WELD-ON®
SIGN & DISPLAY

DCM & TCE FREE

New Weld-On®
Methylene Chloride-FREE and Trichloroethylene-FREE
Solvent Cements for Acrylics

Introducing the NEW Weld-On® 3, Weld-On® 4 and Weld-On® 16

Weld-On® 3 is a water-thin, non-flammable cement formulated for clear bond to many thermoplastic substrates, particularly acrylic. The initial bond forms within a few minutes and quickly increases in strength to a high level within only a few hours.

SUBSTRATE RECOMMENDATIONS

Bonds acrylic (PMMA) to itself.

Weld-On® 4 is a water-thin cement formulated to develop clear bond within minutes with a longer time full bond strength than Weld-On 3. It is less likely to leave white marks (commonly called blushing) with significant and increased strength reached over several hours.

SUBSTRATE RECOMMENDATIONS

Blush-resistant cement for bonding acrylic (PMMA) to itself.

Weld-On® 16 is a medium-bodied, clear solvent-type acrylic cement with very high strength. The fast curing time means some parts may be handled within a few minutes when applied to cast, molded or extruded acrylics. Bond strength continues to develop very rapidly reaching a substantial level and forming strong joints within hours.

SUBSTRATE RECOMMENDATIONS

Formulated for acrylic (PMMA); also bonds butyrate, PVC, ABS, polycarbonate, and porous plastics.

WELD-ON® NUMBER	STOCK NUMBER	COLOR	NUMBER OF COMPONENTS	WORKING TIME	FIXTURE TIME	ULTIMATE BOND STRENGTH	MINIMUM EXPECTED SHELF LIFE @73°F (yr)	TYPICAL SPECIFIC GRAVITY (g/cc)	VISCOSITY REFERENCE	SIZES	UNITS/CASE
3	16369	clear	1	1 min	2 min	2,825 lbs/in	2 years	1.218 ± 0.01	water thin	GALLON	4
	16372	clear	1	1 min	2 min	2,825 lbs/in	2 years	1.218 ± 0.01	water thin	QUART	4
	16370	clear	1	1 min	2 min	2,825 lbs/in	2 years	1.218 ± 0.01	water thin	PINT	6
	16371	clear	1	1 min	2 min	2,825 lbs/in	2 years	1.218 ± 0.01	water thin	1/4 PINT	24
4	16374	clear	1	1-2 min	3 min	2,429 lbs/in	2 years	1.164 ± 0.01	water thin	GALLON	4
	16377	clear	1	1-2 min	3 min	2,429 lbs/in	2 years	1.164 ± 0.01	water thin	QUART	4
	16375	clear	1	1-2 min	3 min	2,429 lbs/in	2 years	1.164 ± 0.01	water thin	PINT	6
	16376	clear	1	1-2 min	3 min	2,429 lbs/in	2 years	1.164 ± 0.01	water thin	1/4 PINT	24
16	16381	clear	1	5 min	10 min	2,626 lbs/in	2 years	1.202 ± 0.01	water thin	GALLON	4
	16382	clear	1	5 min	10 min	2,626 lbs/in	2 years	1.202 ± 0.01	water thin	PINT	4
	16383	clear	1	5 min	10 min	2,626 lbs/in	2 years	1.202 ± 0.01	water thin	5 oz TUBE	24
	16384	clear	1	5 min	10 min	2,626 lbs/in	2 years	1.202 ± 0.01	water thin	1.5 oz TUBE	48

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Benefits of Solvent Bonding vs Mechanical Fastening

Solvent Bonding

Advantages

- ✔ Evenly distributes stress on substrate
- ✔ Joins complex parts
- ✔ Invisible finish on sign substrate's surface
- ✔ Acts as a sealant & prevents corrosion
- ✔ Works well with thin metals
- ✔ Requires little finishing and training
- ✔ Reduce labor time and cost
- ✔ Can be sanded, painted or drilled
- ✔ Bonds dissimilar substrates
- ✔ Reduces vibrations

Disadvantages

- ✘ Some curing time required

Mechanical Fastening

Advantages

- ✔ Can be easily inspected once installed; may be pulled apart
- ✔ Immediate connection; no curing time

Disadvantages

- ✘ Stress only at the connection point; not consistently spread across substrate
- ✘ Visible on signage
- ✘ Difficult to paint or hide
- ✘ Higher probability of leakage/ corrosion at joints