PRODUCT BULLETIN

TCC-625/115N
LAMINATING SYSTEM

INTERMEDIATE/HIGH TEMP
ALUMINUM FILLED

TOOL CHEMICAL COMPOSITES

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DESCRIPTION

Epoxy Resin **TCC-625** with Epoxy Hardener **TCC-115N** is an aluminum filled laminating system designed for use when intermediate to high heat resistance is required. When cured this material demonstrates excellent thermal shock characteristics, low thermal degradation properties and high impact resistance at elevated temperatures. This system is used for compression molds, vacuum form molds or in any tools to be used at elevated temperatures.

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

Mix Ratio (parts by weight)	Resin TCC-625/Hardener TCC-115N	100R/10H
Pot Life (400 gram mass)		60 minutes
Linear Shrinkage		0.0015 in/in
Mixed Specific Gravity		1.48
Viscosity:		
	Resin TCC-625	12,000 cps
	Hardener TCC-115N	20 cps
	Mixed Viscosity	3,000 cps
Color:		
	Resin TCC-625	Aluminum
	Hardener TCC-115N	Amber
	Mixed Color	Aluminum
Coefficient of Linear Thermal Expansion		4.9 x 10^{-5} in/in/°F
Hardness		85 Shore D
Compressive Strength		37,000 psi
Tensile Strength		9,850 psi
Flexural Strength		13,000 psi
Heat Deflection Temperature @ 66 psi		97°C/207°F
Cure Time		12 - 24 hours
Shelf Life (in original unopened containers)	TCC-625/TCC-115N	2 years

POST CURE SCHEDULE

This epoxy system will cure to a demoldable state in 12 to 48 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, contact physician.

STORAGE

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

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