



TC-895 A/B
RIGID 84 SHORE D HIGH HEAT RESISTANT
POLYURETHANE CASTING SYSTEM



TC-895 A/B is a RoHS compliant, non-mercury based catalyst polyurethane system that produces a tough 84 shore D material. This system has an extremely high heat deflection temperature and has been used for under the hood automotive applications. In some cases, TC-895 can be post cured without having to use fixtures.

- High heat resistance
- High impact
- RoHS/REACH compliant
- Working time of 6-7 minutes

PHYSICAL PROPERTIES	TEST METHOD	CURE SCHEDULE 1*	CURE SCHEDULE 2*
Hardness, Shore D	ASTM D2240-04e1	84 ± 2	84 ± 2
Density (g/cc)	ASTM D792-00	1.22	1.22
Cubic Inches per Pound	N/A	24	24
Color/Appearance	Visual	Translucent Pale Yellow	Translucent Pale Yellow
Tensile Strength (psi)	ASTM D638-03	10,300	10,400
Tensile Modulus (psi)	ASTM D638-03	2.93 x 10 ⁵	2.87 x 10 ⁵
Elongation (%)	ASTM D638-03	9.1	9.8
Flexural Strength (psi)	ASTM D790-03	12,700	12,200
Flexural Modulus (psi)	ASTM D790-03	3.17 x 10 ⁵	3.03 x 10 ⁵
Shrinkage (in/in) linear	12"x 1/2" x 1/2"	0.008	0.005
Izod Impact, notched (ft-lb/in)	ASTM D256-05	0.88	0.95
Heat Deflection Temperature @ 66 psi	ASTM D648-04	340°F (171.1°C)	290°F (143.3°C)
Heat Deflection Temperature @ 264 psi	ASTM D648-04	218°F (103.3°C)	213°F (100.6°C)
Coefficient of Thermal Expansion (in/in/°F)	ASTM E831-06	73.1 x 10 ⁻⁶	TBD

CURE SCHEDULE 1:

To achieve maximum physical properties, the material should be preconditioned to 77°F (25°C) and the mold approximately to 120°F (49°C). After casting the material, the mold should be placed into a 150°F (66°C) oven and left for 1 hour. After 1 hour the part can be demolded and then post cured with heat for 16 hours at 180°F (82°C). Support of the part in some cases may be required to prevent part deformation during the heat curing process.

CURE SCHEDULE 2:

Most of the physical properties can be achieved when casting this product at room temperature then followed with a post cure. Precondition the material and molds to 77°F (25°C). After casting, leave the part at room temperature for 16 – 24 hours followed with a post cure for an additional 16 hours at 180°F (82°C). Support of the part in some cases may be required to prevent part deformation during the heat curing process.

Note: To obtain higher heat deflection temperatures and faster demold times, it is advised to use heat during the casting process.

HANDLING PROPERTIES	Part A	Part B
Mix Ratio (by weight or volume)	100	50
Specific Gravity	1.16	1.16
Color	Pale Yellow	Amber
Viscosity (cps) @ 77°F (25°C) Brookfield	1,000	650
Mixed Viscosity (cps) @ 77°F (25°C) Brookfield	850	
Work Time, 100g mass @ 77°F (25°C)	6 – 7 minutes	
Gel Time	7 – 8 minutes	
Demold Time @ 77°F (25°C)	5 – 6 hours	
Demold Time @ 150°F (66°C)	1 hour	

Properties above are typical and not for specifications.

NOTE #1:

It is advisable whenever possible to evacuate entrapped air prior to casting this system. The use of a de-airing agent can speed up the process. BJB's AF-4 antifoam works best as the de-airing agent. In conjunction with these support products BJB offers pigments in a wide variety of colors and stainless steel mixers called "Jiffy Mixers". For additional information on the use of this product, refer to BJB Guidelines for Handling Polyurethane Products. If further information is required, please call BJB's technical staff for assistance.

NOTE #2:

When the cured material is exposed to direct sunlight or strong UV, the material will turn to an orange color within approximately 2 hours.

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 lb.	72
Gallon Kits	8 lbs.	4 lbs.	288
5-Gallon Kits	40 lbs.	20 lbs.	1,440

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 Naphthalene, which is known to the State of California to cause cancer. For more information, go to www.P65Warnings.ca.gov.



Handling Guide