



TC-1611 A/B

HIGH TEMPERATURE EPOXY SURFACE COAT



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).

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

PHYSICAL PROPERTIES	TEST METHOD	TEST RESULTS
Hardness, Shore D	ASTM D2240	92 ± 2
Density (g/cc)	ASTM D792	2.0
Cubic Inches per Pound	N/A	15.4
Color/Appearance	Visual	Black
Tensile Strength (psi)	ASTM D638	8,200
Flexural Strength (psi)	ASTM D790	12,500
Heat Deflection Temperature (264 psi)	ASTM D648	330°F (166°C)
Compressive Strength (psi)	ASTM D695	28,000
Coefficient of Thermal Expansion (in/in/F°)	ASTM D3386	3.6 x 10 ⁻⁵

HANDLING PROPERTIES	Part A	Part B
Mix Ratio by weight	100	6
Mix Ratio by volume	100	11
Specific Gravity @ 77°F (25°C)	1.85	0.98
Color	Black	Amber
Mixed Viscosity (cps) @ 77°F (25°C) Brookfield	Brushable	
Work Time, 1 lb. mass @ 77°F (25°C)	20 – 25 minutes	
Demold Time @ 77°F (25°C)	16 – 24 hours	

Properties above are typical and not for specifications.

POST CURING:

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 ambient temperatures, 65-80°F (18-27°C). Unopened containers will have a shelf life of 12 months from date of shipment when properly stored at recommended temperatures. Purge opened containers with dry nitrogen before re-sealing.

PACKAGING	Part A	Part B	Square Inches per Kit Coverage (@ 1/16" Thick)
Quart Kits	3 lbs.	2.8 oz.	782
Gallon Kits	10 lbs.	10 oz.	2617
5-Gallon Kits	50 lbs.	3 lbs.	13059

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.

NOTE:

Refer to the Safety Data Sheet before using this product. For processing tips and guides, please visit: learn.bjbmaterias.com to discover additional information.

⚠WARNING: This product can expose you to chemicals including Carbon black and 1 H-Imidazole, 4-methyl-, which are known to the State of California to cause cancer. For more information, go to www.P65Warnings.ca.gov.