

Adhesives and Dispensers

for Orenco Products

Applications

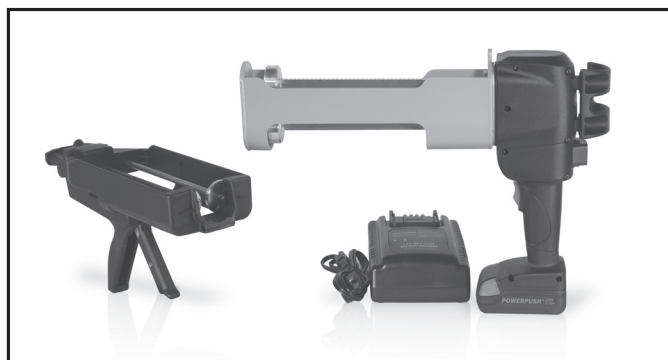
Adhesives and dispensers for Orenco products are used to create durable, watertight bonds between tanks, risers, and adapters, as well as between grommets and risers.

General

When working with Orenco products, use only approved adhesives. Before using an adhesive not listed in this document, contact Orenco or your distributor. Also, check the expiration date on adhesive packages. If the adhesive is expired, do not use it to install Orenco components.



Adhesives



Dispensing guns:
MA-MANUAL GUN-600ML and MA-BATT GUN-600ML

Structural Methacrylate Adhesives

MA8120 and SA510

MA8120 and SA510 are two-component methacrylate structural adhesives. They are used to bond ABS, DCPD, FRP, and PVC for strong, watertight joints. They will not bond to concrete. Clean, dry bonding surfaces are required for proper adhesion.

MA8120 is intended for applications requiring a long working time or for thicker adhesive bead lines; it will sag slightly in warm temperatures. SA510 is intended for applications requiring a short working time or for thinner adhesive bead lines. Both have a 1:1 mix ratio.

MA320

MA320 is a two-component methacrylate adhesive. It is used to bond ABS, FRP, and PVC for strong, watertight joints. It will not bond to concrete. Clean, dry bonding surfaces are required for proper adhesion. MA320 requires hand mixing.

IPS 810

IPS 810 is a self-leveling, two-component methacrylate adhesive, used to bond ABS, FRP, PVC, and concrete for strong, watertight joints. Clean, dry bonding surfaces are required for proper adhesion. IPS 810 requires hand mixing. Pint (product code ADHP10) or quart (product code ADHPQ10) quantities are available.

Sealant/Adhesive

ADH200

ADH200 is a moisture-curing, single-component sealant/adhesive used for sealing pipe grommets and for joining PVC or FRP risers to ABS or FRP tank adapters where joints are in shear. It is designed for applications in damp, dry, or cold climates. It is solvent free and contains no isocyanates. ADH200 will not shrink upon curing and will not discolor when exposed to UV light. Clean, dry bonding surfaces are required for proper adhesion. It is not intended for structural joints that are primarily in tension, in peel, or in bending.

Adhesives Specifications

	MA8120	SA510	MA320	IPS 810	ADH200
Applications	Bonds ABS, DCPD, FRP, PVC; for longer working times or thicker adhesive beads	Bonds ABS, DCPD, FRP, PVC; for shorter working times or thinner adhesive beads	Bonds ABS, FRP, PVC	Self-leveling; bonds ABS, concrete, FRP, PVC	Shear joints (PRTA-style adapters; adheres and seals pipe grommets, fasteners, etc.)
Color	Grey	Grey	White	White	White
Working Time @ 70°F (21°C)	~ 20min	10-15min	10-20min	~ 10min	n/a; 35min (+/- 10min) tack-free time
Cure Time @ 70°F (21°C)	< 2hr, depending on ambient temperature and adhesive bead/joint thickness	< 45min, depending on ambient temperature and adhesive bead/joint thickness	~ 1hr, depending on ambient temperature and adhesive bead/joint thickness	~ 2hr, depending on ambient temperature and adhesive bead/joint thickness	2-3 days, depending on ambient temperature and adhesive bead/joint thickness
Unit Quantities	300/300mL cartridge (600mL total)	300/300mL cartridge (600mL total)	7oz (200mL) packet	1pt (473mL), 1qt (946mL)	10.2oz (300mL) tube
Shelf Life	See "use by" date on cartridge	See "use by" date on cartridge	1yr from oldest date code shown on product	1yr from date shown on product	12mo from mfg date at 70°F (21°C) with 50% relative humidity
Dispensing Guns	MA-MANUAL GUN-600ML, MA-BATT GUN-600ML	MA-MANUAL GUN-600ML, MA-BATT GUN-600ML	None; hand mix in the packet	None; hand mix in the jar	Standard caulking gun

Approximate Quantities of Adhesive Needed for Various Products

	MA8120	SA510	MA320	IPS 810	ADH200
FRTA24-RVF Adapter, 24in (600mm)	½ cartridge*	½ cartridge*	1-2 packets	n/a	1 tube
PRTA24 Adapter, 24in (600mm)	½ cartridge*	½ cartridge*	1-2 packets	n/a	1 tube
PRTA24-2 Adapter, 24in (600mm)	> ½ cartridge*	> ½ cartridge*	n/a	< 1pt	n/a
PRTA30 Adapter, 30in (750mm)	< 1 cartridge*	< 1 cartridge*	2 packets	n/a	< 2 tubes
RLA24-2 Adapter, 24in (600mm)	½ cartridge*	½ cartridge*	1-2 packets	n/a	1 tube
RRFTA Adapter, 24in (600mm)	< 1 cartridge*	n/a	n/a	1pt	n/a
RRFTA30 Adapter, 30in (750mm)	1 cartridge*	n/a	n/a	1qt	n/a
GR24XX Grade Ring, 24in (600mm)	½ cartridge*	½ cartridge*	1-2 packets	n/a	1 tube
GR30XX Grade Ring, 30in (750mm)	< 1 cartridge*	< 1 cartridge*	2 packets	n/a	< 2 tubes
Grommets	n/a	n/a	n/a	n/a	various quantities

* Preferred adhesive for this application