



TC-800 A/B

75 SHORE D POLYURETHANE CASTING SYSTEM

WHITE

PRODUCT DESCRIPTION:

TC-800 A/B is an easy to use rigid urethane casting material. TC-800 A/B exhibits excellent physical properties, very low viscosity, high heat capability and quick demold times. In addition, this system is economically priced. The one-to-one volume ratio makes it perfect for use with dispensing equipment. TC-800 A/B is a great product when ABS-type parts with a quick turnaround are required.

PHYSICAL PROPERTIES:

Hardness, Shore D ASTM D-2240.....	75 ± 2
Density, (g/cc) ASTM D-792.....	1.11
Color/Appearance.....	Opaque White
Cubic Inches Per Pound	25.7
Tensile Strength, (psi) ASTM D-638.....	6,100
Tensile Modulus, (psi) ASTM D-638.....	1.9×10^5
Elongation, (%) ASTM D-638.....	8
Flexural Strength, (psi) ASTM D-790.....	9,250
Flexural Modulus, ASTM D-790.....	2.3×10^5
Shrinkage, (in./in.) linear 12" x 1/2" x 1/2"	0.007
Izod Impact, notched (ft.-lb./in.) ASTM D-256	0.5
Heat Deflection Temperature ASTM D-648:	
@ 66 psi.....	185°± 5°F (85°± 3°C)
@ 264 psi.....	160°± 5°F (71°± 3°C)

HANDLING PROPERTIES:

Mix Ratio (by weight):

Part A	100 parts by weight
Part B	88 parts by weight

Mix Ratio (by volume):

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

Specific Gravity:

Part A	1.15
Part B	1.01

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

Part A	60
Part B	375
Mixed.....	200

HANDLING PROPERTIES (continued):

Color:

Part A Clear pale yellow
Part B Clear/colorless
Work Time, (100-gram mass) @ 77°F (25°C) 2 minutes
Demold Time @ 77°F (25°C) 60 minutes
Cure Schedule For maximum physical
properties the material should be post-cured @ 180°F (82°C) for 6
hours.

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 temperature. Purge opened containers with dry nitrogen before re-sealing.

PACKAGING:

Gallon kits 8 lbs. A, 7.1 lbs. B
5 Gallon kits 40 lbs. A, 35.2 lbs. B
Drum kits 400 lbs. A, 352 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.