

# BJB Polyurethane TC-816 A/B

Polyurethane  
BJB Enterprises, Inc.

Message:

TC-816 A/B is a durable, filled polyurethane system that offers excellent duplication properties. TC-816 A/B exhibits low shrink, low exotherm and quick demold times.

Product Highlights:

- Exceptionally low viscosity
- Workable in semi-gel stage as a paste if desired
- Low exotherm contributing to low shrinkage
- Will readily bond to itself
- Greater settling resistance
- Integrates well with epoxy surface coats for polishable tools
- Safe to use with platinum based silicones

General Information			
Features	Durable		
	High Viscosity		
	Low Exotherm		
	Low Shrinkage		
Uses	Tooling		
RoHS Compliance	RoHS Compliant		
Appearance	Grey		
	Opaque		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.62	g/cm <sup>3</sup>	ASTM D792
Specific Gravity			
Part A : 25°C	1.596	g/cm <sup>3</sup>	
Part B : 25°C	1.596	g/cm <sup>3</sup>	
Shrinkage	0.40	%	ASTM D2566
Work Time (25°C) <sup>1</sup>	5.0	min	
Brookfield Viscosity - Mixed (25°C)	1.00	Pa · s	
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	83 to 87		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Compressive Strength	63.4	MPa	ASTM D695
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	103	°C	
1.8 MPa, Unannealed	97.8	°C	
Thermoset	Nominal Value	Unit	

Thermoset Components		
Part A	Mix Ratio by Weight: 100	
Part B	Mix Ratio by Weight: 100	
Shelf Life	26	wk
Demold Time <sup>2</sup> (25°C)	60 to 120	min
NOTE		
1.	1-lb. mass	
2.	mass dependent	

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