



SUBSTRATE RECOMMENDATIONS

Flexible or rigid vinyl to itself or a variety of other plastics and non-plastics.

BONDING RECOMMENDATIONS

Weld-On® 1910 is high strength cement that is being used by a number of companies for bonding flexible vinyl to itself, flexible to rigid vinyl, ABS, acrylic, canvas and other porous materials. It is also being used to repair vinyl seats in buses, patch vinyl waterbeds, etc.

GENERAL DESCRIPTION

Weld-On 1910 is a clear, medium bodied, high strength solvent cement. It cures rapidly with the dissipation of the solvent at room temperature resulting in a very strong, flexible, water resistant bond. Indications are that service life for a number of years may be expected under normal use, but some yellowing may be expected.

TYPICAL BOND STRENGTH[†]

Substrate Material	Aged Bond Strength, lbs/in ² (kg/cm ²)		
	2 Hours	24 Hours	1 Week
PVC	250	650	1,000
ABS	150	500	1,000

[†]Substrate thickness: 0.25 inch (0.64 cm). Bond area: 1.0 in² (6.45 cm²). Ultimate Bond Strength is defined as strength achieved after 24-hour room temperature cure.

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

Color:	Clear	Time to reach ultimate bond strength:	72 Hours
Viscosity:	2100 ± 100 cps	Specific Gravity:	0.924 ± 0.01
Working Time:	15 Minutes	Coverage:	10 mil: 32 sq ft/pint 280 sq ft/gallon
Fixture Time (Time to reach 80% of ultimate strength)	20 – 25 Minutes		20 mil: 16 sq ft/pint 130 sq ft/gallon

DIRECTIONS FOR USE

Clean surfaces to be joined.

Coat each mating surface. Weld-On 1910 may be applied with brush, syringe, gun, etc. Press parts together immediately and hold a few seconds until “grab” begins – or for quicker initial set: coat each surface and wait 10 to 20 seconds, then press firmly together.

If not possible to coat both surfaces, give generous coat to one and press gently to other to wet it. Then apply nominal pressure.

Good strength will develop in a few minutes with some materials. Bond strength will be considerable in a few hours and will reach high strength in 24 to 48 hours. Thereafter, strength will continue to increase gradually for some weeks.

AVAILABILITY

This product is available in gallon (3.785 liters) metal cans. For detailed information on containers and applicators, refer to the current Sign and Display Assembly Selection Guide.

SHELF LIFE

Two years expectancy in tightly sealed containers. Stability of the product is limited by the permanence of the container and the evaporation of the solvent when container is open. Evaporation of solvent will cause the cement to thicken and reduce the effectiveness of the cement.

QUALITY ASSURANCE

Weld-On 1910 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 Individual Container Larger than One Liter: DOT Shipping Name: Adhesive. DOT Hazard Class: 3. ID #: UN1133. Packaging Group: II. Label: Flammable Liquid. **For Less than One Liter:** DOT Shipping Name: Consumer Commodity. DOT Shipping Class: ORM-D.



SAFETY AND ENVIRONMENTAL PRECAUTIONS

This product is a flammable, fast evaporating, solvent. It is considered a hazardous material. In conformance with the Federal Hazardous Substances Labeling Act, the following hazards and precautions are given. Purchasers who may repack this product must also conform to all local, state and federal labeling, safety and other regulations.

**DANGER: EXTREMELY 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 40° F – 110°F (5° C – 43°C). Use only with adequate ventilation. Avoid breathing of vapors. Atmospheric levels should be maintained below established exposure limit values contained in Section II and VIII of the 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, safety goggles and impervious apron should be used. Carefully read Material Safety Data Sheet and follow all precautions.

Contains Tetrahydrofuran (109-99-9), Methyl Ethyl Ketone (78-93-3) and Cyclohexanone (108-94-1). 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.

