



PHILLYBOND® TA-30 – TILE ADHESIVE AND GROUT. QPL - MIL-A-24456

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TECHNICAL DATA SHEET #958

VERSION: B

PRODUCT DESCRIPTION

PHILLYBOND TA-30 is a two component, high tack strength, epoxy adhesive specifically developed for the installation of vibration damping materials such as MLD-2 Tiles, RA, Saper, Isoper, PVC and others. Clamping or shoring is generally eliminated as TA-30 Adhesive will support in excess of 5 lbs./ft² (25 kg/m²) on overhead and vertical surfaces while curing takes place. TA-30 is excellent for grouting between damping tile sheets and for forming fillets at welds or seams. TA-30 is nontoxic and contains no solvents. Fumes and odors of mixed TA-30 are negligible thus facilitating usage in confined areas. Resistance to fresh water, salt water, crude and refined oils, gasoline, jet fuel, etc., is excellent.

SURFACE PREPARATION

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

MIXING & APPLICATION INSTRUCTIONS

PHILLYBOND TA-30 is mixed one-part white resin to one-part black hardener by volume. Equal sized quantities are best placed side by side on a wood or hard board surface and thoroughly mixed until a uniform gray color is achieved. Mix quantities which can be used within approximately one hour. PHILLYBOND TA-30 has an exceptionally soft creamy

consistency providing ease of mixing.

Mixed adhesive may be applied to damping tile or sheet with either a smooth or notched trowel. With smooth edge trowel apply uniformly at approximately 1/32" (0.8mm) or thicker. Notched trowels with serrated edges of 1/16" (1.6mm) or larger may be utilized. Coat entire surface of tile evenly including edges. Bend coated tile and starting with edge roll onto hull structure such that adhesive spreads under tile ensuring that air is not entrapped. Adhesive may be applied to either or both surfaces. Intimate contact may be further insured through pounding with a rubber mallet. TA-30 develops excellent bonds between poorly fitted surfaces and is recommended for metals, rubber, wood, glass, masonry, and many plastics. PHILLYBOND TA-30 is easily cleaned off tools and hands prior to setting with water.

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.

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.

PRODUCT INFORMATION

PRODUCT COVERAGE	Up to 75 ft ² per gallon (1.85 m ² per liter) Applied with notched trowel		
UNIT COVERAGE	CAN	1.3 gal, 280 in ³ (4588 cm ³ , 4.6 L)	
	300mL x 300mL CARTRIDGE	36 in ³ (4588 cm ³ , 0.6 L)	
TYPICAL APPLICATION TEMPERATURES	55°F to 95°F (13°C to 35°C)		
INITIAL CURE TIME (APPROXIMATE, BASED ON CONTACT SURFACE TEMPERATURES)	72°F (22°C) -		24 hrs.
	35°F (1.7°C) -		15 days
POT LIFE (APPROXIMATE)	1-1/2 hrs @ 72°F (22°C) 1.6 gal. (6 L) batch		
MIXING RATIO	By volume: 1:1 By weight 100 parts resin to 88 parts hardener		
PACKAGING PER UNIT	CAN	Resin (A):	0.91 gal (0.24 L) in 1-gal can
		Hardener (B):	0.8 gal (0.21 L) in 1-gal can
	300mL x 300mL CARTRIDGE	Resin (A):	0.08 gal (0.3 L) in cart.
		Hardener (B):	0.08 gal (0.3 L) in cart.
COMPONENT WEIGHTS	CAN	Resin (A):	7.5 lbs (11.6 kg)
		Hardener (B):	6.6 lbs (4.2 kg)
	300mL x 300mL CARTRIDGE	Resin (A):	1 lbs (0.45 kg)
		Hardener (B):	0.95 lbs (0.43 kg)
UNIT SHIPPING WEIGHT	CAN	33 lb (15.0 kg) per case 2 kits per case	
	300mL x 300mL CARTRIDGE	24 lb (10.9 kg) per case 12 kits per case	
COMPONENT COLORS	RESIN (A): White HARDENER (B): Black MIXED (A + B): Gray		
CLEAN UP	IMPAX IXT-59, or similar epoxy solvent		
SHELF LIFE	2 years in dry storage		
CHEMICAL RESISTANCE	Refer to Technical Guide 675		

PHYSICAL PROPERTIES

COMPRESSIVE STRENGTH	11,000 psi (770 kg/cm ²)	ASTM D695
COMPRESSIVE MODULUS OF ELASTICITY	197,000 psi (13,790 kg/cm ²)	ASTM D695
TEMPERATURE RESISTANCE	150°F (65°C)	
RESISTANCE TO HIGH IMPACT	Pass MIL-S-901	
TENSILE STRENGTH	3,200 psi (224 kg/cm ²)	ASTM D638
TENSILE ADHESION PERPENDICULAR TO THE BOND	1,700 psi (120 kg/cm ²)	MIL-A-24456
SHEAR ADHESIVE STRENGTH	1,274 psi (89.5 kg/cm ²)	
HARDNESS - BARCOL	20	ASTM D2583
SPECIFIC GRAVITY	1.38	
CONSISTENCY	Thixotropic paste, trowelable	
MIL-SPEC	MIL-A-24456	

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

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