



# RIGID FILLED & UNFILLED URETHANES

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

## TC-875 A/B

### RIGID 75 SHORE D URETHANE CASTING SYSTEM

**PRODUCT DESCRIPTION:**

TC-875 A/B is a two component liquid castable urethane that produces a high impact 75 Shore D engineering plastic. Typically, it is used for making production molded parts. With a working time of 2 - 3 minutes, a volume ratio of one to one, and low viscosity, TC-875 is ideally suited for "meter mix" machine dispensing or prototype LRIM (liquid reaction injection molding).

**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.....	75 ± 2
Specific Gravity (gm/cc )/Density part A.....	1.17
Specific Gravity (gm/cc )/Density part B ...	1.04
Specific Gravity (gm/cc )/Density mixed.....	1.11
Cu. in per pound .....	25.2
Color.....	Off White
Tensile Strength (psi) ASTM D 638-82 .....	6,450
Tensile Modulus, (psi).....	127, 500
Compressive stress, 10% strain, psi.....	85,000
Elongation (%) ASTM D 638-82 .....	4.0%
Shrinkage (in./in.) ASTM D 2566-79 .....	.003
Post cured, 6 hours @ 160°F.....	.005
Shrinkage (in./in.) 0.5" square, 12" bar .....	.0022
Post cured, 6 hours @ 160°F.....	.004

**HANDLING PROPERTIES:**

Mix Ratio:Resin Part A	100 parts by volume (100 parts by Weight)
Curative Part B.....	100 parts by volume (90 parts by Weight)
Viscosity, Centipoise (cps) @ 77° F.:	
Resin Part A.....	125 CPS
Curative Part B.....	400 CPS
Mixed Viscosity (cps) .....	250 ±10 CPS
Color: Resin Part A.....	Translucent yellow
Curative Part B.....	Off white
Work Life @ 75° .....	Aprox. 2 minutes
Demold Time .....	1-1 1/2 hours
Cure Schedule .....	For ultimate heat distortion the material should be post cured at 160° F. or 6 hours. This gives an HDT of 155° F.

