

## Product Name

**TC-808 A/B**

**78 Shore D Urethane Casting System White**

## Product Description

TC-808 A/B is a low viscosity, rapid setting, and rigid urethane compound. This system will cure quickly to a hard, tough casting. TC-808 A/B is generally insensitive to moisture during and after cure and will readily bond to itself if stage pours are required. TC-808 A/B is recommended in applications where a "thermoplastic feel" is desired.

## Physical Properties

Hardness	Shore D	ASTM D-2240	78 ± 2
Specific Gravity, cured	g/cc	ASTM D-792	1.08
Cubic Inches per Pound	psi		25.7
Tensile Strength	psi	ASTM D-638	6000
Tensile Modulus	psi	ASTM D-638	1.9 x 10 <sup>5</sup>
Elongation	%	ASTM D-638	7.0
Flexural Strength	psi	ASTM D-790	6225
Flexural Modulus	psi	ASTM D-790	1.7 x 10 <sup>5</sup>
Shrinkage	linear (12" x ½" x ½") in/in		0.004
Izod Impact	ft. lbs./in	ASTM D-256	0.52
Heat Deflection Temperature	@ 66 psi	ASTM D-648	77° C

## Handling Properties

Mix Ratio	by weight	Part A	100 parts by weight
		Part B	100 parts by weight
Mix Ratio	by volume	Part A	90 parts by volume
		Part B	100 parts by volume
Specific Gravity	g/cc	Part A	1.20
		Part B	1.02
Viscosity	cps at 25° C	Part A	175
		Part B	400
		Mixed	250
Color		Part A	Light yellow, clear
		Part B	Creamy White, opaque
Work Time	100g mass @ 25° C		2 - 2 1/4 minutes
Demold Time	@ 25° C		30-60 minutes (see Note 1)
Cure Schedule	3 days ambient; or demold followed with a short post cure of 4-6 hours @ 71° C is recommended to promote maximum physical properties		

## Storage

Store at room temperature in a dry area. Unopened containers will have a shelf life of six months, from date of shipment, when properly stored under normal conditions at 25° C.

## Note 1

TC-808 A/B generally cures to a demoldable state in about 30 minutes; however, thin sections or certain part configurations may require more in-mold cure time. TC-808 A/B gains increasing toughness early in the cure cycle and thick sections, (3/8" or greater), may be demolded much sooner. Sections that are less than an 1/8" may require an hour or more before demold.

## Note 2

The "B" side should be remixed before each use until uniform in appearance. Opened containers of material should be purged with dry nitrogen prior to replacing lids or caps to prevent moisture contamination from humid air.

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1

## Disclaimer

The data presented in this leaflet are in accordance with the present state of our knowledge, and does not absolve the user from carefully checking all supplies immediately on receipt. We reserve the right to alter product constants within the scope of technical progress or new developments. The recommendations made in this leaflet should be checked by preliminary trials because of conditions during processing over which we have no control, especially where other companies' raw materials are also being used. Recommendations for use do not constitute a warranty, either expressed or implied, of the fitness or suitability of the product for a particular purpose.

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