



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:

Hardness, Shore D ASTM D-2240.....	65 ± 2
Density, (g/cc) ASTM-792.....	1.15
Cubic Inches Per Pound	24
Tensile Strength, (psi) ASTM D-638.....	2,475
Tensile Modulus, (psi) ASTM D-638.....	99,000
Elongation, (%) ASTM D-638.....	70
Flexural Strength, (psi) ASTM D-790.....	2,875
Flexural Modulus, (psi) ASTM D-790	92,850
Tear Strength, (pli) ASTM D-624	585
Izod Impact, notched (ft.-lb./in.) ASTM D-256	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

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

Part A	1,350
Part B	1,500
Mixed.....	1,400

Color:

Part A	Clear, light yellow
Part B	Cream

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 cast

Cure Schedule.....3 days

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% by weight 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.