



TC-1622 A/B
LOW VISCOSITY HIGH TEMPERATURE
EPOXY LAMINATING RESIN

TC-1622 A/B is an unfilled laminating resin for high temperature mold and part fabrication formulated to provide superior wet-out and adhesion to a variety of substrates. It is a great material for Vacuum Assisted Resin Transfer Molding (VARTM) as well as other wet lay-up methods due to its low viscosity and long working time. When properly cured TC-1622 A/B can be used up to 350°F (177°C).

Table with 3 columns: PHYSICAL PROPERTIES, TEST METHOD, TEST RESULTS. Rows include Hardness, Density, Cubic Inches per Pound, Color/Appearance, Tensile Strength, Tensile Modulus, Elongation, Flexural Strength, Flexural Modulus, Shrinkage, Izod Impact.

Reported physical properties based on elevated temperature cured test specimens.

Table with 3 columns: HANDLING PROPERTIES, Part A, Part B. Rows include Mix Ratio by weight, Mix Ratio by volume, Specific Gravity, Color, Viscosity, Mixed Viscosity, Work Time, Gel Time, Demold Time.

Properties above are typical and not for specifications.

Note: Thin laminates may require mild heat (100-120°F) to sufficiently cure for demold.

POST CURING:

All physical property results are based upon post-curing this system. The following procedure provides the best results:

- 150°F (66°C) for 1.5 to 2 hours
- 250°F (121°C) for 2 hours
- 300°F (149°C) for 1 hour
- 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	Cubic Inches per Kit
Quart Kits	2 lbs.	7 oz	61
Gallon Kits	9 lbs.	1.8 lbs.	271
5-Gallon Kits	40 lbs.	8 lbs.	1,205

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.bjbmaterals.com to discover additional information.

⚠️WARNING: This product can expose you to chemicals including Ethylbenzene and 4,4'-Isopropylidenediphenol, which are known to the State of California to cause cancer, birth defects or other reproductive harm. For more information, go to www.P65Warnings.ca.gov.