PRODUCT BULLETIN

TCC-204
ADHESIVE SYSTEM

THIXATROPIC

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DESCRIPTION

Epoxy Resin **TCC-204** with either Epoxy Hardener **TCC-102** or **TCC-104** is a rigid adhesive system designed to be slightly thixatropic for ease of application. This system is used as an adhesive for wood, plastic and Tooling Planks.

HANDLING CHARACTERISTICS AND PHYSICAL PROPERTIES @ 25°C/77°F

Mix Ratio (parts by weight)	Resin TCC-204	100 parts
	Hardener TCC-102 or TCC-104	25 parts
Mixed Viscosity		17,000 cps
Mixed Specific Gravity		92
Mixed Color		Cream
Heat Distortion Temperature		155°F - 160°F
Hardness		85 Shore D
Shelf Life (in original unopened containers)	TCC-204/TCC-102 or TCC-104	2 years

	TCC-102	**TCC-104**
Pot Life (100 gram mass)	15 - 20 minutes	30 - 35 minutes
(1 pound mass)	8 - 10 minutes	12 - 14 minutes
Cure Schedule (Tack Free)	1 - 2 hours	2 - 3 hours
(Rigid)	2 - 4 hours	4 - 8 hours

SANITARY PRECAUTIONS

Do not take internally. Avoid prolonged breathing of vapors. Work in a well-ventilated area. Avoid skin contact. Protective gloves should be worn. If contact occurs: wash skin with soap and water. Avoid eye contact. If contact occurs: rinse well with water for 15 minutes, contact physician.

STORAGE AND HANDLING

Store at room temperature. Mix resin well before use.

TCC-204 Tech/Revised 5/20/10
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