

# BJB Polyurethane TC-640 A/B

Polyurethane Thermoset Elastomer

BJB Enterprises, Inc.

Message:

TC-640 is a multi-purpose elastomer that can perform many functions. Typical product uses and features are:

- Mold fabrication
- Skin membranes for animated characters
- Bumpers and many types of urethane rubber parts
- Excellent as an adhesive for resilient and flexible bonds
- Highly water-resistant. Insensitive to moisture during cure

General Information			
Features	Aliphatic		
	Good Adhesion		
	Good Flexibility		
	Low to No Water Absorption		
	Resilient		
Uses	Adhesives		
	Automotive Bumper		
	Bonding		
	Membranes		
Appearance	Clear Amber		
Forms	Liquid		
Processing Method	Casting		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
-- <sup>1</sup>	0.998	g/cm <sup>3</sup>	ASTM D792
-- <sup>2</sup>	1.02	g/cm <sup>3</sup>	
Molding Shrinkage - Flow	0.10	%	ASTM D2566
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A)	30 to 40		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	2.41	MPa	ASTM D412
Tensile Elongation (Break)	750	%	ASTM D412
Tear Strength	8.76	kN/m	ASTM D624
Thermoset	Nominal Value	Unit	Test Method
Thermoset Components			
Part A	Mix Ratio by Weight: 100		
Part B	Mix Ratio by Weight: 100		
Shelf Life (25°C)	26	wk	

Thermoset Mix Viscosity <sup>3</sup> (25°C)	3200	cP	ASTM D2393
Demold Time (25°C)	960 to 1400	min	
Post Cure Time (27°C)	120 to 170	hr	
Gel Time	1.0	hr	
Work Time <sup>4</sup> (25°C)	45.0	min	

#### NOTE

- |    |                   |
|----|-------------------|
| 1. | Part B            |
| 2. | Part A            |
| 3. | Mixed, Brookfield |
| 4. | 100 g mass        |

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