PHILLYBOND ORANGE
Flexible Stern Tube Sealant

Technical Bulletin #646D

DESCRIPTION

PHILLYBOND ORANGE is a two component, epoxy paste, developed for sealing exposed edges of CHOCKFAST in stern tube applications. It is resistant to sea water and lubrication oils. It has good adhesive strength and flexibility over a wide temperature range. Because of its paste-like consistency, it can be applied in thick, vertical applications without sagging, yet is easy to trowel and provide a smooth finished surface.

USES

Excellent for sealing any type gap where both mechanical and thermal expansion and contraction will take place. It adheres well to steel, brass, and other epoxies and epoxy chocking materials.

SURFACE PREPARATION

The adhesion of PHILLYBOND ORANGE is dependent upon a clean, dry surface. All grease, rust, scale, and paint should be removed from the surface before application. The preferred procedure is to solvent wipe the surface using Xylene or PRT-52 Solvent, sand or grind the area, and then repeat the solvent wipe. Clean rags saturated with the solvent should be used.

MIXING INSTRUCTIONS

Scoop out equal amounts of resin and hardener (by volume) placing the material on a clean flat surface (such as cardboard), using a putty knife, combine the resin and hardener and mix until a uniform color is achieved.

Phillybond Orange may be applied to steel surfaces coated with ITW Philadelphia Resins Rust Inhibitive Primer.

PHYSICAL PROPERTIES

Color:	Resin – Orange Hardener – Amber Mixed – Orange
Tensile Strength:	45 kg/cm² (640 psi) ASTM D 638
Adhesive Strength:	On Steel – 40 kg/cm² (567 psi) On Brass – 35 kg/cm² (500 psi) On CHOCKFAST ORANGE – 39.5 kg/cm² (563 psi)
Lap Shear on Steel:	30 kg/cm² (424 psi) ASTM D 1002
Elongation:	37.5%

ITW PHILADELPHIA RESINS

130 Commerce Drive · Montgomeryville, PA 18936 · 215-855-8450 · Fax 215-855-4688

 MAY, 2003

PHYSICAL PROPERTIES

Viscosity, mixed:	464 000 cps (Paste Consistancy)
Mixing Ratio – By Volume	1 : 1
Pot Life:	3 hours at 21°C (70°F)
Cure Time:	36 hours at 21°C (70°F) Gel 5 hours 48 hours at 15°C (60°F) Gel 7 hours
Shelf Life:	2 years
Packaging:	3.8 liters (1 gal.) unit