

## TECHNICAL DATA SHEET

# TCC-230

### EPOXY BOARD ADHESIVE

### TOUGHENED, TWO HARDENER CHOICES – TCC-102 & TCC-104

#### DESCRIPTION

*TCC-230 is a two-component toughened epoxy adhesive system for the Sika line of machinable polyurethane modeling and tooling boards for ambient temperature applications up to 180 °F (93°C).*

*TCC-230 can be used with either epoxy hardener TCC-102 or TCC-104 hardener for fast or medium pot life. This system is easy to use and has no objectionable fumes.*

- High mechanical properties
- Variable use hardeners
- Great ease of use during glue-up
- Medium mixed viscosity for lower run off
- Excellent adhesive properties
- Excellent machinability

#### PHYSICAL PROPERTIES

Property	Test Method	TCC-205 Resin	TCC-102 Hardener	TCC-104 Hardener
Composition		Epoxy	Amine	Amine
Mix ratio by weight		100	17	17
Cured color (mixed)			Clear amber	Clear amber
Specific gravity mixed (g/cc)			1.06	1.06
Mixed viscosity at 77°F (25°C) (Cps & mPas)	ASTM D2393		4,400	4,400
Pot life at 77°F (25°C) (100 g) (Minutes)	ASTM D2471		5 - 10	15 - 20
Cure time (hours)			12 - 16	16 - 24

#### Neat - Mechanical and Thermal Properties <sup>(1)</sup>

Property	Test Method	TCC-102 Hardener	TCC-104 Hardener
Hardness (Shore D)	ASTM D-2240	75 - 80	75 - 80

<sup>(1)</sup> The above properties were obtained under laboratory conditions using standardized specimens. Cured 7 days at room temperature

## HANDLING PRECAUTIONS

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Normal health and safety precautions should be observed when handling these products:

- Ensure good ventilation.
- Wear gloves, glasses and protective clothes.

For further information, please consult the Safety Data Sheets.

## STORAGE CONDITIONS

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- This product has a shelf life of 24 months for the resin and hardener as indicated by the expiration date on the container when stored in original unopened containers.

## PACKAGING

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Packaging information on request, please contact your local sales representative or find your local contact on [www.sikaadvancedresins.us](http://www.sikaadvancedresins.us)

## LEGAL NOTICE

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The information, and, in particular, the recommendations relating to the application and end-use of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

## CONTACT

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