



TC-816 A/B GRAY FAST CAST URETHANE FOR TOOLING AND PARTS

PRODUCT DESCRIPTION:

TC-816 A/B is a durable, filled polyurethane system that offers excellent duplication properties. TC-816 A/B exhibits low shrink, low exotherm and quick demold times.

PRODUCT HIGHLIGHTS:

- Exceptionally Low Viscosity
- Workable in semi-gel stage as a paste if desired
- Low exotherm contributing to low shrinkage
- Will readily bond to itself
- Greater settling resistance

PHYSICAL PROPERTIES:

Hardness, Shore D ASTM D-2240.....	85
Specific Gravity, (g/cc) cured ASTM D-792	1.62
Cubic Inches Per Pound	17.2
Color/Appearance.....	Gray
Shrinkage, (in./in.) linear ASTM D-2566.....	0.004
Compressive Strength, (psi) ASTM D-695	9,200

HANDLING PROPERTIES:

Mix Ratio (by weight or volume):

Part A 100 parts by weight or volume

Part B 100 parts by weight or volume

Specific Gravity (g/cc):

Part A 1.6

Part B 1.6

Mixed Viscosity, (cps) @ 77°F (25°C) Brookfield..... 1,000

Color:

Part A Black

Part B White

Work Time, (1-lb. mass) @ 77°F (25°C) 5 minutes

Demold Time, (mass dependent) @ 77°F (25°C) 1 - 2 hours

MIXING INSTRUCTIONS:

TC-816 A/B settles on standing but is easily remixed. Thoroughly mix cans A and B separately, preferably with a Jiffy Mixer. Then combine equal parts of A and B by weight or volume. Mix thoroughly for not more than 30 seconds and pour promptly. Do not mix in the original containers. Polyethylene mixing pails are excellent and may be reused. Be sure all material on the sides and bottom are well mixed. After each use, cans should be purged with dry nitrogen and tightly sealed to prevent moisture in the air from reacting with the contents.

STORAGE:

Store in a cool dry place. Unopened containers of TC-816 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 10 lbs. A, 10 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.

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."