



TC-318 A/B

12# DENSITY SELF-SKINNING FOAM



The TC-318 A/B is a rigid, self-skinning polyurethane foam system that can be easily hand mixed. The skin surface cures smooth and hard while the inner cell structure reduces density. The flow characteristics of the TC-318 A/B system allows intricate mold cavities to be easily filled. Demold time is short, 15 minutes or less.

- Easy to hand cast
- Fast Demolds
- Off-white color
- Flows well into mold cavities
- Bone-like structure

PHYSICAL PROPERTIES	TEST METHOD	RESULTS
Density, (free rise) lbs/ft ³	ASTM D1622-03	12
Color/Appearance	Visual	Off-white/Opaque

HANDLING PROPERTIES (All densities)	Part A	Part B
Mix Ratio by weight	100	85
Mix Ratio by volume	96	100
Specific Gravity @ 77°F (25°C)	1.15	0.94
Color	Pale yellow	White
Viscosity (cps) @ 77°F (25°C) Brookfield	60	525
Mixed Viscosity (cps) @ 77°F (25°C) Brookfield	275	
Cream Time	60 seconds	
Gel Time	2 minutes	
Tack Free Time	3 minutes	
Demold Time	15 minutes	

Properties above are typical and not for specifications.

NOTES:

The “B” component must be pre-mixed prior to each casting to keep ingredients adequately suspended.

In order to achieve bone-like parts using TC-318 A/B can depend on mold design and handling of the material when casting. Please contact your BJB Technical representative for assistance.

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.

PACKAGING	Part A	Part B
Gallon Kits	8 lbs.	6.8 lbs.
5-Gallon Kits	40 lbs.	34 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 to discover additional information.

⚠️WARNING: This product can expose you to chemicals including 1,2-Benzenedicarboxylic acid, di-C9-11-branched alkyl esters, C10-rich, which are known to the State of California to cause cancer and birth defects or other reproductive harm. For more information, go to www.P65Warnings.ca.gov.