



ITW REPAIR COMPOUND - A GENERAL PURPOSE REPAIR EPOXY & FAIRING COMPOUND

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TECHNICAL DATA SHEET #1015

VERSION: F

PRODUCT DESCRIPTION

ITW REPAIR COMPOUND (formerly known as PHILLYBOND Blue 6A) is a two-component epoxy paste developed specifically for filling, smoothing and fairing applications on metals, plastics (FRP), wood or masonry. The smooth consistency and excellent non-sagging properties of REPAIR COMPOUND make it unsurpassed for leveling rough or pitted plating, forming fillets, smoothing weld seams, etc.

REPAIR COMPOUND is nontoxic and contains no solvents. Resistance to fresh water, salt water, crude and refined oils, gasoline, jet fuel, etc., is excellent.

USE & BENEFITS

REPAIR COMPOUND is ideal for repairing and preparing surfaces of hulls, storage tanks, sonar domes, etc., for painting, fiber glassing or rubber lining where all welds, pitting, rough surfaces, or irregularities are required to be smoothed. The use of REPAIR COMPOUND provides a tough, uniform surface that will readily accept any top coating or lining.

Its exceptional troweling and application characteristics provide a smooth finished surface. If additional finishing is desirable, the cured epoxy is readily sanded or ground. The excellent feathering properties facilitate achieving a precision surface profile or smoothness.

Pump casings, impellers, sea chests, condenser boxes, etc., are easily and effectively repaired with REPAIR COMPOUND. Additional uses include the fairing of corroded or uneven hull and deck plating, repair of cavitation damage,

repair and sealing of riveted seams, etc. REPAIR COMPOUND is ideally suited for fairing around sensitive electrical equipment, as it contains no metallic fillers.

SURFACE PREPARATIONS

The adhesion of REPAIR COMPOUND is greatly improved by removing all grease, rust, scale, and paint from surface before application. Sandblasting of metal surfaces to SSPC #10 Near White is the preferred preparation, but sanding, grinding or hand chipping are acceptable for small areas.

Un-coated fiberglass or wood requires grinding or sanding to roughen and clean the surface. Compound may be used for fairing over sound old coatings if surface is lightly abraded by sanding to maximize adhesion.

Remove all grease and oil films by thoroughly cleaning the surface with clean rags saturated with TriChloroEthylene, Xylene, or IMPAX IXT-59 Solvent.

MIXING & APPLICATION INSTRUCTIONS

Please refer to the appropriate safety data sheet (SDS) prior to using this product.

Place equal quantities by volume of blue resin and white hardener on small palette or mortarboard with putty knife.

Thoroughly mix the equal quantities together until a uniform streak-free blue color is achieved. A complete inter-mixing of the two components is essential for proper curing.

Working time of mixed material is one hour at 72°F (22°C), longer at lower temperatures, shorter at higher temperatures.

REPAIR COMPOUND will hard cure and is readily overcoated, ground, or sanded in 6 hours at 70°F (21°C). Up

to 8 hours may be required at 50°F (10°C). Hand or tool dampened with water aids in smoothing. Clean tools and equipment with epoxy sol- vent or IMPAX IXT-59 Solvent.

Please contact your local representative of our Worldwide Distributor Network or ITW Performance Polymers for any questions or support.

STORAGE RECOMMENDATIONS

All product components should be stored in a dry, shaded area in original unopened containers and within a temperature range of 65°- 95°F (16° - 35°C). For additional information, please refer to Technical Guide 1024.

PHYSICAL PROPERTIES

COMPRESSIVE STRENGTH	8,900 psi (61.36 MPa)	ASTM D695
TENSILE STRENGTH	2,600 psi (17.93 MPa)	ASTM D638
HARDNESS	65-70 Shore D after 8 hours@ 72°F (22°C) 80-85 Shore D after 24 hours@ 72°F (22°C)	ASTM D2240
IZOD IMPACT STRENGTH	5.3 in.lb./in (0.24 Newton meters/cm)	
TYP. MAX. SERVICE TEMPERATURE	180°F (82°C)	
SPECIFIC GRAVITY	1.45	ASTM D258
COMPRESSIVE STRENGTH	8,900 psi (61.36 MPa)	ASTM D695

The data shown reflect typical results based on laboratory testing under controlled conditions. Variations from the above data are typical for field-prepared samples.

PRODUCT INFORMATION

UNIT COVERAGE	415 in ³ (6.8 L)
TYPICAL APPLICATION TEMPERATURES	55°F to 95°F (13°C to 35°C)
INITIAL CURE TIME (APPROXIMATE, BASED ON CONTACT SURFACE TEMPERATURES)	Sandable: 3 hours@ 72°F (22°C) Hard Cure: 8 hours@ 72°F (22°C) Full Cure: 24 hours@ 72°F (22°C)
POT LIFE (APPROXIMATE)	70 min. @ 72°F (22°C)
MIXING RATIO	1:1 by Volume
PACKAGING PER UNIT	RESIN (NH): 3.2 L (0.84 gal) in a 1 gal can HARDENER (NH): 3.6 L (0.94 gal) in a 1 gal can
COMPONENT WEIGHTS	RESIN: 10.2 lbs (4.6 kg) HARDENER: 12.2 lbs (5.5 kg)
UNIT SHIPPING WEIGHT	25 lbs (11.3 kg)
COLOR	RESIN: Blue HARDENER: Cream MIXED: Blue
CLEAN UP	IMPAX IXT-59, or similar epoxy solvent
SHELF LIFE	2 years in dry storage
CHEMICAL RESISTANCE	Refer to Technical Guide 675

REFERENCE

For any additional recommendations or applications beyond the typical ones listed in this document, please contact your local representative of our Worldwide Distributor Network or ITW Performance Polymers for further support.

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ITW PERFORMANCE POLYMERS

130 Commerce Drive | Montgomeryville | PA 18936 | USA | T: +1-215-855-8450 | E-mail: customerservice.na@itwpp.com | www.itwperformancepolymers.com
Bay 150 | Shannon Industrial Estate | Shannon | County Clare | Ireland | T: +353 61 771 500 | E-mail: customerservice.shannon@itwpp.com