

### 1. DESCRIPTION

**Chem-Set<sup>TM</sup> Rodmaster 6600T Rodding adhesive** is a two-part methacrylate, 10 to 1 ratio, structural bonding adhesive designed for the structural bonding of various substrates, including fiberglass, steel, aluminum, and various plastics (not low energy surfaces). Combined at a ratio of 10:1, **Rodmaster 6600T Rodding adhesive** has a working time of 3 to 7 minutes and achieves nearly 90 percent of its ultimate strength in 10 to 15 minutes at room temperature curing. **Chem-Set<sup>TM</sup> Rodmaster 6600T Rodding adhesive** provides high strength with different rod options, including steel (round, flat, and high-tension bars), fiberglass rods, and carbon fiber rods with no preparation effort. The **Rodmaster 6600T** rodding adhesive works on damp granite and bonds very strongly to most granites, engineered stone, and marbles. Simply, blow out dust and water in grooves with compressed air. It is important that the rod slots should be cut to provide a minimal gap (<1/32") on all sides for adhesive between the rod and the stone. Oversized slots weaken the stone, create wasted adhesive and can cause the stone to break as the adhesive cures. For 1/8" fiberglass rod a blade with a thickness of .165" (e.g. Alpha Hot Rod HT03A+ or similar) is appropriate. **Chem-Set<sup>TM</sup> Rodmaster 6600T Rodding adhesive** is flowable, and will flow into channels, especially to be used for horizontal applications. **Chem-Set<sup>TM</sup> Rodmaster 6600T Rodding adhesives** are NOT UV STABLE, AND WILL YELLOW OVER TIME and must not be used to create imperceptible seams in countertops or for seaming countertops. This yellowing will not affect bond performance but will affect bond appearance.

### **Chemical Concepts**

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### 2. CHARACTERISTICS:

#### Room Temperature Cure

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

#### Properties

3 to 7 minutes (at 75°F/ 24°C)  
 10 to 15 minutes (at 75°F/ 24°C)  
 15 to 20 minutes  
 65°F to 85°F (18°C to 30°C)  
 BD466 is a flowable rodding adhesive  
 8.1 lbs/gal (.96 g/cc)  
 51°F (11°C) – See SDS for more safety information

### 3. PHYSICAL PROPERTIES:

#### Uncured:

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

#### Resin

40,00 – 100,000  
 Cream  
 11 to 12  
 10

#### Activator

20,000 – 50,000  
 Clear  
 8.5  
 1.0

- Cartridge (250/490ml): MFQX 08-24T – Square 24 element Orange/Green Mix Tips (10:1)

### 4. MECHANICAL PROPERTIES:

#### Tensile Strength (ASTM D638)

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

#### Substrate

Fiberglass Surfaces  
 ABS/PVC Sheeting  
 Steel/Stainless Steel  
 Aluminum

#### Results

2,500+  
 1,000+  
 2,500 – 3,500  
 2,500 – 3,500

#### Failure Type

Substrate  
 Substrate  
 Cohesive  
 Cohesive

### 5. EXAMPLE OF STRENGTHENING WITH Chem-Set<sup>™</sup> Rodmaster 6600T Rodding adhesive

Situation	Flexural Strength	Sample Dimensions	How to Rod
Unreinforced Granite	<750 PSI	3cm granite 36" long x 3" wide	As Is
Reinforce Granite	< 5,000 PSI	3cm granite 36" long x 3" wide with a 2.5mm Fiberglass rod in ¼" wide channel that is ½" deep	Cut ¼ inch channel wet; blown dry with compressed air

### 6. HANDLING AND APPLICATION:

**Chem-Set<sup>™</sup> Rodmaster 6600T** Rodding 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 **Rodmaster 6600T** Rodding 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 **Rodmaster 6600T** Rodding 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. **Rodmaster 6600T** Rodding adhesives will still react, but will take longer, and it may be hard to dispense with manual and pneumatic dispensers. Warm up to room temperature slowly by setting in an office. 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 **Rodmaster 6600T** Rodding adhesives are affected by temperature.

### 7. HANDLING AND STORAGE

The shelf life of **Rodmaster 6600T** Rodding adhesive is twelve (12) months from the date of manufacture based upon continuous storage at room temperature (77°F or 25°C). Storage of **Rodmaster 6600T** Rodding adhesives in refrigerated compartments will extend the shelf life even more. Do not store **Rodmaster 6600T** Rodding adhesive or any other adhesives in a refrigerator which has food or lunch products in them. Be sure to bring **Rodmaster 6600T** Rodding 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 **Rodmaster 6600T** Rodding adhesives considerably. Storage at temperatures above 100°F or 38°C could shorten the shelf life to less than one month. **Rodmaster 6600T** Rodding adhesives contain no water, so freezing of the adhesive for short periods is permissible, but is not encouraged.

### 8. ADDITIONAL INFORMATION

NOTE: Information contained herein is based on tests we believe to be reliable and accurate. It is offered in good faith for the benefit of the consumer. The Company shall not be liable for any injury, loss, or damage in the use or handling of its chemical products since conditions and use are beyond our control. In every case, we urge and recommend the user conduct tests to determine to their own satisfaction that the product is of acceptable quality and suitability for their particular purpose under their own operating conditions. Statements concerning possible use of our products are not intended as recommendations to use our products in the infringement of any patent, or for any particular purpose or application. These products are intended for industrial use only.