



1130 International Pkwy
Fredericksburg, VA 22406
540-286-2266
www.artcorp.com



SHORE A POLYURETHANES

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

TC-460 A/B

60 SHORE A POLYURETHANE ELASTOMER

PRODUCT HIGHLIGHTS:

TC-460 A/B is a multi-purpose elastomer system that can perform many functions. Product characteristics are:

- ✓ Cures at room temperature to produce a strong, resilient elastomer
- ✓ Easy to use
- ✓ Exudate and volatile free
- ✓ Maintains a dry, tack free surface after cure

PHYSICAL PROPERTIES:

Hardness, Shore A, ASTM D 2240-04e1	60	5
Density, (g/cc) ASTM D 792-00	1.07	
Cubic Inches per Pound.....	26.4	
Color/Appearance.....	Pale yellow/Transparent	
Tensile Strength, (psi) ASTM D 412-98a(2002)e1	1,687	
Modulus @ 100% Elongation (psi) ASTM D 412-98a(2002)e1	214	
Modulus @ 200% Elongation (psi) ASTM D 412-98a(2002)e1	346	
Modulus @ 300% Elongation (psi) ASTM D 412-98a(2002)e1	427	
Elongation, (%) ASTM D 412-98a(2002)e1	1,200	
Tear strength, (pli) ASTM D 624-00e1	236	
Shrinkage, (in/in) linear ASTM D 2566-.....	0.008	

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

HANDLING PROPERTIES:

Mix Ratio (by weight):

Part A	100 parts by weight
Part B	100 parts by weight

Mix Ratio (by volume):

Part A	94 parts by volume
Part B	100 parts by volume

Specific Gravity:

Part A	1.09
Part B	1.02

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

Part A	15,000
Part B	1,000
Mixed	4,500

Color:

Part A	Pale yellow
Part B	Amber

HANDLING PROPERTIES (continued):

Work Time, 100g mass @ 77°F (25°C)	30 minutes
Gel Time	70 minutes
Demold Time @ 77°F (25°C).....	6-8 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 160°F (71°C).

MOLD PREPARATION AND RELEASING:

When TC-460 A/B is used to reproduce molds from plaster, wood or other porous substrates, we would first recommend that they be sealed. Release agents may then be applied over the sealed surface.

NOTE:

Prolonged direct exposure to sunlight can affect the surface of this product. Cover molds or other products when storing outdoors. **The cure will be inhibited if cast against a tin catalyzed silicone RTV.**

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 medical personnel. Never give anything by mouth to an unconscious person.

Refer to the Material Safety Data Sheet before using this product.