



## PHILLYCLAD® #8 – FAST SETTING, LAMINATING RESIN TECHNICAL DATA SHEET #966

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VERSION: D

### PRODUCT DESCRIPTION

PHILLYCLAD #8 is a two-component fast setting epoxy laminating resin system designed for high strength fiberglass reinforced repairs to pipes, tanks, valves, and other equipment subject to corrosion or erosion.

### USE & BENEFITS

PHILLYCLAD #8 is used to reinforce waste pipes and repair leaks in cargo heating coils, turbine drains, deck steam lines and other similar areas at operating temperatures up to 428°F (220°C). PHILLYCLAD #8 has excellent resistance to salt water, crude and refined oil, gasoline, caustics, and most acids. When used with four layers of fiberglass tape, PHILLYCLAD #8 has the capability to withstand more than 1,000 psi (6.89 MPa) hydrostatic pressure after one hour of cure.

### SURFACE PREPARATION

Repair effectiveness is dependent upon cleanliness of the surface of the repair area. Maximum adhesion is assured by removal of all grease, oil, paint, and foreign matter. Surface must be cleaned to rough, bright metal finish by blasting, grinding or with emery cloth. Rinse surface with IXT-59 solvent to ensure a clean area.

### APPLICATION INSTRUCTIONS

Please refer to the appropriate safety data sheet (SDS) prior

to using this product.

Do not mix hardener with resin until preparations are completed as the working time of catalyzed material is approximately 10-15 minutes at 72°F (22°C). Mix PHILLYCLAD #8 by adding hardener to resin and stirring vigorously until a streak-free uniform color is achieved.

For repair of leaks, brush PHILLYCLAD #8 over an area extending 3" (7.5cm) on each side of the repair area. Apply 1-1/2" or 3" (3.75 or 7.5cm) fiberglass tape in a spiral wind, overlapping one-half of previous turn. Cover the coated area. Brush additional coat of PHILLYCLAD #8 and repeat for 4 wraps.

PHILLYCLAD #8 may also be used as a coating without fiberglass reinforcement and may be machined after it is fully cured using water as a coolant.

### 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.

## PHYSICAL PROPERTIES

VISCOSITY	Brushable, Pourable Liquid
MIL SPEC	R-17882-C

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	28 in <sup>3</sup> (461 cm <sup>3</sup> )
TYPICAL APPLICATION TEMPERATURES	55°F to 95°F (13°C to 35°C)
INITIAL CURE TIME (APPROXIMATE, BASED ON CONTACT SURFACE TEMPERATURES)	Glass reinforced patches 1/8" to 1/4" (3.0 to 6.5mm) thick approximately 1 hour @ 72°F (22°C). Thinner coats and lower temperatures require longer
MIXING RATIO	BY WEIGHT OR VOLUME: 4 TO 1
POT LIFE (APPROXIMATE)	70°F (21°C): 10-15 mins.
PACKAGING PER UNIT	RESIN (A): 12.1 oz (358 mL) in a 1-pt can
	HARDENER (B): 3.47 oz (103 mL) in a 4-oz plastic jar
COMPONENT WEIGHTS	RESIN (A): 0.90 lbs (410 grams)
	HARDENER (B): 0.24 lbs. (110 grams)
UNIT SHIPPING WEIGHT	16 kits/case
	23 lbs. (10.4 kg)/case
COLOR	RESIN (A): WHITE HARDENER (B): INDIGO MIXED (A + B): LIGHT PURPLE
CLEAN UP	IMPAX IXT-59 Solvent or equal
SHELF LIFE	2 years in dry storage
CHEMICAL RESISTANCE	Refer to Technical Guide 675 for full list.

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