



TC-1611 A/B

HIGH TEMPERATURE EPOXY SURFACE COAT

PRODUCT DESCRIPTION:

TC-1611 A/B is an easy to apply, heat resistant, black surface coat commonly used as a face coat for epoxy laminating and casting systems. TC-1611 A/B provides excellent surface detail reproduction and has a service temperature of 350°F (177°C).

PRODUCT HIGHLIGHTS:

- Very easy to apply
- No sag or runoff when applying up to 1/16" thickness
- Heat resistance to 350°F (177°C)
- Provides a hard durable surface

PHYSICAL PROPERTIES:

Hardness, Shore D ASTM D-2240.....	92
Specific Gravity, (g/cc) ASTM D-792.....	2.0
Tensile Strength, (psi) ASTM D-638.....	8,200
Flexural Strength, (psi) ASTM D-790.....	12,500
Coefficient of Thermal Expansion, ASTM D-3386.....	3.6×10^{-5}
Heat Deflection Temperature, (@ 264 psi) ASTM D-648.....	330°F (166°C)
Compressive Strength, (psi) ASTM D-695.....	28,000

HANDLING PROPERTIES:

Mix Ratio (by weight):

Part A..... 100 parts by weight

Part B..... 6 parts by weight

Specific Gravity (g/cc):

Part A..... 1.85

Part B..... 0.98

Mixed Viscosity, (cps) @ 77°F (25°C) ASTM D-2393..... 15,500

Work Time, (1lb mass) @ 77°F (25°C)..... 20 - 25 minutes

Demold Time @ 77°(25°C)..... 16 - 24 hours

POST-CURE:

All physical property results are based upon post-curing this system. For best results, it is recommended the following procedure be followed:

- 1) 150°F (66°C) for 1.5 to 2 Hours
- 2) 250°F (121°C) for 2 Hours
- 3) 350°F (177°C) for 1 Hour

Allow to cool in the oven. This procedure provides further stabilization and eliminates possible thermal shocks for cavity tools that are temporarily clamped together for curing purposes.

STORAGE:

Store at 55° - 90°F (13° - 32°C) in a dry location. Unopened containers will have a shelf life of 12 months from date of shipment when properly stored at room temperature. Keep containers tightly sealed after use.

PACKAGING:

Quart Kit 3 lbs. A, 2.8 oz. B
Gallon Kit 10 lbs. A, 10 oz. B
5 Gallon Kit 50 lbs. A, 3 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.