

BJB Polyurethane TC-670 A/B

Polyurethane Thermoset Elastomer

BJB Enterprises, Inc.

Message:

TC-670 A/B is a two-component polyurethane elastomer compound. This product is a safe, easy-to-handle, room temperature mixing and curing system that contains no TDI, MDI, MDA, or MOCA. The low shrinkage, superior toughness, and excellent detail reproduction of TC-670 A/B makes this system ideal for general-purpose castings and quality tooling operations. TC-670 A/B contains UV ray stabilizers to provide added protection when used in outdoor applications.

General Information			
Additive	UV stabilizer		
Features	Good UV resistance		
	Good toughness		
	Low shrinkage		
	aliphatic		
Uses	Mold/Mold/Tool		
Appearance	Transparent amber		
Forms	Liquid		
Processing Method	Casting		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
-- ¹	1.06	g/cm ³	
-- ²	1.11	g/cm ³	
--	1.10	g/cm ³	ASTM D792
Shrinkage	0.30	%	ASTM D2566
Gel Time	25.0	min	
Work Time ³ (25°C)	20.0	min	
Cure Time (25°C)	5.0 - 7.0	day	
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A)	65 - 70		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
100% strain	1.92	MPa	ASTM D412
200% strain	2.64	MPa	ASTM D412
300% strain	3.22	MPa	ASTM D412
Tensile Strength (Yield)	9.10	MPa	ASTM D412
Tensile Elongation (Break)	800	%	ASTM D412
Tear Strength	30.5	kN/m	ASTM D624
Thermoset	Nominal Value	Unit	Test Method
Thermoset Components			

Component a	Mixing ratio by weight: 100, mixing ratio by capacity: 100		
Component B	Mixing ratio by weight: 95, mixing ratio by capacity: 91		
Shelf Life	26	wk	
Thermoset Mix Viscosity			Brookfield
25°C ⁴	65.0	cP	Brookfield
25°C ⁵	6000	cP	Brookfield
25°C	1360	cP	Brookfield
Demold Time	240 - 360	min	
Additional Information	Nominal Value	Unit	Test Method

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 130-160°F (54-71°C).

NOTE

1. Part A
2. Part B
3. 100g mass
4. Part B
5. Part A

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