

BJB Epoxy TC-1650 A/B

Epoxy; Epoxide
BJB Enterprises, Inc.

Message:

TC-1650 A/B is an aluminum powder filled epoxy casting resin system that provides service temperatures to 350°F (177°C). TC-1650 A/B is most commonly used for the construction of molds that require good heat conductivity, outstanding durability and provide production run capability. The majority of applications for TC-1650 A/B are used in conjunction with other materials in developing composite mold structures, however, the TC-1650 A/B is frequently used by itself.

General Information			
Filler / Reinforcement	Aluminum		
Uses	Molds/Dies/Tools		
Forms	Liquid		
Processing Method	Casting		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.76	g/cm ³	ASTM D792
Shrinkage	0.20	%	ASTM D2566
Demold Time (24 to 27°C)	16.0 to 24.0	hr	
Gel Time	1.5	hr	
Work Time ¹ (25°C)	1.0	hr	
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	90		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	56.2	MPa	ASTM D638
Flexural Modulus	7310	MPa	ASTM D790
Flexural Strength	76.5	MPa	ASTM D790
Compressive Strength	192	MPa	ASTM D695
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	139	°C	ASTM D648
CLTE - Flow	3.4E-5	cm/cm/°C	ASTM D3386
Thermoset	Nominal Value	Unit	Test Method
Thermoset Components			
Part A	Mix Ratio by Weight: 100		
Part B	Mix Ratio by Weight: 7.0		
Shelf Life	52	wk	
Thermoset Mix Viscosity (25°C)	15500	cP	ASTM D2393
NOTE			
1.	1 lb mass		

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