

ITW PHILADELPHIA RESINS REPAIR COMPOUND

TECHNICAL BULLETIN #1015A

DESCRIPTION

ITW Philadelphia Resins REPAIR COMPOUND 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 nonsagging properties of Repair Compound make it unexcelled 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.

Preparing surfaces of hulls, storage tanks, sonar domes, etc., for painting, fiberglassing or rubber lining generally requires that all welds, pitting, rough surfaces or irregularities be smoothed. The use of REPAIR COMPOUND provides a tough, uniform surface that will readily accept any top coating or lining.

Exceptional troweling and application characteristics provide a smooth finished surface. If additional finishing is desirable, the material is readily sanded or ground. The excellent feathering properties facilitate the achieving of precision surface profiles or smoothness.

Repairs of pump casings, impellers, sea chests, condenser boxes, etc., are easily and effectively accomplished 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 PREPARATION

The adhesion of REPAIR COMPOUND is greatly improved by removing all grease, rust, scale and paint from surface before application. Sand-blasting of metal surfaces to SSPC #10 Near White is the preferred preparation, but sanding, grinding or hand chipping are acceptable for small areas. Uncoated fiberglass or wood requires grinding or sanding to roughen or clean 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 surface with clean rags saturated with TriChloroEthylene, Xylene or Impax IXT-59 Solvent.

ITW PHILADELPHIA RESINS

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MIXING INSTRUCTIONS

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 solvent or Impax IXT-59 Solvent.

PHYSICAL PROPERTIES

COLOR:	Resin - Blue Hardener - Cream Mixed - Blue	
COMPRESSIVE STRENGTH:	8,900 psi (623 kg/cm ²)	ASTM D-695
CURE TIME:	8 hours @ 72°F (22°C) Sandable in 3 hours @ 72°F (22°C) Full Cure: 24 hours @ 72°F (22°C) 1/8" (3.1 mm) film	
HARDNESS - SHORE D:	65-70 after 8 hours @ 72°F (22°C) 80-85 after 24 hours @ 72°F (22°C)	ASTM 4-2240
IZOD IMPACT STRENGTH:	5.3 in.lb./in (0.24 Newton meters/cm)	ASTM D-256
MIXING RATIO - By Volume:	1:1	
NET WEIGHT PER 7.57 Liters:	22 lbs. (10 Kg) (two gallon) unit	
PACKAGING:	Two Quart (1.89 liters) unit Two Gallon (7.57 liters) unit	
POT LIFE:	70 min. @ 72°F (22°C) 3" (75 mm) thickness	
SHELF LIFE:	One year (closed container)	
SPECIFIC GRAVITY:	1.45	
TENSILE STRENGTH:	2,600 psi (183 kg/cm ²)	ASTM D-638
VISCOSITY:	Paste	

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