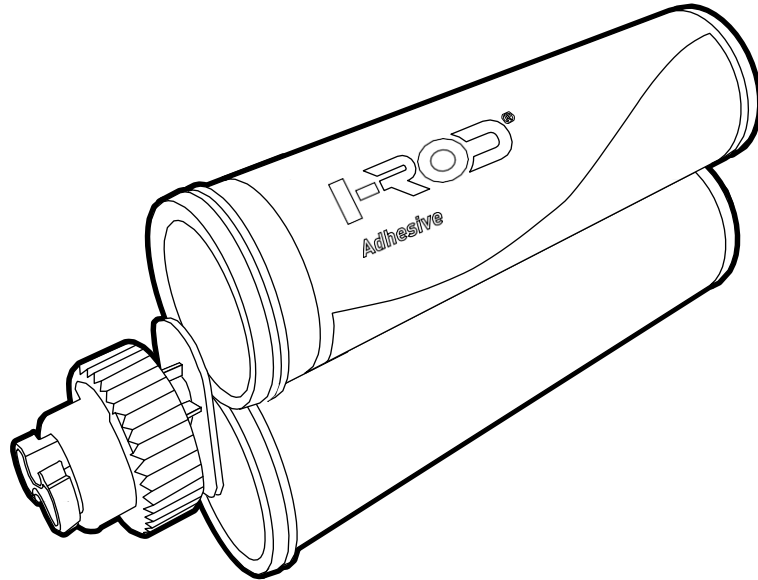


I-Rod® Adhesive

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 with an applicator using a 1:1 mix ratio, and is non-flammable once cured. One 400 mL cartridge will apply 0.021" of adhesive to 10' of 0.75" (I-Rod® Classic) on bare steel, painted steel and concrete. 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 used.



Shore hardness STM-707 (ASTM D 2240)

Durometer D 39

Full coverage on I-Rod Classic

Cartridge size	I-Rod diameter	Length
400mL	0.75"	10'
400mL	1"	7.5'
400mL	1.5"	5'

Fixture time

Time needed to develop sheer 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 -	
Part A: Part B	1 : 1
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	Highest
-110°C (-166°F)	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	1,000 hours
Environment	49	130	120
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/alvcol 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)



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