

# BJB Polyurethane TC-812 A/B LIGHTCAST

Polyurethane

BJB Enterprises, Inc.

## Message:

TC-812 A/B is a light weight filled, low viscosity, quick setting, easy to use casting material. A model or tool cast from TC-812 A/B will weigh 40% less than other unfilled urethane systems. Within 60 minutes after mixing and pouring, it is ready to be carved, sanded, filed, tapped, etc. Its characteristics make it ideal for lightweight backing of laminates and/or surface coats. Perfect for fast take offs, cores, engineering changes, temporary molds, patterns, models, prototypes, and bases for die molds.

General Information			
Features	Low Viscosity		
Uses	Molds/Dies/Tools		
	Prototyping		
Forms	Liquid		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			ASTM D792
-- <sup>1</sup>	0.608	g/cm <sup>3</sup>	
--	0.638	g/cm <sup>3</sup>	
-- <sup>2</sup>	0.648	g/cm <sup>3</sup>	
Specific Volume	1.57	cm <sup>3</sup> /g	
Gel Time	6.0	min	
Work Time <sup>3</sup> (25°C)	4.0	min	
Molding Shrinkage - Flow	0.30	%	ASTM D2566
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	60 to 65		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	17.8	MPa	ASTM D638
Flexural Modulus	1180	MPa	ASTM D790
Flexural Strength	18.8	MPa	ASTM D790
Compressive Strength	21.0	MPa	ASTM D695
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	56.1	°C	ASTM D648
Thermoset	Nominal Value	Unit	Test Method
Thermoset Components			
Part A	Mix Ratio by Weight: 100		
Part B	Mix Ratio by Weight: 100		
Shelf Life	26	wk	
Thermoset Mix Viscosity			ASTM D2393
25°C <sup>4</sup>	875	cP	

25°C <sup>5</sup>	650	cP
25°C <sup>6</sup>	750	cP
Demold Time (25°C)	60	min

#### NOTE

- |    |                    |
|----|--------------------|
| 1. | Part B             |
| 2. | Part A             |
| 3. | 1/2lb mass         |
| 4. | Part B, Brookfield |
| 5. | Part A, Brookfield |
| 6. | Mixed, Brookfield  |

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#### Recommended distributors for this material

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