



# TC-812 REV 1 A/B LIGHTCAST



TC-812 REV 1 A/B Lightcast is a lightweight, rigid, quick setting, low shrinkage, low viscosity filled cast urethane that weighs 30-40% less than most conventional unfilled urethane systems. Parts made from TC-812 REV 1 can float in the water and its fast-curing properties allow parts to be demolded in 1 hour or less. TC-812 REV 1 is ideal for carving, sanding, drilling, machining, and modifying parts due to its low-density filler content. This product is perfect for fast patterns, mold cores, vacuum forming bucks, temporary molds, lightweight models, fishing lures, and much more.

- RoHS/REACH Compliant
- Low Density/Lightweight
- Low Shrinkage
- Mercury and Phthalate Free
- Fast Processing
- Easy to Machine/Sand/Carve
- Easy to Paint or Pigment
- Economical
- Floats/Buoyant

PHYSICAL PROPERTIES	TEST METHOD	RESULTS
Hardness, Shore D	ASTM D2240	60±5
Density (g/cc)	ASTM D792	0.70
Cubic Inches per Pound	N/A	39.62
Color/Appearance	Visual	Opaque Cream
Tensile Strength (psi)	ASTM D638	2,600
Flexural Modulus (psi)	ASTM D790	2.1 x 10 <sup>5</sup>
Shrinkage (in/in) linear	12"x1/2"x1/2"	0.003
Heat Deflection Temperature @ 66psi	ASTM D648	140°F (60°C)

**Note:** Reported physical properties are based on test specimens cured at room temperature (77°F) for 7 days.

HANDLING PROPERTIES	Part A	Part B
Mix Ratio by weight	100	90
Mix Ratio by volume	100	100
Color	Amber	White
Viscosity (cps) @ 77°F (25°C) Brookfield	350	340
Mixed Viscosity (cps) @ 77°F (25°C) Brookfield	375	
Work Time, 0.5 lb. mass @ 77°F (25°C)	4 – 5 minutes	
Gel Time	8 – 10 minutes	
Demold Time @ 77°F (25°C)	1 Hour	

Properties above are typical and not for specifications.

### MIXING INTRUCTIONS:

Both sides of TC-812 REV 1 A/B must be pre-mixed before each use. We recommend using a Jiffy Mixer™ to resuspend the fillers, then combine Parts A and B by weight. Mix thoroughly in a polyethylene pail scraping the sides and bottom, de-air the mixture and pour within two minutes. For best results, be sure that TC-812 REV 1 A/B and molds are at room temperature.

**ACCESSORIES:**

BJB offers silicone RTV mold making materials along with a wide range of accessory items. These include de-airing agents, pigments, mold releases, and Jiffy® Mixers. Visit BJB’s website at [www.bjbenterprises.com](http://www.bjbenterprises.com) or consult a BJB representative for more information.

**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.

<b>PACKAGING</b>	<b>Part A</b>	<b>Part B</b>
Gallon Kits	6.2 lbs.	5.6 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.**



Handling Guide

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."