

Orenco® Adhesives and Dispensers



MA8120-300/300



SA510-300/300



MA-BATT GUN-600ML



MA320



IPS 810

Structural Methacrylate Adhesives

MA8120 and SA510

MA8120 and SA510 are two-component methacrylate structural adhesives. They are used to bond PVC, ABS, and fiberglass for strong, watertight joints. They do 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; MA8120 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 PVC, ABS, and fiberglass 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 PVC, ABS, fiberglass, and concrete for strong, watertight joints. Clean, dry bonding surfaces are required for proper adhesion. IPS 810 requires hand-mixing.

Sealant/Adhesive

ADH200

ADH200 is a moisture-curing, single-component adhesive/sealant used for sealing pipe grommets and for joining PVC or fiberglass risers to ABS or fiberglass tank adapters where joints are in shear. It is designed for applications in damp, dry, or cold climates. This adhesive 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.

Product images are for illustrative purposes only.

Adhesives Specifications

	MA8120	SA510	MA320	IPS 810	ADH200
Applications	Bonds PVC, ABS, fiberglass; for longer working times or thicker adhesive beads	Bonds PVC, ABS, fiberglass; for shorter working times or thinner adhesive beads	Bonds PVC, ABS, fiberglass	Self-leveling; bonds PVC, ABS, fiberglass, concrete	Shear joints (PRTA-style adapters; adheres and seals pipe grommets, fasteners, etc.)
Color	Gray	Gray	White	White	White
Working Time @ 70° F (21° C)	About 20 minutes	10-15 minutes	10-20 minutes	~ 10 minutes	n/a; 35 min (+/- 10 min) tack free 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	12 months from date of mfg when stored at 70° F (21° C) with 50% relative humidity.
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

	MA8120	SA510	MA320	IPS 810	ADH200
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 pint	N/A

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