

Technical Bulletin # 958A

QPL -- MIL-A-24456

Product Description

PHILLYBOND TA-30 is a two component, high tack strength, epoxy adhesive specifically developed for the installation of vibration damping materials such as MLD-2 Tiles, RA, Saper, Isoper, PVC and other. Clamping or shoring is generally eliminated as TA-30 Adhesive will support in excess of 25 kg/sq.m. (5 lbs./sq.ft.) on overhead and vertical surfaces while curing takes place. TA-30 is excellent for grouting between damping tile sheets and for forming fillets at welds or seams. TA-30 is nontoxic and contains no solvents. Fumes and odors of mixed TA-30 are negligible thus facilitating usage in confined areas. Resistance to fresh water, salt water, crude and refined oils, gasoline, jet fuel, etc., is excellent.

Surface Preparation

Surfaces must be clean and sound and free of oil, dirt, old paint and other foreign matter. Blast, abrade or clean surface for best adhesion. Final rinse of surface with Impax IXT 59 solvent helps to ensure complete removal of grease and oils.

Mixing and Application Instructions

PHILLYBOND TA-30 is mixed one part white resin to one part black hardener by volume. Equal sized quantities are best placed side by side on a wood or hard board surface and thoroughly mixed until a uniform gray color is achieved. Mix quantities which can be used within approximately one hour. PHILLYBOND TA-30 has an exceptionally soft creamy consistency providing ease of mixing.

Mixed adhesive may be applied to damping tile or sheet with either a smooth or notched trowel. With smooth edge trowel apply uniformly at approximately 0.8mm (1/32") or thicker. Notched trowels with serrated edges of 1.6mm (1/16") or larger may be utilized. Coat entire surface of tile evenly including edges. Bend coated tile and starting with edge roll onto hull structure such that adhesive spreads under tile ensuring that air is not entrapped. Adhesive may be applied to either or both surfaces. Intimate contact may be further insured through pounding with a rubber mallet. TA-30 develops excellent bond between poorly fitted surfaces and is recommended for metals, rubber, wood, glass, masonry and many plastics. PHILLYBOND TA-30 is easily cleaned off tools and hands prior to setting with water.

Technical Information

COLOR:	Resin - White Hardener - Black Mixed - Gray	
COMPRESSIVE MODULUS OF ELASTICITY:	13,790 kg/cm ² (197,000 psi)	
COMPRESSIVE STRENGTH:	770 kg/cm ² (11,000 psi)	ASTM-D-695
COVERAGE:	Up to 1.85 sq.m. per liter (75 sq.ft. per gallon) Applied with notched trowel	

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CURE TIME:	24 hrs. @ 22°C (72°F) 15 days @ 1.7°C (35°F)	
HARDNESS - BARCOL:	20	ASTM-D-2583
MIXING RATIO -	By volume: 1:1 By weight 100 parts resin to 88 parts hardener	
PACKAGING:	6.35 kg (14 lb.) unit 4.9 liters (1.3 gallon) unit	
POT LIFE:	1-1/2 hrs @ 22°C (72°F) 6 liters (1.6 gallon) batch	
RESISTANCE TO HIGH IMPACT:	Pass MIL-S-901	
SHEAR ADHESIVE STRENGTH:	89.5 kg/cm ² (1,274 psi)	
SHELF LIFE:	2 years	
TEMPERATURE RESISTANCE:	65°C (150°F)	
TENSILE ADHESION PERPENDICULAR TO THE BOND:	120 kg/cm ² (1,700 psi)	MIL-A-24456
TENSILE STRENGTH:	224 kg/cm ² (3,200 psi)	ASTM-D-638
VISCOSITY:	Thixotropic paste, trowelable	

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