



TC-660 A/B

60 SHORE A CASTABLE ALIPHATIC POLYURETHANE ELASTOMER

PRODUCT DESCRIPTION:

TC-660 A/B is a multi-purpose elastomer that can perform many functions. Typical product uses and features are:

- ✓ Mold fabrication
- ✓ Skin membranes for animated characters
- ✓ Bumpers and many types of urethane rubber parts
- ✓ Excellent as an adhesive for high strength and resilient bonds

PHYSICAL PROPERTIES:

Hardness, Shore A.....	60
Specific Gravity (g/cc) cured ASTM D-792	1.04
Color/Appearance.....	Amber
Tensile Strength (psi) ASTM D-412.....	950
Elongation (%) ASTM D-412.....	600
Tear Strength (pli) ASTM D-624	140
Shrinkage (in./in.) linear ASTM D-2566.....	0.002

HANDLING PROPERTIES:

Mix Ratio:

Part A	100 parts by Weight
Part B	50 parts by Weight

Specific Gravity (g/cc):

Part A	1.02
Part B	1.04

Mixed Viscosity (cps) @ 77°F (25°C) Brookfield..... 3800

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

Demold Time..... 4-6 hours at room temperature. 2 hours or less with elevated temperatures.

Cure Schedule..... 5-7 days for full properties at room temperature.

NOTE:

After demolding, it is recommended that this product be allowed to cure at room temperature conditions, 70° - 85°F (21° - 29°C), for a period of 5-7 days to develop full properties. Do not cast or demold this product if temperatures fall substantially below this range. Demold times may be shortened if mold temperatures and curing conditions are kept moderately high, 90° - 110°F (32° - 43°C). Allow TC-660 A/B to cure for 24 hours at room temperature prior to post curing at elevated temperatures. Post curing at 150°F (66°C) for 2-4 hours will expedite the time required to reach full properties.

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 of TC-660 A/B will have a shelf life of 6 months, from date of shipment, when properly stored under normal indoor conditions, 77° ± 15° F (25° ± 8°C). Purge opened containers with dry nitrogen before resealing.

PACKAGING

1 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. 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.

NON-WARRANTY "Except for a warranty that materials substantially comply with the data presented in Manufacturer's latest bulletin describing the product (the basis for this substantial compliance is to be determined by the standard quality control tests generally performed by Manufacturer), all materials are sold "AS IS" and without any warranty express or implied as to merchantability, fitness for a particular purpose, patent, trademark or copyright infringement, or as to any other matter. In no event shall Manufacturer's liability for damages exceed Manufacturer's sale price of the particular quantity with respect to which damages are claimed."