

**TC-861 REV 1 A/B**  
**RIGID 60 SHORE D POLYURETHANE**  
**CASTING SYSTEM**



TC-861 REV 1 A/B is translucent and extremely easy to color. This tough "LDPE" like product is very user friendly. This versatile material easily demolds in less than 3 hours and has extremely high impact.

- RoHS/REACH Compliant
- High Impact
- Mercury/Phthalate Free
- Translucent, Easy to Color
- Similar to LDPE
- Low Viscosity
- Demold in 2 Hours

PHYSICAL PROPERTIES	TEST METHOD	RESULTS
Hardness, Shore D	ASTM D2240-04e1	60 ± 5
Density (g/cc)	ASTM D792-00	1.085
Cubic Inches per Pound	N/A	25.49
Color/Appearance	Visual	Translucent Pale Yellow
Tensile Strength (psi)	ASTM D638-03	3,000
Tensile Modulus (psi)	ASTM D638-03	70,000
Elongation (%)	ASTM D638-03	55
Tear Strength (pli)	ASTM D624-00e1	180
Flexural Strength (psi)	ASTM D790-03	2,100
Flexural Modulus (psi)	ASTM D790-03	52,000
Shrinkage (in/in) linear	12"x 1/2" x 1/2"	0.0056
Izod Impact, notched (ft-lb/in)	ASTM D256-05	1.4
Izod Impact, unnotched (ft-lb/in)	ASTM D256-05	>16
Heat Deflection Temperature @ 66 psi	ASTM D648-04	150°F (65.6°C)
Heat Deflection Temperature @ 264 psi	ASTM D648-04	115°F (46.1°C)
Dielectric Constant, 1 MHz	ASTM D150-87	3.963
Dissipation Factor, 1 MHz	ASTM D150-87	0.0397

\*Note: Reported physical properties are based on test specimens cured 1-3 hours at room temperature then 16 hours at 160°F (71°C).

HANDLING PROPERTIES	Part A	Part B
Mix Ratio by weight	100	92
Mix Ratio by volume	100	100
Specific Gravity @ 77°F (25°C)	1.13	1.042
Color	Pale Yellow	Pale Yellow
Viscosity (cps) @ 77°F (25°C) Brookfield	350	1,500
Mixed Viscosity (cps) @ 77°F (25°C) Brookfield	620	
Work Time, 100g mass @ 77°F (25°C)	6 – 7 minutes	
Gel Time	8 – 9 minutes	
Demold Time @ 77°F (25°C)	1 – 2 hours	

Properties above are typical and not for specifications.

**IMPORTANT MIXING DIRECTION:**

It is important to remix the “B” component thoroughly prior to each use before combining with the “A” side.

**CURE SCHEDULE:**

Most of the physical properties can be achieved in 5-7 days at 77°F (25°C). You may use your own post-cure schedule but the physical properties may vary from BJB’s cure schedule of 1-3 hours at 77°F (25°C) followed by 16 hours at 160 °F (71°C). Do not exceed curing temperatures of 200°F (93°C). Support of the part may be required to prevent part deformation during the heat curing process.

**ACCESSORIES:**

BJB offers silicone RTV mold making materials along with a wide range of accessory items. These include de-airing agents, pigments, mold releases, and Jiffy® Mixers. Visit BJB’s website at [www.bjbenterprises.com](http://www.bjbenterprises.com) or consult a BJB representative for more information.

**STORAGE:**

Store at ambient temperatures, 65-80°F (18-27°C). Unopened containers will have a shelf life of 6 months from date of shipment when properly stored at recommended temperatures. Purge opened containers with dry nitrogen before re-sealing.

PACKAGING	Part A	Part B	Cubic Inches per Kit
Quart Kits	2 lbs.	1.84 lbs.	98
Gallon Kits	8 lbs.	7.36 lbs.	392
5-Gallon Kits	40 lbs.	36.8 lbs.	1,958
55-Gallon Drum Kits	440 lbs.	404.8 lbs.	21,534

**SAFETY PRECAUTIONS:**

Use in a well-ventilated area. Avoid contact with skin using protective gloves and protective clothing. Repeated or prolonged contact on the skin may cause an allergic reaction. Eye protection is extremely important. Always use approved safety glasses or goggles when handling this product.

**IF CONTACT OCCURS:**

**Skin:** Immediately wash with soap and water. Remove contaminated clothing and launder before reuse. It is *not* recommended to remove resin from skin with solvents. Solvents only increase contact and dry skin. Seek qualified medical attention if allergic reactions occur.

**Eyes:** Immediately flush with water for at least 15 minutes. Call a physician.

**Ingestion:** If swallowed, call a physician immediately. Remove stomach contents by gastric suction or induce vomiting only as directed by medical personnel. Never give anything by mouth to an unconscious person.

Refer to the Material Safety Data Sheet before using this product.



Handling Guide



TC-861 REV 1 Part A SDS



TC-861 REV 1 Part B SDS

NON-WARRANTY "Except for a warranty that materials substantially comply with the data presented in Manufacturer's latest bulletin describing the product (the basis for this substantial compliance is to be determined by the standard quality control tests generally performed by Manufacturer), all materials are sold "AS IS" and without any warranty express or implied as to merchantability, fitness for a particular purpose, patent, trademark or copyright infringement, or as to any other matter. In no event shall Manufacturer's liability for damages exceed Manufacturer's sale price of the particular quantity with respect to which damages are claimed."