

Ultracast II TC-1630 A/B

Polyurethane Thermoset Elastomer

BJB Enterprises, Inc.

Message:

TC-1630 A/B Ultracast is a very hard, tough, fast setting filled polyurethane casting resin system which is ideal for a wide range of casting jobs such as pattern duplication, vacuum forming tools, tracing tools, foundry core boxes, wax casting molds, and general casting molds.

- Product Highlights:
- Foam Latex Molds
 - Excellent Heat Resistance
 - Low Shrinkage, Low Exotherm
 - Short Demold Time
 - Excellent Detail Reproduction
 - Low Viscosity

General Information			
Features	Good Toughness		
	High Hardness		
	High Heat Resistance		
	Low Shrinkage		
	Low Viscosity		
RoHS Compliance	RoHS Compliant		
Appearance	Grey		
	Opaque		
Forms	Liquid		
Processing Method	Casting		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
Part A	1.726	g/cm ³	
Part B	1.596	g/cm ³	
Specific Volume	0.596	cm ³ /g	
Color			
Part A	Black		
Part B	White		
Demold Time (25°C)	1.0	hr	
Gel Time	7.0 to 8.0	min	
Work Time (25°C) ¹	5.0 to 6.0	min	
Brookfield Viscosity			
Mixed : 25°C	1.10	Pa · s	
Part A : 25°C	0.900	Pa · s	
Part B : 25°C	1.30	Pa · s	
Density	1.80	g/cm ³	ASTM D792

Molding Shrinkage - Flow ²	0.20	%	ASTM D2566
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	82 to 86		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Flexural Strength	42.9	MPa	ASTM D790
Compressive Strength	57.9	MPa	ASTM D695
Thermoset	Nominal Value	Unit	
Thermoset Components			
Part A	Mix Ratio by Weight: 100, Mix Ratio by Volume: 93		
Part B	Mix Ratio by Weight: 100, Mix Ratio by Volume: 100		
Shelf Life (25°C)	13	wk	
NOTE			
1.	100g mass		
2.	1" depth		

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