**Technical Data Sheet**
Version 3. 04/2023

# 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.

**Features:**
**Low odor technology**
**Room temperature cure**
**Non-sagging formula**
**Bonds dissimular substrates**
**Minimal surface preparation**
**Strong adhesion**

**Limitations:** Suitability of product is determined by the end user for their application and process.

**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 (24°C) | Typical Values |
|---|---|
| Adhesive Tensile Lap Shear (AL) | 2,400 psi (16.5 MPa) |
| Adhesive Tensile Lap Shear (ABS, PVC) | 1,200 psi (8.3 MPa) |
| Coefficient of thermal expansion (x10-6) | 64 in/in.°F (115 cm/cm.°C) |
| Cured Shrinkage | 0.0010 in/in (cm/cm) |
| Dielectric Strength | 250 volts/mil (9.8 kV/mm) |
| Flexural strength | 19,000 psi (131 MPa) |
| Hardness | 70 Shore D |
| Solids by Volume | 100 |
| Tensile Elongation | 15-25% |
| Tensile Modulus | 192,000 psi (1,324 MPa) |
| Tensile Strength | 10,000 psi (69 MPa) |
| Tpeel | 35 pli (6.1 N/mm) |

| Standard Tests |
|---|
| Tensile Strength (Epoxies) ASTM D 638 |
| T-Peel Strength ASTM D 1876 |

| Uncured Properties @ 72°F (23°C) | |
|---|---|
| Average thickness | 1 ply: 0.075 in. (1.9 mm) |
| Color | Brown |
| Coverage | 4x9 in. (10x23 cm) patch |
| Fixture Time | 1 hr. |
| Flashpoin | 300°F (149°C) |
| Full Cure | 4 hrs. |
| Functional Cure | 1 hr. |
| Mixed Viscosity | 17,000 cP |
| Pot Life | 5 min |
| Service Temperature | 200°F (93°C) |

**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

**Storage:** Store between 55°F and 75°F (13°C and 24°C). Continuous storage above 75°F (24°C) reduces the shelf life of the materials. prolonged exposure above 100°F (38°C) quickly diminishes the product's reactivity, and should be avoided. Shelf life can be extended by refrigeration between 45°F and 55°F (7°C and 13°C). DO NOT FREEZE.

**Chemical Resistance:**

Chemical resistance is calculated with a 7 day, room temp. cure (30 days immersion) @ 75°F (24°C)

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

**Precautions:**

**FOR INDUSTRIAL USE ONLY:** Please refer to the appropriate **S**afety **D**ata **S**heet prior to using this product.

**Warranty:**

ITW Performance Polymers 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.

**Order Information:**

| Item No. | Package Size |
|---|---|
| 11500 | 4x9 in. (10x23 cm) patch |

**Contacts:**

www.itwpp.com

ITW Performance Polymers (EMEA)
Bay 150, Shannon Industrial Estate
Shannon, County Clare, Ireland V14 DF82
TEL: +353 61 771 500
FAX: +353 61 471 285
Email: customerservice.shannon@itwpp.com

ITW Performance Polymers (US)
30 Endicott Street
Danvers, MA 01923 USA
TEL: 855 489 7262
FAX: 978 774 0516
Email: info@itwpp.com

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