

Orenco® Adhesives and Dispensers



SA530-300/300



SA510-300/300



MA-BATT GUN-600ML



MA320



IPS 810



ADH100

Structural Methacrylate Adhesives

SA530 and SA510

SA530 and SA510 are two-component methacrylate structural adhesives. They are used to bond PVC, ABS, and fiberglass for strong, watertight joints. They will not bond to concrete. Roughen bonding surfaces with sandpaper for the best bond. Clean, dry bonding surfaces are required for proper adhesion.

SA530 is intended for applications requiring a long working time or for thicker adhesive bead lines; SA530 will sag slightly in warm temperatures. SA510 is intended for applications requiring a short working time or for thinner adhesive bead lines. These products have a 1:1 mix ratio.

MA320

MA320 is a two-component methacrylate adhesive. It is used to bond PVC, ABS, and fiberglass for strong, watertight joints. It will not bond to concrete. Roughen bonding surfaces with sandpaper for the best bond. 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. It is used to bond PVC, ABS, fiberglass, and concrete for strong, watertight joints. Roughen bonding surfaces with sandpaper for the best bond. Clean, dry bonding surfaces are required for proper adhesion. IPS 810 requires hand-mixing.

Sealant/Adhesives

ADH100

ADH100 is a single-component adhesive/sealant. It is used for sealing pipe grommets and for joining PVC or fiberglass risers to ABS or fiberglass PRTA-style tank adapters (where joints are in shear). Clean, dry bonding surfaces are required for proper adhesion. ADH100 will sag slightly in warm temperatures. It is not formulated for exposure to sunlight and not intended for structural joints that are primarily in tension, in peel, or in bending.

Product images are for illustrative purposes only.

Adhesive Specifications

	SA530	SA510	MA320	IPS 810	ADH100
Applications	Bonds PVC, ABS, fiber-glass; for longer working times or thicker adhesive beads	Bonds PVC, ABS, fiber-glass; for shorter working times or thinner adhesive beads	Bonds PVC, ABS, fiber-glass	Self-leveling; bonds PVC, ABS, fiberglass, concrete	Shear joints (PRTA-style adapters; adheres and seals pipe grommets, fasteners, etc.
Color	Gray	Gray	White	White	Clear
Working Time	20-30 minutes	10-15 minutes	10-20 minutes	~ 30 minutes	n/a (4-minute tack time)
Cure Time @ 70° F (21° C)	< 2 hours, depending on ambient temperature and adhesive bead/joint thickness	< 45 minutes, depending on ambient temperature and adhesive bead/joint thickness	~ 1 hour, depending on ambient temperature and adhesive bead/joint thickness	~ 2 hours, depending on ambient temperature and adhesive bead/joint thickness	Handling strength in 12 hours; full cure in 2-3 days
Unit Quantities	300/300-mL cartridge (600 mL total)	300/300-mL cartridge (600 mL total)	7-oz (200-mL) packet	1 pint (473 mL) 1 quart (946 mL)	10.2-oz (300-mL) tube
Shelf Life	See "use by" date on cartridge	See "use by" date on cartridge	1 year from oldest date code shown on product	1 year from date shown on product	2 years from date code shown on product
Dispensing Guns	MA-BATT GUN-600ML MA-MANUAL GUN-600ML	MA-BATT GUN-600ML MA-MANUAL GUN-600ML	None, hand-mix in packet	None, hand-mix in jar	Standard caulking gun

Approximate Quantities of Adhesive Needed, By Product

	SA530 300/300-mL cartridge	SA510 300/300-mL cartridge	MA320 7-oz (200-mL) packet	IPS 810 1 pint	ADH100 10.2-oz (300-mL) tube
GR24XX Grade Ring 24-in. (600-mm)	½ cartridge*	½ cartridge*	1-2 packets	N/A	1 tube
GR30XX Grade Ring 30-in. (750-mm)	< 1 cartridge*	< 1 cartridge*	2 packets	N/A	< 2 tubes
PRTA24 Adapter 24-in. (600-mm)	½ cartridge*	½ cartridge*	1-2 packets	N/A	1 tube
PRTA24-2 Adapter 24-in. (600-mm)	≥ ½ cartridge*	≥ ½ cartridge*	N/A	< 1 pint	N/A
PRTA30 Adapter 30-in. (750-mm)	< 1 cartridge*	< 1 cartridge*	2 packets	N/A	< 2 tubes
RRFTA Adapter 24-in. (600-mm)	< 1 cartridge	N/A	N/A	1 pint*	N/A
RRFTA30 Adapter 30-in. (750-mm)	1 cartridge	N/A	N/A	1 quart*	N/A

* Indicates the preferred adhesive(s) for the product listed