



TC-4207 A/B

GENERAL PURPOSE, STRUCTURAL ADHESIVE

PRODUCT DESCRIPTION:

TC-4207 A/B is a buff-colored epoxy adhesive with a smooth, paste-like consistency. It has been used primarily for bonding wood, metal and plastics. The TC-4207 A/B has a semi-paste consistency providing a more vertical hang than its sister product designated TC-4206 A/B.

PHYSICAL PROPERTIES:

Hardness, Shore D ASTM D-2240.....	65 - 70
Color/Appearance.....	Buff
Compressive Strength, (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-paste
Work Time 1 lb. mass @ 77°F (25°C)	1 hour
Gel Time	105 minutes
Cure Schedule; tack free time @ 77°F (25°C)	6 - 8 hours

Full cure requires about 40 hours at 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.

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."