

Applications

Granite
Natural Stone
Engineered Stone
Quartz Surfacing
Steel/Fiberglass
Reinforcing Rods

Advantages

High Strength
Fast Curing
Easy Cleanup
Low Waste
Meter/Mix/Dispense System

Characteristics

Working Time 5/10 minutes
Fixture Time 15/20 minutes
Temperature Dependent

Rodding Compound RD50 is an epoxy based compound packaged in a 500ml dual cartridge designed to increase strength, cut costs, reduce waste and save time when embedding fiberglass or steel reinforcement rods in countertops. Testing shows that the process can improve load tolerance up to 300 % and deflection up to 1600%.

Rodding Compound provides excellent bond strength and flow properties for the different rods options available to fabricators: Steel Flat bar, Rectangular rods, round rods and Fiberglass flat stock are all compatible.

Rodding Compound uses a meter-mix-dispense system (cartridge delivery) that combines the strength of an epoxy with the cure speed and consistency of an acrylic to combat waste, save time and reduce overall costs. Additional properties include a 15/20 minute cure, and low waste static mixers.



Dispensing

Rodding Compound RD50 is packaged in dual component cartridges as part of a meter / mix / dispense system utilizing specialized dispensing guns and static mixing tips. The 500ml cartridge is complemented by Integra's ***Dispensing Gun and X-Stream mixer tips***.

Packaging

Rodding Compound RD50 is currently available in 500ml cartridges and each cartridge comes with **4 X-Stream mixer tips**.

Case sizes

500ml Cartridge = 12 Cartridges

Shipping Options

Integra's adhesives are stocked at several locations in North America and Europe. 2 to 3 day lead times can generally be expected for ground delivery within the continental US and Canada.

Flammable adhesives require specialized packaging and documentation for air transport. Please contact Integra for information on overnight air shipping.

Order Processing-North America

Email: contact@integra-adhesives.com

Orders processed by email, fax or phone.

Integra Main number 1 (604) 850-1321

Toll free 1 (800) 862-6665

Fax 1 (604) 850-1354

Updated information can be found at

www.integra-adhesives.com

Order Processing - European Union

Email: contact@integra-adhesives.com

Orders processed by email, fax or phone.

Integra International Phone 1 (604) 850-1321

Integra International Fax 1 (604) 850-1354

Updated information can be found at

www.integra-adhesives.com/

Distributor Information - Please contact us for the names and location of distributors in your area.

Performance Characteristics- Rodding Compound RD50

Examples of strengthening low strength granite with RD50 Rodding Compound and fibreglass rods

Example	Flexural Strength	SAMPLE DIMENSIONS	MOISTURE
Un-reinforced granite 50mm (2") x 1000mm (40") strip No reinforcement	<800 PSI <5500 KPA	1 m (40") Long 5.5 cm (2 3/16") Wide 3 cm (1 3/16") Deep	N/A
Reinforced Granite: DRY 50mm (2") x 1000mm (40") strip with one 2.5 x 10 mm fibreglass rod	6600 PSI 45000 KPA	1 m (40") Long 5.5 cm (2 3/16") Wide 3 cm (1 3/16") Deep	Cut wet, blown dry with compressed air until no moisture was visible.
Reinforced Granite: WET 50mm (2") x 1000mm (40") strip with one 2.5 x 10 mm fibreglass rod	3200 PSI 22000 KPA	1 m (40") Long 5.5 cm (2 3/16") Wide 3 cm (1 3/16") Deep	Cut wet, blown to remove only large droplets of water. Surface saturated with water

Appearance Component A	Grey / Beige viscous liquid
Appearance Component B	White viscous liquid
Viscosity A	25,000 / 100,000CPS (Thixotropic)
Viscosity B	10,000 / 30,000 CPS (Thixotropic)
S.G. Combined (Density)	1.30
Working Time	5/10 minutes
Fixture Time	15 to 20 minutes
Recommended Bond Line	.5 to 1.5 mm
Flexural Bond Strength on Quartz, Granite - (ASTM D- 790) Bonded sections (Butt Joint) without reinforcement	3000 / 4000 PSI – 210 / 281 Kg/cm
Shelf Life Component A	1 year
Shelf Life Component B	1 year (Temperature Dependent)
Mix Ratio (Volume) A/B	10/1 optimum

Estimated Yield: Based on recommended groove size of (4 mm x 12) mm and a rod size of (3 mm x 10.5 mm) - 75 ft (23 m) per 500 ml cartridge

* Failure to follow recommended procedures could cause damage to the substrate, refer to technical bulletin – TB060601

Storage and handling:

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. 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 site at www.integra-adhesives.com Store the adhesive in a cool area away from direct sunlight. High temperatures will reduce the shelf life of the adhesive and activator. Exposure of activators, including cartridges, which contain activators, above 100°F rapidly diminishes the product's reactivity and must be avoided. Refrigeration is an acceptable means to increase storage life, however freezing should be prevented. Shelf life results are based on constant temperature storage between 55 and 75°F - (12/23°C).

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 exothermic temperatures. Avoid mixing large quantities or creating thick cross sections (over 1/4 inch) as high temperatures may cause damage, skin burns and create the release of volatile vapors. To assure maximum bond strength, surfaces must be mated within the specified working time. Use sufficient material to ensure the joint is completely filled when parts are mated and lapped. All adhesive application and part positioning should occur before the working time of the mix has expired. After indicated working time, parts must remain undisturbed until the fixture time is reached.

Working time:

The working time information 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, and 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. - (15/30 c).

High temperatures increase the cure rate while lower temperatures slow the cure.
Use at temperatures below 55°F - (12°C). may cause incomplete cure.

Disclaimer:

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