



**TCC-626/116A
SURFACE
CASTING SYSTEM
HIGH TEMPERATURE
WHITE, BLACK**

PRODUCT BULLETIN



www.axson-technologies.com 800.344.7776 axsonmh@axson.com
31200 Stephenson Hwy Madison Heights, MI 48071 Ph 248.588.2270 Fax 248.588.5909

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.

TYPICAL HANDLING CHARACTERISTICS AND PHYSICAL PROPERTIES @ 77°F (25°C)

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
Specific Gravity		1.43g/cc
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		37,000psi (255MPa)
Tensile Strength		9,000psi (62MPa)
Flexural Strength		13,000psi (90MPa)
Heat Deflection Temperature @ 66 psi (following 300°F (149°C) postcure)		217°F (103°C)
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 70F-75°F (21°C-24°C). 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 (66°C). 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 (149°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 1/29/15
Supersedes 6/19/14

The information contained in this technical data sheet results from research and tests conducted in our laboratories under precise conditions. Seller cannot anticipate all conditions under which seller's products, or the products of other manufacturers in combination with seller's products, may be used. It is the responsibility of the user to determine the suitability of the Axson Technologies' products, under their own conditions, before commencing with the proposed application. In no event shall Axson Technologies, Inc. be liable for any direct, indirect, punitive, incidental, special, and/or consequential damages, to property or life, whatsoever arising out of or connected with the use or misuse of our products.

AXSON TECHNOLOGIES US +1 248 588 2270 axsonmh@axson.com axson-na.com	CHINA +86 21 58 68 30 37 marketing.china@axson.com	GERMANY +49 6 07 44 07 11-0 verkauf@axson.com	INDIA +91 20 25 56 07 10-11 info.india@axson.com	ITALY +39 02 96 70 23 36 axson@axson.it	JAPAN +81 5 64 26 25 91 sales.japan@axson.com	FRANCE Global Headquarters +33 1 34 40 34 60 axson@axson.com axson-technologies.com
	MEXICO +52 55 52 64 49 22 marketing@axson.com.mx	MIDDLE EAST +971 7 2432227 axsonmiddleeast@axson.com	SLOVAKIA +42 1 76 42 25 26 axson.sk@axson.com	SPAIN +34 9 32 25 16 20 spain@axson.com	U.K. +44 16 38 66 00 62 sales.uk@axson.com	