

# BJB Epoxy TC-1604 A/B

Epoxy; Epoxide

BJB Enterprises, Inc.

## Message:

TC-1604 A/B is a filled, easy to apply, laminating epoxy resin for variety of fabricating applications. Designed to be used with heavier weight fiberglass cloth (typically 8-10 oz. tooling fabric), TC-1604 can produce thick laminates without excess draining of the resin. Being a very stable system with low shrinkage, its common usages include:

Drill and Trim Fixtures

Pattern/Foundry Applications

Composite Tooling

Support Shells for Silicone Glove Molds.

It features the ability to cure at room temperature for applications that do not require a working service temperature above 224°F (107°C). TC-1604 can also be used as an adhesive for bonding wood, composites, and other materials. Adding fillers like fumed silica, micro-spheres, and short-strand fibers can create pastes for fillets, fairings, and bonding applications.

General Information			
Filler / Reinforcement	Filler		
Features	Low Shrinkage		
Uses	Adhesives		
	Laminates		
Appearance	White		
Forms	Liquid		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.30	g/cm <sup>3</sup>	ASTM D792
Specific Gravity			
Part A : 25°C	1.280	g/cm <sup>3</sup>	
Part B : 25°C	1.017	g/cm <sup>3</sup>	
Water Absorption - 100 hr	1.3	%	ASTM D570
Shrinkage	0.015	%	ASTM D2566
Work Time (25°C) <sup>1</sup>	20.0	min	
Brookfield Viscosity - Mixed (25°C)	8.00	Pa · s	
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	89		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	221	MPa	ASTM D638
Flexural Modulus	15900	MPa	ASTM D790
Flexural Strength	269	MPa	ASTM D790
Compressive Strength	276	MPa	ASTM D695
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	107	°C	ASTM D648
CLTE - Flow	2.2E-5	cm/cm/°C	ASTM D3386

Thermoset	Nominal Value	Unit
Thermoset Components		
Part A	Mix Ratio by Weight: 100	
Part B	Mix Ratio by Weight: 12	
Shelf Life	52	wk
NOTE		
1.	1 lb mass	

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#### Recommended distributors for this material

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