



TC-812 A/B LIGHTCAST

PRODUCT DESCRIPTION:

TC-812 A/B LIGHTCAST is a low viscosity, quick setting, easy to use casting material. A model or tool cast from TC-812 A/B LIGHTCAST will weigh 60% less than other filled urethane systems. Within 60 minutes after mixing and pouring, it is ready to be carved, sanded, filed, tapped, etc.. Its characteristics make it ideal for lightweight backing of laminates and/or surface coats. Perfect for fast take offs, cores, engineering changes, temporary molds, patterns, models, prototypes, and bases for die molds.

PHYSICAL PROPERTIES:

Hardness, Shore D ASTM D-2240.....	60 - 65
Density, (g/cc) ASTM D-792.....	0.64
Cubic Inches per Pound	43.4
Tensile Strength, (psi) ASTM D-638.....	2,575
Flexural Strength, (psi) ASTM D-790.....	2,730
Flexural Modulus, (psi) ASTM D-790	1.71 x 10 ⁵
Shrinkage, (in./in.) linear ASTM D-2566.....	0.003
Heat Deflection Temperature, ASTM-D-648.....	133°F (56°C)
Compressive Strength, (psi) ASTM D-695	3,050

HANDLING PROPERTIES:

Mix Ratio (by weight):

Part A	100 parts by weight
Part B	100 parts by weight

Specific Gravity:

Part A	0.63
Part B	0.59

Viscosity, (cps) @ 77°F (25°C) Brookfield:

Part A	650
Part B	875
Mixed.....	750

Work Time, ½ lb. mass @ 77°F (25°C)4 minutes

Gel Time6 minutes

Demold Time @ 77°F (25°C)..... 1 hour

Dependent upon wall thickness of casting.

MIXING INSTRUCTIONS:

Both sides of TC-812 A/B LIGHTCAST must be pre-mixed. Use a Jiffy Mixer™ with a drill motor. Then combine equal parts of A and B by weight. Mix thoroughly in a polyethylene pail scraping the sides and bottom, de-air the mixture and pour within two minutes. For best results, be sure that TC-812 A/B LIGHTCAST and molds are at room temperature.

STORAGE:

Store in a cool dry place. Unopened containers of TC-812 A/B LIGHTCAST will have a shelf life of 6 months from date of shipment when properly stored under normal temperature conditions, 75°F (25°C).

PACKAGING:

Gallon Kits 3.6 lbs. A, 3.6 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."