



TCC-90 A/B POLYURETHANE ADHESIVE SYSTEM

FAST

PRODUCT BULLETIN



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DESCRIPTION

TCC-90 A/B is a self-extinguishing cream colored adhesive designed for use with our polyurethane foam boards. The strength of this adhesive bond will exceed the strength of the 10#, 15# or 20# density polyurethane foam boards. The TCC-90 A/B will expand slightly on cure to fill gaps between boards, minimizing voids along bond lines.

HANDLING CHARACTERISTICS @ 25°C/77°F

Mix Ratio (by weight).....	Resin TCC-90A/Hardener TCC-90B.....	100R/100H
Mix Ratio (by volume)	Resin TCC-90A/Hardener TCC-90B.....	90R/100H
Pot Life (200 gram mass).....		4 - 6 minutes
Peak Exotherm (after 15 minutes)		275°F
Mixed Viscosity (@ 2 minutes)		
(LVT #4, 6 rpm)		9,000 cps
(LVT #4, 60 rpm)		7,400 cps
Thixotropic Index.....		1.2
Color.....	Resin TCC-90A.....	Dark Amber
	Hardener TCC-90B.....	Dark Red
	Cured Color.....	Cream
Shelf Life (in original unopened containers).....		2 years

*It is not recommended mixing more than 400 grams at a time, due to the high exotherm generated in a large mass.

GENERAL USAGE INFORMATION

- 1.) Weigh out 100 to 200 grams of TCC-90A and TCC-90B and thoroughly mix the two components together. The adhesive will thicken and turn dark amber on mixing.
- 2.) Quickly apply a thin layer to each surface to be joined by brushing or using a squeegee. When the adhesive is spread out into a thin layer the open time before joining surfaces will be 10 to 20 minutes depending on shop temperature and humidity.
- 3.) It is recommended that the joined surfaces be clamped together to minimize the bond line. TCC-90 A/B Polyurethane Adhesive will expand slightly on cure to fill gaps between boards, minimizing voids along bond lines.
- 4.) After joining, bond lines are sandable in 2 to 4 hours depending on temperature and humidity.
- 5.) TCC-90 A/B cures completely in 16 to 24 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, consult physician.

STORAGE AND HANDLING

Store closed containers at 65°F - 85°F. Partially used containers must be blanketed with dry nitrogen and resealed.

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