

Technical Bulletin # 966B

Epoxy Laminating Pipe Repair System

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. PHILLYCLAD #8 is also used to repair leaks in cargo heating coils, turbine drains, deck steam lines and other similar areas at operating temperatures to 220 °C (428 °F).

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 in excess of 70 kg/cm² (1000 psi) hydrostatic pressure after one hour cure.

Surface Preparation

Repair surfaces must be clean and sound and free of oil, dirt, old paint and other foreign matter. Surface must be cleaned to rough, bright metal by blasting, grinding or with emery cloth. Rinse surface with Impax IXT 59 solvent to ensure a clean area.

Mixing and Application Instructions

Do not mix hardener with resin until preparations are completed as working time of catalyzed material is approximately 15 minutes at 22 °C (72 °F). 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 7.5 cm. (3 in.) on each side of the repair area. Apply 3.75 or 7.5 cm (1 ½ in or 3 in.) 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.

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Technical Information

COLOR: Purple Gray (resin – white; hardener – black)
CURE TIME: Glass reinforced patches 3.0 to 6.5 mm (1/8 in to 1/4 in) thick cure in approximately 1 hr @ 22 °C (72 °F).
MIXING RATIO: 4:1 by volume and weight
PACKAGING: 500 grams (1.1 lb) kit, 16 kits per case
POT LIFE: 10 -15 minutes @72 °F (22 °C)
SHELF LIFE: Two years/ Store in a cool dry area
VISCOSITY: Liquid, brushable, pourable
MIL SPEC: R-17882-C

Date

07/2006

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