



Rodding Compound (1A)

Technical Data Sheet

Product Overview

Rodding Compound 1A is a Grafted Epoxy Methacrylate Resin for Encapsulating and Bonding Natural Stone, Quartz Surfacing and Reinforcing Rods made from Steel and Fiberglass.

Rodding Compound 1A is designed to produce tough, fast curing castings in Natural stone. It will set up in approximately 5 minutes and reach a high degree of strength in 20 minutes.

Rodding Compound 1A is formulated as a two component adhesive provided in a 10/1 mix ratio for packaging in many industry standard cartridges.

Rodding Compound 1A takes advantage of new technology to produce a hybrid polymer with the bond characteristics of Epoxies, plus the fast cure of cross linked Acrylics.

Physical Properties:	Adhesive	Activator	Combined
Color	Clear or Tinted	Transparent	Cures White
Specific Gravity	1.10	1.15	1.125
Mix ratio by volume	10/1		
Viscosity (cP.)	20 to 30,000	20/25,000	
Working time (minutes @ 75 f.)	5		
Handling Strength (minutes @ 75 f.)	20		
Flexural Strength (ASTM D- 790)	10,000		
Tensile Strength (ASTM D- 638)	7,000		
T-Peel (ASTM D-1876)	N/A		
Lap Shear (ASTM D- 638)	N/A		
Water resistance (ISSFA 5.8)	PASS		
Hardness- Barcol (ASTM D-2583)	40/50		

Storage and handling:

Before use or handling, consult the appropriate Material Safety Data Sheet. (MSDS)

Information is supplied at time of initial purchase and may be requested from the manufacturer or downloaded from the web sight at- www.integra-adhesives.com

Epoxy / Methacrylate Adhesives and Activators are flammable and can be dangerous if used improperly. Avoid skin and eye contact. In case of eye contact flush with water for 15 minutes and get medical attention. Keep away from sources of ignition.

Store the adhesive in a cool area away from direct sunlight. High temperatures will reduce the shelf life of the adhesive and activator. Refrigeration is an acceptable means to increase storage life, however freezing should be prevented. Shelf life tests are based on constant temperature storage between 60 and 75 f.

Dispensing:

Integra adhesives are supplied in kit form at the appropriate mix ratio. Always maintain this ratio when mixing. Excess activator will cause higher than normal exotherm temperatures. Avoid mixing large quantities or creating thick cross sections (over ½ inch) as high temperatures may cause damage, skin burns and create the release of volatile vapors.

Working time:

The working time for the adhesive is indicated in the technical data sheet. The time is provided as an estimate of the time between mixing and set up of the adhesive. The working time is effected by the mixing ratio, air temperature, adhesive temperature, or the substrate temperature as well as the shelf life condition of the adhesive. For best results, use the adhesive at temperatures between 60 and 85 f. High temperatures increase the cure rate while lower temperatures slow the cure. Use at temperatures below 55 f. may cause incomplete cure.

Disclaimer:

The Information provided, is based on testing under controlled conditions. It is the responsibility of the end user to test the adhesive on the intended substrate under the conditions which they will be used and to determine the suitability of the compound for the intended purpose.

Integra Adhesives makes no representations or warranties of any kind with respect to the data on this form or the suitability for any specific application.