PRODUCT BULLETIN

TCC-602/115NF SURFACE COAT SYSTEM

HIGH TEMPERATURE
ALUMINUM FILLED

TOOL CHEMICAL COMPOSITES

www.CASSpolymers.com **800.344.7776** **TCC@CASSpolymers.com**
31200 Stephenson Hwy **Madison Heights MI 48071** **Ph 248.588.2270 Fax 248.588.5909**

DESCRIPTION

Epoxy Resin **TCC-602** with Epoxy Hardener **TCC-115NF** is an aluminum filled surface coat for use in conjunction with TCC's high temperature laminating and casting systems. This high temperature surface coat system exhibits excellent sag resistant properties for ease of application, high impact and thermal resistant properties.

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

Mix Ratio (parts by weight)	Resin TCC-602/Hardener TCC-115NF	100R/12H
Pot Life (100 gram mass)		15 minutes
Tack Time		1 ½ hours
Viscosity:		
	Resin TCC-602	21,000 cps
	Hardener TCC-115NF	150 cps
	Mixed Viscosity	Paste
Peak Operating Temperature		300°F
Linear Shrinkage		.0015 in/in
Mixed Specific Gravity		1.27
Mixed Color		Aluminum
Coefficient of Linear Thermal Expansion		4.9 x 10^{-5} in/in/°F
Hardness		80 - 85 Shore D
Compressive Strength		37,000 psi
Tensile Strength		9,850 psi
Flexural Strength		13,000 psi
Cure Time		12 - 24 hours
Shelf Life (in original unopened containers)	TCC-602/TCC-115NF	2 years

POST CURE SCHEDULE

This epoxy system will cure to a demoldable state in 12 to 24 hours if the tool is kept at an ambient temperature (70°F - 75°F). A post cure is required if the tool is to be used at elevated temperatures

Place tool in oven at room temperature and then set oven to 150°F. Cure for 2 hours at 150°F (66°C). Raise oven temperature and continue cure for 2 hours at 200°F (94°C). Raise oven temperature and continue cure for 2 more hours at 250°F (121°C). Turn oven off and let cool slowly in oven until tool reaches room temperature.

These curing times may have to be extended for large tools. For applications over 300°F (148°C), or for large tools, consult your CASS Polymers Company Representative.

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, consult physician.

STORAGE

Store at room temperature. Before use, mix resin well with mechanical device.

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