



# TECHNICAL DATA SHEET



## 1. DESCRIPTION

RodPoxy Adhesive is a two-part methacrylate, structural rodding and clip bonding adhesive designed for the structural bonding of sink clips, steel and fiberglass rodding materials, and steel and aluminum to solid surface (acrylic and polyester), engineered stone, quartz surfaces, and natural stone products. Combined at a ratio of 1:1, RodPoxy has a working time of 4 to 8 minutes and achieves nearly 90 percent of its ultimate strength in 10 to 15 minutes at room temperature curing. RodPoxy provides high strength bonds to acrylic solid surface, polyester solid surface (both filled and unfilled), and alloy solid surface (combinations of both acrylic and polyester solid surface resins) and the steel clips, rods, fiberglass and other materials. RodPoxy bonds very strongly to steel, stainless steel, and aluminum metals. RodPoxy is NOT UV STABLE, AND WILL YELLOW OVER TIME and must not be used to create imperceptible seams in countertops. However, this yellowing will not affect bond performance, but will affect bond appearance.

## 2. CHARACTERISTICS:

### Room Temperature Cure

- Working Time
- Fixture Time
- Can be Moved In
- Operating Temp.
- Gap Filling
- Mixed Density
- Flash Point

### Properties

4 to 8 minutes (at 75°F/ 24°C)  
 10 to 15 minutes (at 75°F/ 24°C)  
 20 to 25 minutes  
 65°F to 85°F (18°C to 30°C)  
 .250 inches  
 8.1 lbs/gal (.96 g/cc)  
 51°F (11°C) – See MSDS for more safety information

## 3. CHEMICAL RESISTANCE:

### Excellent Resistance to:

- Hydrocarbons
- Acids and Bases
- Vinegar
- Wine and Condiments
- Most Household Foods

### Susceptible to:

Polar Solvents  
 Super Strong Acids and Bases

## 4. PHYSICAL PROPERTIES:

### Uncured:

- Viscosity(cps)
- Color
- Density (lbs/gal)
- Mix Ratio (wt or vol)
- Mixer Recommendation

### Resin

30,000 – 50,000  
 Translucent  
 8.2  
 1.0  
 Cartridge (50ml):  
 Cartridge (400ml):

### Activator

70,000 – 100,000  
 Amber  
 8.0  
 1.0  
 MBQ05-24L– Square 24 element  
 7701370 – Square 18 element

## 5. MECHANICAL PROPERTIES:

### Tensile Strength (ASTM D638)

- Strength, psi
- Strength, psi
- Strength, psi
- Strength, psi

### Substrate

Acrylic Solid Surface  
 Polyester Solid Surface  
 Steel/Stainless Steel  
 Aluminum

### Results

2,500 - 3,000  
 2,500 – 3,000  
 2,800 – 3,500  
 2,000 – 2,500

### Failure Type

Cohesive  
 Substrate  
 Cohesive  
 Cohesive



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### **6. HANDLING AND APPLICATION:**

**RodPoxy** resin (Part A) and activator (Part B) are flammable. Contents include Methacrylate ester and acids. Keep containers closed after use. Wear gloves and safety glasses to avoid skin and eye contact. Wash with soap and water after skin contact. In case of eye contact, flush with water for 15 minutes and get medical attention. Harmful if swallowed. Keep out of the reach of children. Keep away from heat, sparks, and open flames. Do not smoke cigarettes or anything else while handling or near the product. Refer to the RodPoxy Safety Data Sheet for more complete safety instruction. To assure maximum bond strength, surfaces must be mated together within the specified working time, and all clamps affixed within that time. Use sufficient material to ensure that the joint is completely filled when parts are mated and clamped. Avoid over clamping parts, which may cause a dry joint or a joint starved of adhesive. All adhesive application, part positioning, fixturing, and clamping should occur before the working time of the adhesive has expired. After the indicated working time, parts must remain undisturbed until the fixture time is completed. Components bonded, adhesive, and shop temperature can have a significant effect on the work and fixture time of the adhesive. Application of RodPoxy adhesive at temperatures between 65°F and 85°F (18°C and 30°C) will ensure proper cure. Temperatures below 65°F (18°C) will slow cure and fixture speed. RodPoxy adhesives will still react, but will take longer. Temperatures above 85°F (18°C and 30°C) will increase cure and fixture speeds, and there's a risk that the adhesive will be hardened or too thick to bond materials. The viscosities of RodPoxy adhesives are affected by temperature.

**NOTE:** Because of the rapid curing features of RodPoxy adhesives, large amounts of heat are generated when large masses of material are mixed at one time. The heat generated by the exotherm resulting from mixing large amounts of adhesive can result in a boiling of the monomer in the adhesive (methyl methacrylate), resulting in the release of trapped air, steam and volatile gasses. To prevent this, use only enough material as needed for use within the working time for the product, and confine the gap or spread out the material to no more than .250 inches.

### **7. HANDLING AND STORAGE**

The shelf life of RodPoxy is one (1) year from the date of manufacture based upon continuous storage at room temperature (77°F or 25°C). Storage of RodPoxy in refrigerated compartments will extend the shelf life even more. Do not store RodPoxy or any other adhesives in a refrigerator which has food or lunch products in them. Be sure to bring RodPoxy adhesives to room temperature for 24 hours before use, otherwise longer cure and fixture times may be expected. Long-term storage at temperatures above room temperature will shorten the shelf life of RodPoxy adhesives. Storage at temperatures above 100°F or 38°C could shorten the shelf life to less than one month. RodPoxy contains no water, so freezing of the adhesive for short periods is permissible, but is not encouraged.

### **8. ADDITIONAL INFORMATION**

**NOTE:** All information on this data sheet is based upon laboratory testing and is not intended for design purposes. RodPoxy Adhesive Company makes no representations or warranties of any kind concerning this data. Due to the variance of storage, handling, and application of these materials, UltraTuf Adhesive Company cannot accept liability for results obtained.

### **9. Company Identification:**

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