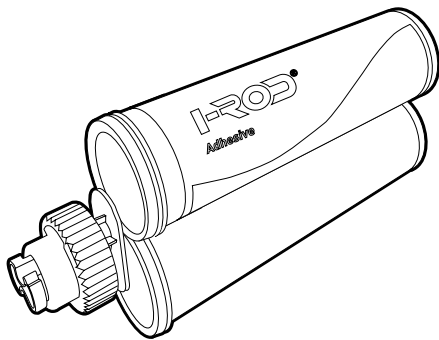




# I-Rod® Adhesive

## General

I-Rod® Adhesive is a high-strength, two-component methacrylate adhesive designed to quickly bond I-Rod® thermoplastic materials to pipe supports without pretreating their clean surfaces. It is applied using a 1:1 mix ratio, and is non-flammable once cured. It is best used by the date specified on the packaging. Room temperature cure time is listed. For applications below room temperature, time to full strength is increased. I-Rod Adhesive should not be used on high-heat installations exceeding 83°C (181°F), even if I-Rod HT or PEEK is also used.



## Cartridge coverage per substrate

Substrate	I-Rod size			Bond thickness	Sq. in. per cartridge
	3/4"	1"	1 1/2"		
Concrete	21'	16'	10'	0.125"	195 sq. in.
Steel*	64'	50'	32'	0.04"	610 sq. in.

\*Painted, galvanized, or bare finish

## Shore hardness STM-707 (ASTM D 2240)

Durometer D 39

## Fixture time

Time needed to develop sheer strength of 0.1 N/mm<sup>2</sup>

Fixture time, ISO 4587: 10 to 20 minutes

## Properties of uncured material (when mixed)

Specific gravity at 25° C 0.99  
 Working time at 25° C: 7 min.  
 Flash point 95° C (203° F)

## Product characteristics

Appearance (mixture) Pale yellow  
 Cure Room temperature cure  
 Components Two component - requires mixing  
 Mix ratio, by volume - 1 : 1  
 Part A: Part B  
 Working time 7 minutes

## Temperature limits

I-Rod Adhesive functions well within the temperature limits of I-Rod Classic, but is not recommended for high-temperature use with I-Rod HT or PEEK.

Lowest -110°C (-166°F) Highest 83°C (181°F)

## I-Rod (white) lap shear strength (psi)

Concrete 1,400 - 1,700  
 Steel 2,500 - 3,000

## I-Rod (white) tensile strength (psi)

Concrete 500 - 600  
 Steel 700 - 800

## Chemical / solvent resistance at 22° C

(Aged under these conditions)	°C	% Strength 500 hours	% Strength 1,000 hours
Environment			
100% RH	49	130	120
Salt fog, 95% RH	35	115	130
Water	22	120	105
Unleaded gasoline	22	Not recommended	Not recommended
Motor oil (10W30)	22	100	90
Water/glycol 50/50	22	120	115
DEF (AdBlue®)	22	125	145
Sulfuric Acid, 10%	22	100	105
Ammonia	22	120	110

## Adhesive properties of material cured for 72 hours at 21°C

**Impact strength (ISO 9653)**  
 21° C 5.8 J  
 100° C 3.2 J  
 -40° C 6.1 J  
**"T" Peel strength (ISO 11339)**  
 Steel N/mm 8 (lb/in) (45)  
 Aluminum N/mm 2 (lb/in) (12)