



GENERAL DESCRIPTION

Weld-On® 11 is a white, low VOC emission, thick syrupy, two-component, high strength reactive adhesive. It is conveniently packaged in a dual cylinder cartridge (10:1 ratio) and can readily be applied onto bonding surfaces by attaching the cartridge to the dispensing gun and mixing tip. Weld-On 11 A & B has these physical properties and capabilities: fast cure time, withstand very high pressure and high impact resistant.

BONDING RECOMMENDATIONS

Weld-On 11 is specially formulated for bonding large diameter PVC and CPVC pipe and fittings. It also bonds ABS, Styrene, Acrylic, FRP (fiberglass-reinforced polyester), aluminum (non-anodized), other metals, concrete, clay and other materials to themselves or to dissimilar materials. It is great for repairing cracks or leaky pipe valves and fittings. Weld-On 11 has excellent gap-filling property and is ideal for fabricating fittings and joining saddles to pipe. It also provides excellent adhesion in peel, tensile or sheer applications. For joints subjected to chemical exposure, prior evaluation must be made of the specific chemical concentration, temperature and pressure involved and the compatibility with Weld-On 11. **Not recommended for use on Neoprene, Delrin, PTFE, Silicone, Polypropylene, Polyethylene and other Polyolefin's or joints with an interference fit.**

STANDARDS AND CERTIFICATION LISTINGS

- Meets SCAQMD Rule 1168/316A
- Compliant with LEED® (Leadership in Energy and Environmental Design). When using this Weld-On low VOC product, credit can be claimed for LEED Green Building Rating System – Indoor Environmental Quality.

ADHESIVE PROPERTIES AND CHARACTERISTICS @ 73°F (23°C)

Color:	White	Time to reach ultimate bond strength:	24 Hours
Viscosity:	40,000 ± 10,000 cps	Approximate Coverage:	15 sq ft/cartridge*
Reactivity:	35 Minutes ± 5	Specific Gravity:	Component A: 1.054 ± 0.004 Component B: 1.060 ± 0.004
Working Time:	25 Minutes		
Fixture Time (Time to reach 80% of ultimate strength):	1 Hour		

*Based on laboratory evaluation @ 20 mil thickness. This data is for reference only. Actual coverage may vary. Ultimate Bond Strength is defined as strength achieved after 24-hour room temperature cure.

DIRECTIONS FOR USE

SUBSTRATES PREPARATION:

Bonding surfaces must be clean and dry. If the surfaces are hard and glossy such as metals, abrading (sanding) and priming with a degreasing solvent is recommended. Chlorinated solvents, methyl ethyl ketone, acetone and/or rubbing isopropyl alcohol may be used to remove grease and/or dirt.

CARTRIDGE ASSEMBLY:

1. Remove plugs from both sides of cartridge (i.e. nozzle and bottom piston) by removing the retaining nut.
2. Place cartridge into the dispensing gun channel. Press trigger until both plungers are snug against the bottom pistons. Continue to press trigger allowing both resin and catalyst to reach tip of cartridge nozzle. Ensure both components are flowing freely from the cartridge nozzle. Wipe off excess resin and catalyst.
3. Attach mixing tip to cartridge and tighten the retaining nut. DO NOT OVER TIGHTEN. The mixing tip can be inserted by lining up the notch on the cartridge with the cutout on the mixing tip.

NOTE: To preserve unused adhesive in the cartridge, leave the mixing tip in place as it temporarily reseals the cartridge. The cartridge with the mixing tip can be removed from the dispensing gun. When you are ready to use the adhesive again:

- Remove the old mixing tip and thoroughly clean the threaded areas at the cartridge nozzle concurrently ensuring there is NO crossover of the two components. Remove any blockages that may have formed in the nozzle. DO NOT FORCE BLOCKAGES BACK INTO THE CARTRIDGE.
- Repeat cartridge assembly steps 2 and 3. Ensure there is no residual catalyzed material in the cartridge nozzle area.
- Always use a new mixing tip when the cartridge is not in use for prolonged duration. DISCARD THE FIRST 6-12 INCHES OF ADHESIVE AFTER THE NEW MIXING TIP IS INSERTED.

INSTALLATION:

1. Assemble materials for the job: Weld-On 11 cartridge, dispensing gun, mixing tips, sandpaper, clean wiping cloth, cleaning solvent, safety glasses and gloves.
2. Prepare joints by sanding to roughen mating surfaces. Wipe surfaces clean with a dry rag or solvent cleaner. Do not soften surfaces with solvent cleaner.



AVAILABILITY

This product is available in 470 ml dual cylinder cartridge. For detailed information on containers and applicators, refer to the current Sign and Display Assembly Selection Guide and Price List.

SHELF LIFE

1-1/2 year in tightly sealed containers stored away from direct sunlight in a cool 50° F – 80° F (10° C – 27° C) dry place. Storage near the ceiling in non air-conditioned warehouses is not recommended. Shelf life is reduced at higher temperatures and enhanced at lower temperatures. Keep away from sources of heat, open flame, sparks and sunlight. The date code of manufacture is stamped on the bottom of the container.

QUALITY ASSURANCE

Weld-On® 11 is carefully evaluated to assure that consistent high quality is maintained. Fourier transform infrared spectroscopy, gas chromatography, and additional in depth testing ensures each batch is manufactured to exacting standards. A batch identification code is stamped on each can and assures traceability of all materials and processes encountered in manufacturing this plastic cement for its intended specific application.

SHIPPING

Shipping Information for One Liter Kit and Above*: Proper Shipping Name: Adhesive. Hazard Class: 3. Identification Number: UN 1133. Packing Group: II. Label Required: Flammable Liquid. **For Less than One Liter:** Proper Shipping Name: Consumer Commodity. Hazard Class: ORM-D

*If components are shipped separately, see Material Safety Data Sheet for shipping instructions.

SAFETY AND ENVIRONMENTAL PRECAUTIONS

This product is a flammable, reactive adhesive. It is considered a hazardous material. In conformance with the Federal Hazardous Substance Labeling Act, the following hazards and precautions are given. Purchasers who may re-package this product must also conform to all local, state, and federal labeling, safety and other regulations. VOC emissions do not exceed 100 grams per liter.

WARNING! FLAMMABLE. VAPOR HARMFUL. MAY BE HARMFUL IF SWALLOWED. MAY IRRITATE SKIN OR EYES.

Keep out of reach of children. Do not take internally. Keep away from heat, spark, open flame and other sources of ignition. Keep container closed when not in use. Store away from direct sunlight between 50° F – 80° F (10° C – 27° C). Use only in adequate ventilation. Avoid breathing of vapors. Atmospheric levels should be maintained below established exposure limit values. See Section II of Material Safety Data Sheet. If airborne concentrations exceed those limits, use of a NIOSH-approved organic vapor cartridge respirator with full face-piece is recommended. The effectiveness of an air-purifying respirator is limited. Use it only for a single short-term exposure. For emergency and other conditions where short-term exposure guidelines may be exceeded, use an approved positive pressure self-contained breathing apparatus. Do not smoke, eat or drink while working with this product. Avoid contact with skin, eyes and clothing. May cause eye injury. Protective equipment such as gloves, goggles and impervious apron should be used. Carefully read Material Safety Data Sheet and follow all precautions.

Component "A" contains Methyl Methacrylate Monomer (80-62-6). Component "B" contains Methyl Ethyl Ketone (78-93-3) and Benzoyl Peroxide (94-36-0). Do not use this product for other than intended use.

"Title III Section 313 Supplier Notification:" This product contains toxic chemicals subject to the reporting requirements of Section 313 of the Emergency Planning and Community Right-to-Know Act of 1986 and of 40CFR372. This information must be included in all Material Safety Data Sheets that are copied and distributed for this material.

FIRST AID

Inhalation: If overcome with vapors, remove to fresh air. If not breathing, give artificial respiration. If breathing is difficult, give oxygen. Call physician.

Eye Contact: Flush with plenty of water for 15 minutes and call a physician.

Skin Contact: Wash skin with plenty of soap and water for at least 15 minutes. If irritation develops, get medical attention.

Ingestion: If swallowed, give 1 or 2 glasses of water or milk. Do not induce vomiting. Contact physician or poison control center immediately.

IMPORTANT NOTE

This product is intended for use by skilled individuals at their own risk. These suggestions and data are based on information we believe to be reliable. Users should verify by test that this product, as well as these methods, is suited to their application.

WARRANTY

IPS Corporation (IPS Corp.) warrants that all new IPS Corp. products shall be of good quality and free from defects in material and workmanship for the shelf life as indicated on the product. If any IPS Corp. product becomes defective, or fails to conform to our written limited warranty under normal use and storage conditions, then IPS Corp. will, without charge, replace the nonconforming product. However, this limited warranty shall not extend to, nor shall IPS Corp. be responsible for, damages or loss resulting from accident, misuse, negligent use, improper application, or incorporation of IPS Corp. products into other products. In addition, any repackaging of IPS Corp. products also shall void the limited warranty. IPS Corp. shall not be responsible for, nor does this limited warranty extend to, consequential damage, or incidental damage or expense, including without limitation, injury to persons or property or loss of use. Please refer to our standard IPS Corp. Limited Warranty for additional provisions.

