INDUSTRIAL PRODUCTS

ITW resin TECHNOLOGIES

PHILLYBOND #6

Technical Bulletin # 470

Epoxy repair and patching compound

Product Description

PHILLYBOND #6 is a two-component, high strength epoxy paste for the repair of punctures or cracks in tanks, pumps, pipes, steam lines, sea chests, valve bodies, etc. The material is also used to fill holes, voids and to provide a smooth surface for repairs [at temperatures up to 428°F (220°C)], PHILLYBOND #6 is resistant to most acids, alkali and hydrocarbons and will adhere to clean surfaces such as steel, cast iron, bronze, aluminum, copper, nickel, wood and most plastics.

Surface Preparation

Repair surfaces must be clean and sound and free of oil, dirt, old paint and other foreign matter. Blast, abrade or clean surface with emery cloth to rough bright finish for best adhesion. Final rinse of surface with Impax IXT 59 solvent helps to ensure complete removal of grease and oils.

Mixing and Application Instructions

Mix white resin with black hardener - four parts resin to one part hardener by weight or volume - with putty knife or similar tool until a streak-free uniform color is achieved. As PHILLYBOND #6 is a fast curing system, mix only that amount that can be used in 10-15 minutes. Apply the mixed compound to the repair area forming a cross section of at least 3/8" (9.5mm) thick. The patch should extend at least 2" (5cm) on all sides of the damaged area. PHILLYBOND #6 may be smoothed by wetting putty knife with IXT 59 solvent or water. After hardening PHILLYBOND #6 can be machined or sanded, as desired, for a smoother surface.

Technical Information

COLOR:	Gray (resin – white; hardener – black)
CURE TIME:	1 hr @72 °F (22 °C) @ ½ " (12.7mm) thickness
MIXING RATIO:	4:1 by volume and weight
PACKAGING:	1 lb (454 grams) kit, 10 kits per case
	1 gallon (3.785 liter)kit
POT LIFE:	10 -15 minutes @72 °F (22 °C)
SHELF LIFE:	Two years/ Store in a cool dry area
TEMPERATURE RESISTANCE:	428 °F (220 °C)
SHEAR STRENGTH:	1000 psi (70.3 cm^2/kg)
VISCOSITY:	Paste putty
MIL SPEC:	R-17882-C

Date

07/2006

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ITW POLYMER TECHNOLOGIES
130 Commerce Drive • Montgomeryville, PA 18936 • 215-855-8450 • Fax 215-855-4688
www.itwresintech.com

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