



I-ROD® ADHESIVE APPLICATION PROCEDURE

I-Rod® Adhesive material is used for installing I-Rod® thermoplastic strips on pipe supports.

DIRECTIONS FOR USE:

1. Remove surface contaminants such as paint, oxide films, oil, dust, mold release agents and all other surface contaminants.
2. Use gloves to minimize skin contact. Do not use solvents for cleaning hands.
3. When using a new dual cartridge, remove cartridge cap and dispense a small amount of adhesive, making sure both parts A and B are extruding. Attach nozzle and dispense approximately 25mm to 50mm before applying onto part to be bonded. Partially used cartridges can be stored with the mixing nozzle attached. To reuse, repeat this step from the beginning.
4. Apply adhesive evenly to both surfaces to be joined for maximum bond strength.
5. Application to substrates should be made as soon as possible. Working time at 25°C (77°F) is around seven minutes; larger quantities and/or higher temperatures will reduce the working time.
6. Join adhesive coated surfaces and allow to cure. Higher temperatures will speed up curing.
7. Keep assembled parts from moving during cure. The bond should be allowed to develop full strength before subjecting to any service load.
8. Excessive uncured adhesive can be cleaned up with ketone-type solvents.

Note: Obtaining full strength at 22°C requires 72 hours. Decreasing the curing time to 24 hours will reduce the full strength to 70%. Decreasing temperature will increase the cure time. Effect of temperature variations on the required time for the curing purpose has not been measured.

AMOUNT OF ADHESIVE

One cartridge contains 13.5 fl.oz.
(400ml) of I-Rod® Adhesive.

ADHESIVE COVERAGE

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

*Painted, galvanized, or bare finish