



# TC-277 A/B

## 4 LB FLEXIBLE FOAM

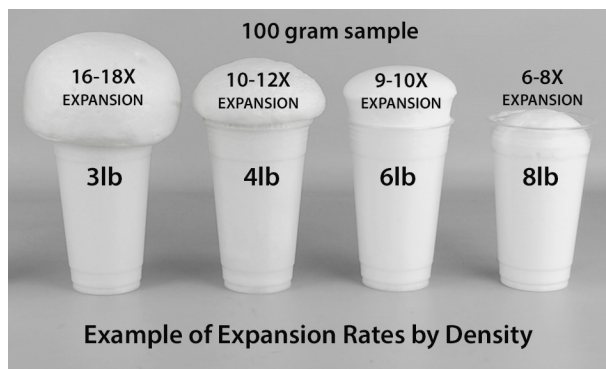


TC-277 A/B is a two-component, flexible polyurethane foam. The cured material feels similar to foam sandals. BJB’s 6800 Series Pigments may be added to the “B” side for developing a wide range of colors. End users can adjust firmness with a slight ratio change as listed below. Common applications are prototypes, prosthetics, medical training devices, movie special effects props and more. This material is frequently molded behind flexible polyurethane skin materials such as BJB’s FP, F, M, and L line or other BJB elastomers.

Note: TC-277 at a ratio of 75/100 pbw produces a firm, quick recovery foam. At 60/100 pbw, the result will be a slightly softer foam.

HANDLING PROPERTIES	For a firmer foam	For slightly softer foam
Mix Ratio by weight	75 parts A 100 parts B	60 Parts A 100 Parts B
Density, (free rise) lbs/ft <sup>3</sup>	4	4
Density, (free rise) kg/m <sup>3</sup>	64	64
Cream Time @ 77°F (25°C)	15-20 seconds	15-20 seconds
Rise Time	80-90 seconds	80-90 seconds
Demold Time @ 77°F (25°C) (Depending on part size and cross section)	20-30 minutes	20-30 minutes
	PART A	PART B
Specific Gravity @ 77°F (25°C)	1.15	1.03
Viscosity, (cps) @ 77°F (25°C) Brookfield	425	2250

\*The density and processing times listed are derived from a statistical average of long-term testing. We recommend a test mix be performed before use. BJB quality control tests and product packaging are based on the 75/100 pbw ratio.



### MIXING:

Mixing is best with a high speed drill or air motor with a “Jiffy Mixer”. The blade shears the material and provides a thorough mix within the 8 to 10 second period generally established for achieving a uniform blend. Mixing too long or not enough can result in poor material performance. Once mixed, the material should be *immediately* poured. If too much time goes by, the foam will rise in the mix container and the batch may be lost.

When pouring the foam, avoid trying to scrape any material from the container sidewalls or bottom. Generally, there isn’t enough time to do this and more importantly there may be material that is not well mixed on the container sides.

**MOLD PREPARATIONS:**

The mold should be well sealed and released. Foams will seek moisture through release waxes and stick to mold surfaces if an insufficient seal exists. Sealing can be accomplished by using acrylic or other similar sealers. The mold should be warmed to between 75-85°F (24-29°C) prior to casting the first part. Once a mold is heated and cycled it will maintain heat for continued production.

Release systems vary in accordance to the type of mold used, however, as a general product we recommend Challenge 95 Release or a mold release paste wax from our line of products. As a rule, silicone based releases do not work with either the flexible or rigid foam groups of materials. The silicone migrates and often causes poor surface conditions. Silicone will also inhibit the adhesion of paints and over-coatings.

The best molds for production (rather than prototype or limited production parts) are either machined aluminum molds or TC-1630 molds. Epoxy molds offer the least expensive method for long term use when cycle times allow slower heat dissipation.

**DEMOLDING FOAM MATERIALS:**

TC-277 A/B can be removed from the mold within a 20-30 minute timeframe. However, smaller masses will develop lower exothermic reaction and may require a slightly longer cure time. It is recommended that foam parts be crushed or squeezed after demolding to remove residual gases remaining in the cell structure. This will help to reduce post shrinkage and aid in reducing natural odors from the foam part.

**NOTE:**

The "B" component should be gently shaken or stirred to re-blend prior to mixing with part "A".

**STORAGE:**

Store at ambient temperatures, 65-80°F (18-27°C). Unopened containers will have a shelf life of 6 months from date of shipment when properly stored at recommended temperatures. Purge opened containers with dry nitrogen before re-sealing.

When first using the material, a sample should be visually inspected to be sure no crystallization is present. Crystallization of either the resin or hardener can occur during shipment in cold weather. If the resin appears cloudy or the hardener becomes gummy, the component should be warmed with the containers open and stirred until the material returns to its proper smooth liquid consistency.

PACKAGING	Part A	Part B
Quart Kits	1.5 lbs.	2 lbs.
Gallon Kits	6 lbs.	8 lbs.
5-Gallon Kits	30 lbs.	40 lbs.
55-Gallon Drum Kits	300 lbs.	400 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.

Refer to the Material Safety Data Sheet before using this product.

**⚠️WARNING:** This product can expose you to chemicals including Diethanolamine, which are known to the State of California to cause cancer. For more information, go to [www.P65Warnings.ca.gov](http://www.P65Warnings.ca.gov).



Scan QR code to see our How-to Foam Video

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."