

TC-808 A/B

78 SHORE D URETHANE CASTING SYSTEM

WHITE

PRODUCT DESCRIPTION:

TC-808 A/B is a low viscosity, rapid setting, and rigid urethane compound. This system will cure quickly to a hard, tough casting. TC-808 A/B is generally insensitive to moisture during and after cure and will readily bond to itself if stage pours are required. TC-808 A/B is recommended in applications where a "thermoplastic feel" is desired.

PHYSICAL PROPERTIES:

| | |
|--------------------------------------------------------|-----------------------|
| Hardness, (Shore D) ASTM D-2240 | 78 ± 2 |
| Specific Gravity, (g/cc) cured ASTM D-792 | 1.08 |
| Cubic Inches per Pound | 25.7 |
| Tensile Strength (psi) ASTM D-638..... | 6000 |
| Tensile Modulus (psi) ASTM D-638..... | 1.9 x 10 ⁵ |
| Elongation (%), ASTM D-638..... | 7.0 |
| Flexural Strength (psi) ASTM D-790..... | 6225 |
| Flexural Modulus, (psi) ASTM D-790 | 1.7 x 10 ⁵ |
| Shrinkage (in/in) linear (12" x ½" x ½") | 0.004 |
| Izod Impact (ft. lbs./in.) ASTM D-256 | 0.52 |
| Heat Deflection Temperature @ 66 (psi) ASTM D-648..... | 170° F (77° C) |

HANDLING PROPERTIES:

Mix Ratio (by weight):

| | |
|--------------|---------------------|
| Part A | 100 parts by weight |
| Part B | 100 parts by weight |

Mix Ratio (by volume):

| | |
|--------------|---------------------|
| Part A | 90 parts by volume |
| Part B | 100 parts by volume |

Specific Gravity (g/cc):

| | |
|--------------|------|
| Part A | 1.20 |
| Part B | 1.02 |

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

| | |
|--------------|-----|
| Part A | 175 |
| Part B | 400 |
| Mixed..... | 250 |

Color:

| | |
|--------------|----------------------|
| Part A | Light yellow, clear |
| Part B | Creamy White, opaque |

Work Time, 100g mass @ 77°F (25° C) 2 - 2 1/4 minutes

Demold Time @ 77°F (25° C)..... 30-60 minutes (see Note 1)

Cure Schedule..... 3 days ambient; or demold followed with a short post cure of
4-6 hours @ 160° F (71° C) is recommended to promote maximum physical properties.

NOTE 1:

TC-808 A/B generally cures to a demoldable state in about 30 minutes; however, thin sections or certain part configurations may require more in-mold cure time. TC-808 A/B gains increasing toughness early in the cure cycle and thick sections, (3/8" or greater), may be demolded much sooner. Sections that are less than an 1/8" may require an hour or more before demold.

NOTE 2:

The "B" side should be remixed before each use until uniform in appearance. Opened containers of material should be purged with dry nitrogen prior to replacing lids or caps to prevent moisture contamination from humid air.

STORAGE:

Store at room temperature in a dry area. Unopened containers will have a shelf life of six months, from date of shipment, when properly stored under normal conditions at 77° F (25° C).

PACKAGING:

| | |
|---------------------|------------------------|
| 1 Gallon kits..... | 8 lbs. A, 8 lbs. B |
| 5 Gallon kits..... | 40 lbs. A, 40 lbs. B |
| 55 Gallon 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. 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.