



TC-802 A/B

73 SHORE D POLYURETHANE CASTING SYSTEM



TC-802 A/B is an easy to use rigid urethane casting material. TC-802 A/B is an extremely low viscosity system with quick demold times. This system also exhibits good physical and heat resistance. In addition, this system is economically priced. The one-to-one volume ratio makes it perfect for use with dispensing equipment. TC-802 A/B is a great product when ABS-type parts with a quick turnaround are required.

PHYSICAL PROPERTIES	TEST METHOD	TEST RESULTS
Hardness, Shore D	ASTM D2240-04e1	73 ± 2
Density (g/cc)	ASTM D792-00	1.06
Cubic Inches per Pound	N/A	26.5
Color/Appearance	Visual	White/Opaque
Tensile Strength (psi)	ASTM D638-03	4,180
Tensile Modulus (psi)	ASTM D638-03	1.32 x 10 ⁵
Elongation (%)	ASTM D638-03	40
Flexural Strength (psi)	ASTM D790-03	5,975
Flexural Modulus (psi)	ASTM D790-03	1.48 x 10 ⁵
Shrinkage (in/in) linear	12"x 1/2" x 1/2"	0.006
Izod Impact, notched (ft-lb/in)	ASTM D256-05	0.42
Heat Deflection Temperature @ 66 psi	ASTM D648-04	177°F (80.6°C)
Heat Deflection Temperature @ 264 psi	ASTM D648-04	147°F (63.9°C)

Note: Reported physical properties based on elevated temperature cured test specimens.

HANDLING PROPERTIES	Part A	Part B
Mix Ratio by weight	100	90
Mix Ratio by volume	100	100
Specific Gravity @ 77°F (25°C)	1.10	0.99
Color	Pale Yellow	Colorless
Viscosity (cps) @ 77°F (25°C) Brookfield	40	120
Mixed Viscosity (cps) @ 77°F (25°C) Brookfield	80	
Work Time, 100g mass @ 77°F (25°C)	1.5 minutes	
Demold Time @ 77°F (25°C)	10 minutes	

Properties above are typical and not for specifications.

CURE SCHEDULE/HEAT CURING:

Most of the physical properties can be achieved in 5-7 days at 77°F (25°C). You may use your own post-cure schedule but the physical properties may vary from BJB's cure schedule of 1-3 hours at 77°F (25°C) followed by 16 hours at 180 °F (82°C). Do not exceed curing temperatures of 200°F (93°C). Support of the part may be required to prevent part deformation during the heat curing process.

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	Cubic Inches per Kit
Quart Kits	2 lbs.	1.8 lbs.	101
Gallon Kits	8 lbs.	7.2 lbs.	403
5-Gallon Kits	40 lbs.	36 lbs.	2,014
55-Drum Kits	400 lbs.	360 lbs.	20,140

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.bjbmaterials.com to discover additional information.