PRODUCT BULLETIN

TCC-230
ADHESIVE SYSTEM
TOUGHENED EPOXY
ADHESIVE FOR
TOOLING PLANKS

TOOL CHEMICAL COMPOSITES

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DESCRIPTION

TCC-230 is a two-component toughened epoxy adhesive system that was developed to be used to bond our TCC Tooling Planks together. The physical properties closely resemble our CNC Tooling Planks and it is an excellent adhesive because of its ease of use during block-up. Once cured, the **TCC-230** shows minimal glue lines. This adhesive system is well suited for our Tooling Planks that are used for ambient temperature applications.

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

Mix Ratio (parts by weight)	Resin TCC-230/Hardener TCC-102 or TCC-104	100R/17H
Pot Life (100 gram mass)	TCC-102 Hardener	5 minutes
	TCC-104 Hardener	20 minutes
Mixed Specific Gravity		1.06
Mixed Viscosity		4,400 cps
Mixed Color		Amber
Peak Operating Temperature		200°F
Hardness		75 - 80 Shore D
Cure Time		12 - 24 hours
Machinability		Good
Shelf Life (in original unopened containers)	TCC-230/TCC-102 or TCC-104	2 years

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.

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