



# RIGID FILLED & UNFILLED URETHANES

"Dedicated to *QUALITY, SERVICE, SAFETY, and INNOVATION*"

## TC-875 A/B FR

### RIGID 78 SHORE D URETHANE CASTING SYSTEM

**PRODUCT DESCRIPTION:**

TC-875 A/B FR is a two component liquid castable urethane that produces a high impact 78 Shore D engineering plastic. Typically, it is used for making production molded parts. With a working time of 4 minutes, a volume ratio of 80/100, and low viscosity, TC875 FR is well suited for variable ratio machine dispensing.

**PRODUCT USES:**

- Computer housings
- Models of all kinds
- Artwork components
- Architectural models
- Gears, wheels, fans
- Transportation cases
- Levels, pedals
- Miniatures movie props parts
- Simulating injection molded pieces

**CURED PROPERTIES:**

Hardness, Shore D .....	78
Specific Gravity {gm/cc}/Part A.....	1.17
Specific Gravity (gm/cc)/Part B.....	1.33
Specific Gravity (gm/cc)/Density, cured.....	1.26
Displacement (cu.in/lb).....	22.0
Color.....	White
Tensile Strength (psi) ASTM D 638.....	7490
Elongation (%) ASTM D 638.....	1.7
Tensile Modulus, (psi).....	.5 x 10 <sup>5</sup>
Flexural Strength (psi) AST M D790.....	8,800
Flexural Modulus (psi) AST M D790.....	.2.8 x 10 <sup>5</sup>
Shrinkage (in./in.) AS1MD 2566.....	.003
Shrinkage (in./in) 12" x 0.25 in <sup>2</sup> .....	.0022
Flammability Test UL 94.....	passes V - 0 to 0.125"

**HANDLING PROPERTIES:**

Mix Ratio:Resin Part B.....	80 parts by volume (70 parts by Weight)
Curative Part A.....	100 parts by volume (100 parts by Weight)
Viscosity, Centipoise (cps) @ 77° F.:	
Resin Part B.....	125 CPS
Curative Part A.....	700 CPS
Mixed Viscosity (cps) .....	350 CPS
Color: Resin Part A.....	Translucent yellow
Curative Part B.....	Opaque, off white
Work Life @ 75° F.....	Approx. 4 minutes
Demold Time .....	1-1 1-2 hours
Cure Schedule .....	3-5 days at room temperature (75°F± 5°F);heat resistance, parts should be post cured at 160 of for 6 hours. See Heat Curing

