



## TC-681 A/B

### BRUSHABLE URETHANE ELASTOMER

#### PRODUCT DESCRIPTION:

TC-681 A/B is a two-component polyurethane elastomer compound specifically designed for brush-up applications. This product is a safe, easy-to-handle, room temperature mixing and curing system that contains no TDI, MDA or MOCA. The low shrinkage, superior toughness and excellent detail reproduction of TC-681 A/B makes this system ideal for general-purpose face coats and quality tooling operations.

#### TYPICAL PRODUCT USES:

- ✓ Decorative parts and Coatings
- ✓ Industrial linings
- ✓ Art objects
- ✓ Potting and encapsulation

#### PHYSICAL PROPERTIES:

Hardness, Shore A ASTM D-2240.....	80 - 85
Specific Gravity, (g/cc) cured ASTM D-792 .....	1.04
Cubic Inches per Pound .....	26.8
Color/Appearance.....	Clear/Pale green
Tensile Strength, (psi) ASTM D-412.....	2200
Elongation, (%) ASTM D-412.....	600
Tear Strength, (pli) ASTM D-624 .....	260

#### HANDLING PROPERTIES:

Mix Ratio (by weight):

Part A ..... 100 parts by weight

Part B ..... 50 parts by weight

Specific Gravity, (g/cc):

Part A ..... 1.06

Part B ..... 1.04

Mixed Viscosity, (cps) @ 77°F (25°C) ..... Thixotropic

Work Time, 100g mass, @ 77°F (25°C) ..... 15 minutes

Gel Time ..... 30 minutes

Demold Time @ 77°F (25°C)..... 4 - 6 hours

Cure Schedule..... 3 - 5 days at ambient temperature or 16 hours at 150°F (66°C).

#### MOLD PREPARATION AND RELEASING:

When TC-681 A/B is used to reproduce molds from plaster, wood or other porous substrates, we would first recommend that they be sealed. Release agents may then be applied over the sealed surface. Consult with BJB's technical staff for specific release agent recommendations.

**STORAGE:**

Store in a cool, dry place. Unopened containers of TC-681 A/B will have a shelf life of 6 months from date of shipment when properly stored under normal temperature conditions, 77°F (25°C).

**PACKAGING:**

Gallon kits..... 8 lbs. A, 4 lbs. B  
5-Gallon kits ..... 40 lbs. A, 20 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.**