



## **PHILLYBOND #6 - TECHNICAL BULLETIN #470A** **EPOXY REPAIR AND PATCHING COMPOUND**

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Revised: 05/2018

### **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 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	Resin - White, Hardener - Black, Mixed - Gray
CURE TIME	1 hr @ 72°F (22°C) @ ½ inch (12.7 mm) thickness
MIXING RATIO	4:1 by volume and weight
PACKAGING	1 lb (454 gram) Kit. 10 Kits per Case
POT LIFE	10 – 15 minutes @ 72°F (22°C)
SHELF LIFE	Two years if stored in a cool, dry area
TEMPERATURE RESISTANCE	428°F (220°C)
SHEAR STRENGTH	1,000 psi (70.3 cm <sup>2</sup> /kgf)
VISCOSITY	Paste / putty
MIL SPEC	R-17882-C

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