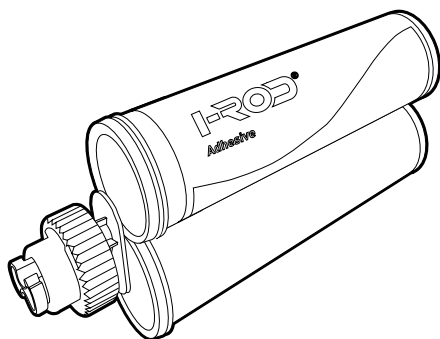




I-Rod® Adhesive

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 shear strength of 0.1 N/mm²

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	49	130	120
100% RH	35	115	130
Salt fog, 95% RH	22	120	105
Water	22	Not recommended	Not recommended
Unleaded gasoline	22	100	90
Motor oil (10W30)	22	120	115
Water/glycol 50/50	22	125	145
DEF (AdBlue®)	22	100	105
Sulfuric Acid, 10%	22	120	110
Ammonia	22		

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)