



PRODUCT BULLETIN – SPECIFICATIONS  
**WELD-ON 811 A&B**  
A REACTIVE HIGH-STRENGTH ADHESIVE

#### GENERAL DESCRIPTION:

Weld-On 811 is a two-part, high strength adhesive packaged in a cartridge. It cures by the reaction of Component A (Base Resin) with Component B (Catalyst).

This adhesive was formulated especially for large size PVC (Polyvinyl Chloride) pipe and fittings, but has also been found to bond many other plastics and non plastics. Tests show good bond strength with PVC (vinyl) rigid and flexible (with low plasticizer content), ABS, Polycarbonate, Styrene, Acrylics, Butyrate and hard rubber. It also bonds well to steel (plastics to steel or steel to itself), aluminum (not anodized), other metals, concrete and other substrates.

Weld-On 811 is not recommended for Neoprene, Delrin, Celcon, polypropylene, polyethylene.

Weld-On 811 is packaged in a 10:1 475 ml cartridge designed for use with a manual 2 component dispensing gun and a static mixing tip. The adhesive is mixed as it passes through the mixing tip. Working time of the mixed product (bead form) is approximately 25 minutes. About one (1) hour cure time is recommended before handling the joint. Cure time of an applied film is about four (4) hours @ 70°F. Higher strength (near ultimate strength) is reached in 24 to 48 hours. In some applications applying heat to the glue line may speed up the cure time.

#### DIRECTIONS FOR USE:

##### ASSEMBLY OF CARTRIDGE TO DISPENSING GUN.

- Remove plugs from both sides of cartridge by removing the retaining nut.
- Place cartridge into channels of dispensing gun. Work trigger until both plungers are snug against bottom pistons. Continue to work trigger allowing both resin and catalyst to reach end of cartridge. Make sure that both components are flowing freely from the cartridge before inserting mixing tip.
- Attach mixing tip to cartridge and tighten retaining nut. **DO NOT OVER TIGHTEN.** The mixing tip can be inserted only by lining up the notch on the cartridge with the cutout on the mixing tip.

##### IF THE MATERIAL IS NOT COMPLETELY USED WITH ONE APPLICATION, IT CAN BE PRESERVED.

- Leave the mixing tip in place and its presence will temporarily reseal the cartridge. To restore the cartridge to its original state, remove the old mixing tip, clean the threaded areas thoroughly ensuring there is NO crossover of the two components. Remove any blockages that may have formed in the nose area.

##### DO NOT FORCE BLOCKAGES BACK INTO THE CARTRIDGE.

- Replace the cartridge plugs to their original cylinder positions and replace the retaining nut to secure the plugs. Slide the removal disc back into place.
- Before dispensing more adhesive, check to see that there is no residual catalyzed material in the nose area.
- Always use a new mixing tip. Never attempt to force material through a blocked opening or a used mixing tip.
- **DISCARD THE FIRST 6-12 INCHES OF MATERIAL WHENEVER A NEW TIP IS USED.**

#### PREPARATION OF SUBSTRATES:

Where there are hard, glossy surfaces such as metals, abrading (sanding) and priming with a degreasing solvent are recommended. In some cases the afore-mentioned preparation is essential to good adhesion.

Chlorinated solvents, MEK, Acetone or even rubbing alcohol (Isopropyl) may be used for removing grease or dirt.

## **STORAGE/SHELF LIFE:**

When components are stored between 45°F and 60 °F, twelve (12) months shelf life can be expected.

## **PHYSICAL PROPERTIES:**

COLOR:	White
CONSISTENCY:	Heavy, Syrupy
VISCOSITY:	40,000 CPS (Approx.)

## **SHIPPING:**

Shipping Information for Gallon and Above: DOT Hazard Class: 3. DOT Shipping Name: Adhesive.

Identification Number: UN 1247. Contains: Methyl Methacrylate Monomer. Label Required: Flammable.

Shipping Information for Less than One Gallon:

DOT Shipping Name: Consumer Commodity. DOT Hazard Class: ORM-D.

## **SAFETY PRECAUTIONS:**

Weld-On 811 is a flammable reactive adhesive. It is considered a hazardous material. In conformance with 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 and safety and other regulations.

**DANGER - 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 in the shade between 45°F and 60°F. Use only with adequate ventilation. Avoid breathing vapors. Atmospheric levels should be maintained below established threshold limit values. See Section II of MSDS. If airborne concentrations exceed these limits, use a chemical cartridge respirator. For emergencies and other conditions where short term exposure may be exceeded, use an approved positive pressure self-contained breathing apparatus. In confined areas, use a positive pressure self-contained breathing apparatus (SCBA). 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 Sheets and follow all precautions. Contains Methyl Methacrylate Monomer (60-62-6). Do not use this product for other than intended use.

## **FIRST AID:**

Inhalation: If ill effects from inhalation, remove to fresh air. If not breathing, give artificial respiration. If breathing is difficult, give oxygen. Call physician.

Eye Contact or Skin Contact: Flush with plenty of water for 15 minutes. If irritation persists, get medical attention.

Ingestion: If swallowed, do not induce vomiting. Contact physician immediately.

"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 MSDSs that are copied and distributed for this material.

## **QUALITY ASSURANCE:**

Every batch of this cement is checked to assure that consistent quality is maintained. An infrared absorption curve is recorded for each batch to ensure that this product was properly formulated. Samples are taken from all batches and kept for a period of at least one year. A batch identification code is stamped on each can.

## **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. Installers should verify for themselves that they can make satisfactory joints under varying conditions. Toward this end, it is highly desirable that they receive personal instruction from trained instructors or competent, experienced installers. Contact us or your supplier for additional information or instruction.

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