



## EPOXY RESIN SYSTEMS

By BJB Enterprises, Inc.  
An ISO-9001 Certified company

# TC-4206 A/B

## GENERAL PURPOSE, STRUCTURAL ADHESIVE

TC-4206 A/B is a buff-colored epoxy adhesive with a smooth, creamy consistency. It has been used primarily for bonding wood, metal and plastics. This product was originally developed to serve the golf club industry where it has been used for shaft and insert bonding. TC-4206 creates a strong, impact and shock resistant bond between a variety of materials. It's great for creating fillets on wood or composite structures. Ideal for marine, automotive, and aerospace applications.

PHYSICAL PROPERTIES	TEST METHOD	TEST RESULTS
Hardness, Shore D	ASTM D2240	85 ± 5
Color/Appearance	Visual	Buff
Compressive Strength (psi)	ASTM D695	10,000
Water Absorption (%)	ASTM D570	2.0
Lap Shear (psi) Aluminum to Aluminum, etched	ASTM D1002	2,000

HANDLING PROPERTIES	Part A	Part B
Mix Ratio (by weight or volume)	100	100
Specific Gravity @ 77°F (25°C)	1.40	1.24
Color	Buff	Amber
Viscosity (cps) @ 77°F (25°C) Brookfield	Semi-flowing	
Work Time, 1 lb. mass @ 77°F (25°C)	45 minutes	
Tack Free Time @ 77°F (25°C)	6 – 8 hours	
Full Cure @ 77°F (25°C)	40 hours	

Properties above are typical and not for specifications.

**SURFACE PREPARATION:**

Clean, dry surfaces are required. Metals should be sanded and wiped clean with solvent.

**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.

<b>PACKAGING</b>	<b>Part A</b>	<b>Part B</b>
Quart Kits	2 lbs.	2 lbs.
Gallon Kits	8 lbs.	8 lbs.
5-Gallon Kits	40 lbs.	40 lbs.

**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](http://learn.bjbmaterals.com) to discover additional information.