

Adhesive	Applications	Working Time	Cure time @ 70° F (21° C)	Physical Description	Product Notes
ADH100	Bonding, sealing; bonds PVC, ABS, fiberglass, seals pipe grommets	4 minutes	Handling strength in 12 hours, full cure in 2-3 days	Opaque, toothpaste	<ul style="list-style-type: none"> Clean, dry bonding surface required; will sag slightly in warm temperatures. Not formulated for exposure to sunlight. Not intended for structural joints that are primarily in tension, in peel, or in bending Single-part adhesive; 10.2-oz (300-mL) tube uses standard caulking gun
MA320	Structural joint bonding; bonds PVC, fiberglass	10-20 minutes	< 1 hour; depends on temperature, adhesive thickness	White, peanut butter	<ul style="list-style-type: none"> Clean, dry bonding surface required; roughened surfaces recommended for best bonding Two-part adhesive; supplied in 7-ounce (200-g packets), no dispensing gun required
SA510	Structural joint bonding; bonds PVC, ABS, fiberglass at low ambient temperatures	10-15 minutes	< 45 minutes; depends on temperature, adhesive thickness	Gray, toothpaste	<ul style="list-style-type: none"> Clean, dry bonding surface required; roughened surfaces recommended for best bonding. For shorter working times or thinner adhesive beads Two-part adhesive, 1:1 mix ratio
SA530	Structural joint bonding; bonds PVC, ABS, fiberglass	20-30 minutes	< 2 hours; depends on temperature, adhesive thickness	Gray, toothpaste	<ul style="list-style-type: none"> Clean, dry bonding surface required; roughened surfaces recommended for best bonding. For longer working times or thicker adhesive beads; will sag slightly in warm temperatures Two-part adhesive, 1:1 mix ratio
SA590	Structural joint bonding; bonds PVC, ABS, fiberglass	80-100 Minutes	< 3 hours; depends on temperature, adhesive thickness	Gray, toothpaste	<ul style="list-style-type: none"> Clean, dry bonding surface required; roughened surfaces recommended for best bonding. For longer working times or thicker adhesive beads in very warm or hot temperatures; will sag slightly Two-part adhesive; 1:1 mixing ratio
IPS 810	Structural joint bonding, self-leveling; bonds PVC, ABS, fiberglass; concrete	~ 30 minutes	~ 2 hours; depends on temperature, adhesive thickness	White, molasses	<ul style="list-style-type: none"> Self-leveling Two-part adhesive; 10:1 mixing ratio; requires hand mixing

* Contact your local Distributor or Orenco for shipping information or an MSDS sheet on any of Orenco's adhesives.

Product Recommendations and Quantities

	ADH100 10.2-oz (300-mL) Tube	MA320 7-oz (200-g) Packet	SA510 600-mL Cartridge	SA530 600-mL Cartridge	SA590 600-mL Cartridge	IPS 810 1-pint (473-mL) jar
GR24XX Grade Ring 24-in. (600-mm)	Requires one tube	Requires one packet	Requires 1/3 cartridge*	Requires 1/3 cartridge*	Requires 1/3 cartridge**	N/A
GR30XX Grade Ring 30-in. (750-mm)	Requires two tubes	Requires two packets	Requires 2/3 cartridge*	Requires 2/3 cartridge*	Requires 2/3 cartridge**	N/A
PRTA24 Adapter 24-in. (600-mm)	Requires one tube	Requires one packet	Requires 1/3 cartridge*	Requires 1/3 cartridge*	Requires 1/3 cartridge**	N/A
PRTA24-2 Adapter 24-in. (600-mm)	Requires one tube	Requires one packet	Requires 1/3 cartridge	Requires 1/3 cartridge	Requires 1/3 cartridge**	<1 pint*
PRTA30 Adapter 30-in. (750-mm)	Requires two tubes	Requires two packets	Requires 2/3 cartridge*	Requires 2/3 cartridge*	Requires 2/3 cartridge**	N/A
RRFTA Adapter 24-in. (600-mm)	N/A	N/A	N/A	N/A	N/A	1 pint*

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

** Preferred adhesive for very warm or hot climates