



# TYPICAL PROPERTIES

	WELD-ON® NUMBER	COLOR	NUMBER OF COMPONENTS	WORKING TIME	FIXTURE TIME (80% BOND STRENGTH)	ULTIMATE BOND STRENGTH	MINIMUM EXPECTED SHELF LIFE @73°F (yr)	TYPICAL SPECIFIC GRAVITY (g/cc)	TYPICAL VISCOSITY (cps)	VISCOSITY REFERENCE
<b>ACRYLICS</b>	3★	clear	1	1 min	2 min	24 hrs	2	1.330	–	water thin
	4★	clear	1	1-2 min	3 min	72 hrs	2	1.375	–	water thin
	4SC●	clear	1	1-2 min	3 min	72 hrs	2	1.120	–	water thin
	16●	clear	1	5-6 min	10 min	24 hrs	2	1.107	800	motor oil
	28●	clear	3	15 min	2 hrs	24 hrs	1*	1.034	3,400	syrup
	40●	clear	2	20 min	2 hrs	72 hrs	1*	1.026	2,900	syrup
	42●	clear	2	15 min	2 hrs	72 hrs	1*	1.026	2,900	syrup
	1802	clear	1	8 min	10-15 min	72 hrs	3	0.880	350	motor oil
3061●	clear	1	–	–	–	2	0.944	–	water thin	
<b>VINYLS PVC, CPVC</b>	66●	clear	1	2-20 min	45-60 min	2 hrs	3	0.850	300	motor oil
	1001	clear	1	15-20 min	30 min	72 hrs	3	0.931	500	motor oil
	1829	tan	1	2-5 mins	2-4 hrs	16-24 hrs	2	0.862	1,750	syrup
	1910	clear	1	15 min	20-25 min	72 hrs	3	0.924	2,100	syrup
	2007●	clear	1	1-2 min	3 min	24-48 hrs	3	0.849	–	water thin
	4007	clear	1	20 min	25 min	72 hrs	3	0.934	800	motor oil
	4052●	clear**	1	15 min	20-25 min	72 hrs	2	0.955	500	motor oil
	4784	clear	1	20 min	20-30 min	72 hrs	3	0.904	335	motor oil
<b>ABS</b>	1707	milky	1	10 min	15-20 min	24 hrs	3	0.900	1,300	motor oil
	2354	clear	1	3 min	5 min	72 hrs	3	0.805	–	water thin
	4707●	milky	1	10 min	10-15 min	24 hrs	3	0.884	4,000	syrup
<b>POLYCARBONATE</b>	55●	clear	2	5-6 min	1-2 hrs	72 hrs	1	1.168	3,000	syrup
	58●	clear	2	2-3 min	20 min	72 hrs	1	1.166	4,000	syrup
<b>STYRENE</b>	4807	milky	1	10-15 min	20 min	72 hrs	3	0.880	600	motor oil
<b>STRUCTURAL</b>	10●	white	2	25 min	1 hr	24 hrs	1	1.053	40,000	ketchup
	11●	white	2	25 min	1 hr	24 hrs	1.5	1.054	40,000	ketchup
	30	off white	2	4-5 min	15-20 min	24 hrs	.5	1.010	225,000	peanut butter
	31	off white	2	13-17 min	30-40 min	24 hrs	.5	1.010	225,000	peanut butter
	32	off white	2	25-35 min	50-70 min	24 hrs	.5	1.010	225,000	peanut butter
	45●	tan	2	5-6 min	15 min	24 hrs	1	1.064	500,000	peanut butter
<b>CLEANER</b>	57	blue (transparent)	1	–	–	–	3	0.810	–	water thin

★For professional use only. \* Refrigeration is recommended to increase shelf life. \*\* Thin amber layer of solvent cement on substrate appears clear when dry.

● These products meet requirements of California South Coast Air Quality Management District (SCAQMD) Rule 1168.

Technical Data Sheets and Material Safety Data Sheets should be read before using our products.

© 2020 IPS, Weld-On Typical Properties/Quick Selection Chart 01/20

ABS	Acrylic Cell Cast	Acrylic Cross-Linked	Acrylic Extruded	Butyrate	Fiberglass	Metal	PETG	Polycarbonate	Polyester	Polyurethane	PVC (Rigid)	PVC (Flexible)	PVC (Foamed)	Styrene	
2354 1707/4707 55/58	16 1802 40/42	10/11 40/42	16 1802 40/42	16 55/58 45/40/42	10/11 45 30/31/32	45 11 30/31/32	16 55/58 40/42	16 55/58 40/42	40/42 10/11	66 4784 55/58	10/11 16/4052 45	45	16 40/42 45	16 1802	ABS
16 1802 40/42	40/42 3/4/45C 16	10/11 40/42	40/42 3/4/45C 16	16 40/42 45	10/11 45 30/31/32	11 45 30/31/32	10/11 40/42 16	16 40/42 45	40/42 10/11	66 4784	40/42 16 4052	45	16 40/42 45	16 4052 10/11	Acrylic Cell Cast
10/11 40/42	10/11 40/42	10/11 40/42	10/11 40/42	40/42 10/11 45	10/11 45	11 45	10/11 40/42 45	10/11 40/42 45	40/42 10/11	40/42 10/11	10/11 40/42 45	45	40/42 45	10/11 40/42	Acrylic Cross-Linked
16 1802 40/42	40/42 3/4/45C 16	10/11 40/42	40/42 3/4/45C 16	16 40/42 45	10/11 45	11 45	10/11 40/42 16	10/11 40/42 45	40/42 10/11	66 4784	40/42 16 4052	45	16 40/42 45	16 4052 10/11	Acrylic Extruded
16 55/58 45/40/42	16 40/42 45	40/42 10/11 45	16 40/42 45	3/4/45C 2007/16 55/58	10/11 45	45 11	16 55/58 40/42	16 55/58 40/42	40/42 10/11 45	66 4784 55/58	16 55/58 40/42	66 4784 45	66 40/42 45	1802 16 45	Butyrate
10/11 45 30/31/32	10/11 45 30/31/32	10/11 45	10/11 45	10/11 45	10/11 45 30/31/32	11 45 30/31/32	10/11 45 30/31/32	10/11 45 30/31/32	10/11 45 30/31/32	10/11 45	10/11 45 30/31/32	45 45 30/31/32	10/11 45	10/11 45	Fiberglass
11 45 30/31/32	11 45 30/31/32	11 45	11 45	11 45	11 45 30/31/32	11 45 30/31/32	11 45 30/31/32	11 45 30/31/32	11 45 30/31/32	11	11 45 30/31/32	45 45 30/31/32	11 45	11 45	Metal
16 55/58 40/42	10/11 40/42 16	10/11 40/42 45	10/11 40/42 16	16 55/58 40/42	10/11 45 30/31/32	11 45 30/31/32	55/58 3/4/45C 40/42	55/58 40/42 45	40/42 45	10/11	10/11 40/42 16	45	16 40/42 45	16 10/11	PETG
16 55/58 40/42	16 40/42 45	10/11 40/42 45	10/11 40/42 45	16 55/58 40/42	10/11 45 30/31/32	11 45 30/31/32	55/58 40/42 45	55/58 3/4/45C 16	40/42 10/11 45	10/11	40/42 10/11 16	45	16 40/42 45	10/11 16 1802	Polycarbonate
40/42 10/11	40/42 10/11	40/42 10/11	40/42 10/11	40/42 10/11 45	10/11 45 30/31/32	11 45 30/31/32	40/42 45	40/42 10/11 45	40/42 10/11 45	10/11 1829	40/42 10/11	45	10/11 40/42 45	40/42 10/11	Polyester
66 4784 55/58	66 4784	40/42 10/11	66 4784	66 4784 55/58	10/11 45	11	10/11	10/11	10/11 1829	66 4784 55/58	66 4784	66 4784 45	66 4784	10/11 45	Polyurethane
10/11 16/4052 45	40/42 16 4052	10/11 40/42 45	40/42 16 4052	16 55/58 40/42	10/11 45 30/31/32	11 45 30/31/32	10/11 40/42 16	40/42 10/11 16	40/42 10/11	66 4784	2007 10/11/40/42 4007	2007 45	16 2007 40/42/45	10/11 16 1802	PVC (Rigid)
45	45	45	45	66 4784 45	45 30/31/32	45 30/31/32	45	45	45	66 4784 45	2007 45	2007 66/4784 45	2007 45	2007 45	PVC (Flexible)
16 40/42 45	16 40/42 45	40/42 45	16 40/42 45	16 40/42 45	10/11 45	45 11	16 40/42 45	16 40/42 45	10/11 40/42 45	66 4784	16 2007 40/42/45	2007 45	2007 16 40/42/45	1802 16 45	PVC (Foamed)
16 1802	16 4052 10/11	10/11 40/42	16 4052 10/11	1802 16 45	10/11 45	11 45	16 10/11	10/11 16 1802	40/42 10/11	10/11 45	10/11 16 1802	2007 45	1802 16 45	4807 16 1802	Styrene