



A brand of ITW Polymers Adhesives North America

Zip Patch

Description: A fast-setting patch system for making permanent, waterproof field repairs.

Intended Use: Patching PVC/ABS piping, tanks, vessels, and containers. Repairing all substrates with a 1 hour functional cure.

Product features: **Low odor technology**
Room temperature cure
Non-sagging formula
Bonds dissimilar substrates
Minimal surface preparation
Strong adhesion

Limitations:

Typical Physical Properties:

Technical data should be considered representative or typical only and should not be used for specification purposes.

Cured 7 days @ 75° F

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| Adhesive Tensile Lap Shear (AL) | 2,400 psi |
| Adhesive Tensile Lap Shear (ABS, PVC) | 1,200 psi |
| Coefficient of thermal expansion | 64 x 10(-5) in./in.[73°F to 194 |
| Cured Shrinkage | 0.0010 in/in |
| Dielectric Strength | 250 volts/mils |
| Flexural strength | 19,000 psi |
| Impact Resistance | 30 ft.lbs./in.(2) |
| Peel Strength (GBS) | 35 pli |
| Pot Life | 5 min |
| Shore Hardness | 70 Shore D |
| Solids by Volume | 100 |
| Tensile Elongation | 15-25% |
| Tensile Modulus | 192,000 psi |
| Tensile Strength | 10,000 psi |
| T Peel | 35 pli |

TESTS CONDUCTED

Impact Resistance ASTM D 950
Tensile Strength (Epoxies) ASTM D 638
T-Peel Strength ASTM D 1876

Uncured

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|----------------------------|-------------------------|
| Average thickness | 1 ply: 0.075 in. |
| Color | Brown |
| Coverage/lb | 4"x9" patch |
| Fixture Time | 1 hr. |
| Flashpoint | 300°F |
| Full Cure | 4 hrs. |
| Functional Cure | 1 hr. |
| Mixed Viscosity | 17,000 cps |
| Service Temperature | 200°F |

Surface Preparation: Clean surface by solvent-wiping any deposits of heavy grease, oil, dirt, or other contaminants. Surface can also be cleaned with industrial cleaning equipment such as vapor phase degreasers or hot aqueous baths. If working with metal, abrade or roughen the surface to significantly increase the microscopic bond area and optimize the bond strength.

Mixing Instructions: Mixing is not applicable to this product. This is a primer system used to increase adhesion to your substrate. Follow instructions on the package for maximum results.

Application Instructions: Zip Patch requires minimal surface preparation. However, for maximum adhesion, the repair surface should be roughened and wiped clean with solvent. When making repairs to pipes, shut down the pressure. In tanks, pressure should be relieved by lowering the fluid level.

Apply only in well-ventilated areas. The Zip Patch kit contains everything required to make fast, permanent emergency

repairs. First, carefully peel away one side of the foil pouch. Then spray the exposed patch surface lightly, but completely, (including the corners) with activator. Proper activation is indicated by the patch becoming darker in color.

Press the activated patch over the repair area and carefully peel back the remaining foil. Use the plastic applicator provided in the kit to eliminate entrapped air by gently smoothing the patch from the center toward the outer edges. Complete activation of the adhesive by spraying the entire surface of the exposed patch.

Storage: Store between 55°F and 75°F. Continuous storage above 75°F reduces the shelf life of the materials. Prolonged exposure above 100°F quickly diminishes the product's reactivity, and should be avoided. Shelf life can be extended by refrigeration between 45°F and 55°F. **DO NOT FREEZE.**

Compliances: None

Chemical Resistance: *Chemical resistance is calculated with a 7 day, room temp. cure (30 days immersion) @ 75 °F)*

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|---------------------|-----------|
| Cutting Oil | Excellent |
| Gasoline (Unleaded) | Very good |
| Glycols/Antifreeze | Very good |

Precautions: Please refer to the appropriate material safety data sheet (MSDS) prior to using this product.

For technical assistance, please call 1-800-933-8266

FOR INDUSTRIAL USE ONLY

Warranty: Devcon will replace any material found to be defective. Because the storage, handling and application of this material is beyond our control, we can accept no liability for the results obtained.

Disclaimer: All information on this data sheet is based on laboratory testing and is not intended for design purposes. ITW Devcon makes no representations or warranties of any kind concerning this data.

Order Information: 11500 4" x 9" patch