

TC-896 A/B

RIGID 82 SHORE D HIGH HEAT RESISTANT POLYURETHANE CASTING SYSTEM

PRODUCT DESCRIPTION:

TC-896 A/B is a RoHS compliant, non-mercury based catalyst polyurethane system that produces a tough 82 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 7 minutes

PHYSICAL PROPERTIES:

Hardness, Shore D ASTM D2240-04e1	82 ± 2
Density, (g/cc) ASTM D792-00.....	1.2
Cubic Inches per Pound.....	24.3
Color/Appearance.....	Translucent pale yellow
Tensile Strength, (psi) ASTM D638-03.....	7,560
Tensile Modulus, (psi) ASTM D638-03.....	2.12 x 10 ⁵
Elongation, (%) ASTM D638-03.....	60
Flexural Strength, (psi) ASTM D790-03.....	9,400
Flexural Modulus, (psi) ASTM D790-03.....	2.27 x 10 ⁵
Shrinkage, (in/in) linear 12"x 1/2"x 1/2".....	0.004
Izod Impact, notched (ft-lb/in) ASTM D256-05	1.04
Heat Deflection Temperature, ASTM D648-04:	
66 psi 240°F (116°C)	
264 psi 210°F (99°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	1.13
Part B	1.16
Viscosity, (cps) @ 77°F (25°C) Brookfield:	
Part A	2,100
Part B	650
Mixed	1,475

HANDLING PROPERTIES (continued):

Color:

Part A Pale yellow
Part B Amber

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

Gel Time 8.5 minutes

Demold Time:

@ 77°F (25°C)..... 6 - 8 hours

@ 150°F (66°C)..... 1 hour

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 the heat curing process.

NOTE:

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.

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.