TC-8764 A/B

CASTABLE HIGH PERFORMANCE 60 SHORE D POLYURETHANE ELASTOMER

PRODUCT DESCRIPTION:

TC-8764 A/B is a two-component urethane casting compound that is specifically formulated for high abrasion and impact resistance. It is recommended for use for the production casting of highly wear-resistant parts and linings. This product is a safe, easy-to-handle, room temperature mixing and curing system that does not contain MDI, MDA or MOCA. TC-8764 A/B is relatively insensitive to typical environmental moisture and will make good void-free parts without the problems that some conventional urethane systems exhibit. Because of this products exceptional toughness and abrasion resistance, castings made with TC-8764 A/B are particularly suitable for mining and mineral process industries.

PRODUCT HIGHLIGHTS:

- ✓ Exceptionally tough, abrasion resistant, high impact material
- ✓ Contains no MDI, MDA or MOCA
- ✓ Easy to handle
- ✓ Room temperature mixing and curing

PHYSICAL PROPERTIES:

Hardness, Shore D ASTM D2240	60 ± 2
Density, (g/cc) ASTM D792	1.13
Cubic Inch per Pound	25
Color/Appearance	Light amber
Tensile Strength, (psi) ASTM D638	4,400
Tensile Modulus, (psi) ASTM D638	41,000
Elongation, (%) ASTM D638	310
Flexural Strength, (psi) ASTM D790	1,430
Flexural Modulus, (psi) ASTM D790	38,700
Tear Strength, (pli) ASTM D624	510
Shrinkage, (in/in) linear ASTM D2566	0.009
Izod Impact, (ft-lb/in), ASTM D256	>10

HANDLING PROPERTIES:

Mix Ratio (by weight):

Part A	100 parts by weight
Part B	50 parts by weight

Mix Ratio (by volume):

Part A	100 parts by volume
Part B	48 parts by volume

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HANDLING PROPERTIES (continued):

Specific Gravity @ 77°F (25°C):
- Part A 1.09
- Part B 1.14

Viscosity, (cps) @ 77°F (25°C) Brookfield:
- Part A 2,750
- Part B 250
- Mixed 1,550

Color:
- Part A ..... Pale yellow
- Part B ..... Amber

Work Time (100-gram mass) @ 77°F (25°C) ..... 10 - 15 minutes
Gel Time ..... 15 - 20 minutes
Demold Time ..... Normally 2 - 3 hours at ambient temperature; can be reduced to one hour with moderately elevated temperatures and/or molds.

CURE SCHEDULE/HEAT CURING:

Most of the physical properties can be achieved in 5-7 days at ambient temperature, @ 77°F (25°C). In order to achieve maximum physical properties, a post cure with heat is required. BJB recommends 24 hours at ambient temperature, @ 77°F (25°C), followed by 16 hours at 160°F (71ºC).

NOTE:

Post-curing the TC-8764 A/B soon after demolding will enhance mechanical properties (tensile strength, tear strength and overall toughness), but may slightly increase shrinkage.

STORAGE:

Store in a cool dry place. Unopened containers will have a shelf life of 6 months from day of shipment when properly stored at room temperatures. Purge opened containers with dry nitrogen before re-sealing.

PACKAGING:

Gallon kits ..... 8 lbs. A, 4 lbs. B
5-Gallon kits ..... 40 lbs. A, 20 lbs. B
55-Gallon drum kits ..... 400 lbs. A, 200 lbs. B

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 eyes 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.

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