ..... 1.16  
Part B ..... 1.16

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

Part A ..... 1,000  
Part B ..... 650  
Mixed ..... 850

Color:

Part A ..... Pale yellow  
Part B ..... Black

Work Time, 100g mass @ 77°F (25°C) ..... 6 - 7 minutes

Gel Time ..... 7 - 8 minutes

Demold Time:

@ 77°F (25°C) ..... 5 - 6 hours  
@ 150°F (66°C) ..... 1 hour

**CURE SCHEDULE 1:**

To achieve maximum physical properties, the material should be preconditioned to 77°F (25°C) and the mold approximately to 120°F (49°C). After casting the material the mold should be placed into a 150°F (66°C) oven and left for 1 hour. After 1 hour the part can be demolded and then post cured with heat for 16 hours at 180°F (82°C). Support of the part in some cases may be required to prevent part deformation during the heat curing process.

**CURE SCHEDULE 2:**

Most of the physical properties can be achieved when casting this product at room temperature then followed with a post cure.

Precondition the material and molds to 77°F (25°C). After casting, leave the part at room temperature for 16 – 24 hours followed with a post cure for an additional 16 hours at 180°F (82°C). Support of the part in some cases may be required to prevent part deformation during the heat curing process.

Note: To obtain higher heat deflection temperatures and faster demold times, it is advised to use heat during the casting process.

**NOTE #1:**

It is advisable whenever possible to evacuate entrapped air prior to casting this system. The use of a de-airing agent can speed up the process. BJB's AF-4 antifoam works best as the de-airing agent. In conjunction with these support products BJB offers pigments in a wide variety of colors and stainless steel mixers called "Jiffy Mixers". For additional information on the use of this product, refer to BJB Guidelines for Handling Polyurethane Products. If further information is required, please call BJB's technical staff for assistance.

**NOTE #2:**

The natural color of TC-895 A/B is a translucent pale yellow. When the cured material is exposed to direct sunlight or strong UV light, the material will turn to an orange color within approximately 2 hours. TC-895 A/B can be special ordered in its natural color. 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 date of shipment when properly stored at room temperatures. Purge opened containers with dry nitrogen before re-sealing.

**PACKAGING:**

Gallon Kits .....	8 lbs. A, 4 lbs. B
5-Gallon Kits .....	40 lbs. A, 20 lbs. B
55-Gallon Drum Kits .....	400 lbs. A, 200 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."