

R1920 Quick Repair Compound

SELECTION & SPECIFICATION DATA

Type	Novolac Epoxy
Description	R1920 Quick Repair Compound is a fast-setting version of ErgonArmor's high-performance paste-grade novolac repair compound for shop and field repair and rebuilding of equipment. Ideally suited for fixing tank leaks, piping, and electrical bushings and for setting keyways or taper fits when fast turnaround is critical.
Features	<ul style="list-style-type: none"> •Fast cure for emergency repairs •Complies with ASME PCC-2, Article 4.1 as long-term repair •Outstanding bond strength •Excellent chemical resistance •Machinable •Non-shrink and low-slump for repair of vertical surfaces
Uses	<ul style="list-style-type: none"> •Metal cooling tower pans •Emergency tank and pipe repairs •Electrical bushings •Setting keyways and taper fits •Repair of metal, fiberglass, composite, PVC and similar plastic materials
Color	Dark Gray
Finish	Satin
Primer	Self-priming
Solids Content	99 – 100% by volume
Theoretical Coverage Rate	12.8 ft ² /gal at 125 mil 2 ft ² /gal at 800 mil Allow for loss in mixing and application.

SUBSTRATES & SURFACE PREPARATION

All	Surfaces must be clean, dry and free of contaminants.
Steel	<p>Immersion: SSPC-SP10 Near-White Metal Blast with angular profile of 3.0 – 4.0 mils.</p> <p>Non-immersion: SSPC-SP6 Commercial Blast with angular profile of 2.5 – 3.5 mils</p>
Weld Repair	Use a flame to sweat out oil from deeply impregnated surfaces. Stabilize cracks by drilling the extremities. Long cracks should be drilled, tapped and bolted every few inches. Vee-out all cracks using a file. Degrease using clean rags.
Substrate Temperature	50°F – 140°F (10°C – 60°C) <90% relative humidity >140°F (60°C), contact ErgonArmor

MIXING & THINNING

Mixing	Thoroughly mix the two parts, supplied in pre-measured sachet packs, until no streaks are seen.
	Apply to surface rapidly, pressing hard to achieve maximum wetting, then proceed with thickness desired.
	Mix no more product than can be applied in 5 minutes.
	When rebuilding structures, use layers of reinforcing cloth and apply product as thick as the parent substrate.
Ratio	2A:1B by volume 2A:1B by weight
Pot Life	5 minutes
Multi-layers	If building layers or pipe wrapping with reinforcing cloth, apply the coating within the recoat window. If this is not possible, allow the compound to cure, then create a mechanical profile by grit blasting, grinding or power tool sanding the surface before coating.

APPLICATION GUIDELINES

Application	Apply directly on to the prepared surface with the plastic applicator or spatula provided. Press down firmly to remove entrapped air, fill all cracks, and ensure maximum contact with the surface. Use reinforcement tape over holes and cracks. Fully machinable using conventional tools once cured.
Brush & Roller	Brush or roller can be used to smooth uncured surface with solvent if desired.

CLEANUP & SAFETY

Cleanup	MEK or Acetone
Safety	Mixes and applications of this product present a number of hazards. Read and follow the hazard information, precautions and first aid directions on the individual product labels and safety data sheets before using.

PACKAGING, HANDLING & STORAGE

Shelf Life	Part A: 5 years at 75°F (24°C) Part B: 5 years at 75°F (24°C)
Package Sizes & Shipping Weight	2 x 170 g kit per case: 1.5 lbs (1.46 kg) 1 x 170 g bag: 6 oz (0.17 kg)
Storage Temperature & Humidity	40°F – 110°F (4°C – 43°C) 0 – 100% relative humidity
Storage	Store in a dry, well-ventilated area. Maintain product in original packaging and sealed until ready for use. Avoid exposure to direct sunlight or extreme temperatures.

CURE SCHEDULE & RECOAT WINDOW

Working Time at 68°F (20°C)	5 minutes
Recoat Window at 68°F (20°C)	20 minutes
Machining at 68°F (20°C)	30 minutes
Mechanical Service at 68°F (20°C)	30 minutes
Chemical Resistant Service at 68°F (20°C)	3 hours

For every 10°C cooler, double the time. For every 10°C warmer, halve the time.

PERFORMANCE DATA

Compressive Strength ASTM D695	15,693 psi
Flexural Strength ASTM D790	7000 psi
Tensile Shear Adhesion ASTM D1002	2550 psi
Barcol Hardness ASTM D785	85

SERVICE TEMPERATURE

ENVIRONMENT	MAXIMUM TEMPERATURE
Dry Service	250°F (121°C)
Spill/Splash Service	212°F (100°C)
Immersion Service*	140°F (60°C)

*Immersion with solvents, mineral acids, or alkalis, or if over 150°F, contact ErgonArmor.

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