PRODUCT BULLETIN

TCC-626/116A SURFACE CASTING SYSTEM

HIGH TEMPERATURE
WHITE, BLACK

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DESCRIPTION

Epoxy Resin **TCC-626** with Epoxy Hardener **TCC-116A** was designed specifically for high temperature surface casting applications. When cured, this material has excellent thermal shock characteristics, low thermal degradation properties and high impact resistance at elevated temperatures.

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

Mix Ratio (parts by weight)	Resin TCC-626/Hardener TCC-116A	100R/12H
Pot Life (500 gram mass)		2 hours
Linear Shrinkage		0.0015 in/in
Mixed Specific Gravity		1.43
Viscosity:		
	Resin TCC-626	12,000 cps
	Hardener TCC-116A	15 cps
	Mixed Viscosity	3,000 cps
Color:		
	Resin TCC-626	White/Black
	Hardener TCC-116A	Clear
	Mixed Color	White/Black
Hardness		85 Shore D
Compressive Strength		37,000 psi
Tensile Strength		9,000 psi
Flexural Strength		13,000 psi
Heat Deflection Temperature @ 66 psi (following 300°F post cure)		103°C/217°F
Cure Time		12 - 24 hours
Shelf Life (in original unopened containers)	TCC-626/TCC-116A	2 years

POST CURE SCHEDULE

This epoxy system will cure to a demoldable state in 12 to 48 hours if the tool is kept in 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 very 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.

TCC-626 Tech/Revised 8/10/11
Supercedes 5/24/10

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