



TC-4206 A/B

GENERAL PURPOSE, STRUCTURAL ADHESIVE

PRODUCT DESCRIPTION:

TC-4206 A/B is a buff-colored epoxy adhesive with a smooth, creamy consistency. It has been used primarily for bonding wood, metal and plastics. The development of this material largely came as a result of servicing the golf club industry where it has been used for shaft and insert bonding.

PHYSICAL PROPERTIES:

Hardness, Shore D ASTM D-2240.....	65 - 70
Color.....	Buff
Compressive Strength, (ultimate psi), ASTM D-695	10,000
Water Absorption, (%) ASTM D-570	2.0
Lap Shear, (psi) Aluminum to Aluminum, etched ASTM D-1002	2,000

The values shown are typical and are not recommended for specification purposes unless practical tolerances or limitations are established with BJB Enterprises, Inc.

HANDLING PROPERTIES:

Mix Ratio:

Part A	100 parts by weight or volume
Part B.....	100 parts by weight or volume
Viscosity	Semi-flowing
Work Time (1 lb. mass) @ 77°F (25°C)	45 minutes
Cure Schedule, tack free time @ 77°F (25°C)	6 - 8 hours
	Full cure requires 40 hours @ 77°F (25°C).

SURFACE PREPARATION:

Clean, dry surfaces are required. Metals should be sanded and wiped clean with solvent.

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 Kits	2 lbs. A, 2 lbs. B
Gallon Kits	8 lbs. A, 8 lbs. B
5 Gallon Kits	40 lbs. A, 40 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.