



**TCC-410
SURFACE/MASS
CASTING SYSTEM
IMPACT RESISTANT**

PRODUCT BULLETIN



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DESCRIPTION

Epoxy Resin **TCC-410** is an aluminum filled system designed for high-impact resistance. This system can be surface cast to metal or other low-cost cores or it may be mass casted. Depending on thickness of cast, a choice of hardeners is provided to control exothermic heat and shrinkage. Applications for this system include casting surfaces on prototype stamping dies or mass casting applications where high-impact resistance is desired.

TYPICAL HANDLING CHARACTERISTICS @ 77°F (25°C) AND HARDENER SELECTION

Thickness of Cast	Surface Cast ½” - 1”	Mass Cast 1” - 4”	Mass Cast 4” - 10”
Hardener Selection	TCC-104	TCC-104-5	TCC-105
Mix Ratio (parts by weight):			
..... Resin TCC 410.....	100 parts.....	100 parts.....	100 parts
..... Hardener.....	10 parts.....	10 parts.....	10 parts
Pot Life (500 gram mass)	60 minutes.....	100 minutes.....	2 - 3 hours
..... Peak Exotherm.....	200°F (93°C).....	N/A.....	N/A
Peak Operating Temperature	180°F (82°C).....	210°F (99°C).....	240°F (116°C)
Cure Time	8 - 12 hours.....	18 - 36 hours.....	48 - 72 hours

TYPICAL PHYSICAL PROPERTIES (with TCC-104 Hardener) @ 77F/25C

Specific Gravity.....	1.65 g/cc
Mixed Viscosity.....	5,000 cps
Cured Color.....	Aluminum
Linear Shrinkage.....	0.0015 in/in..... 0.0015 in/in
Hardness.....	84 Shore D
Notched Izod Impact Strength.....	85 ft lbs/in
Tensile Strength.....	7,000psi/48MPa
Shelf Life (in original unopened containers).....	TCC-410/TCC-104, TCC-104-5, or TCC-105.....2 years

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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