

**GENERAL DESCRIPTION:**

WELD-ON® 810™ is a white, low VOC emission, thick syrupy, two-component, high strength reactive adhesive. It has a fast cure time, withstands very high pressure and is high impact resistant.

**APPLICATION:**

WELD-ON 810 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 810 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 810. **Not recommended for use on Neoprene, Delrin, Teflon, Silicone, Polypropylene, Polyethylene and other Polyolefin's or joints with an interference fit.**

**AVAILABILITY:**

This product is available in 4-ounce (118 ml), pint (473 ml), quart (946 ml) and gallon (3.785 l) two-part, pre-measured, plastic container kits. See our current Price List for detailed information on containers and applicators. For convenient dispensing format, refer to WELD-ON® 811™ which is packaged in 470 ml dual cylinder cartridge and dispensed via dispensing gun and mixing tip.

**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.

**SPECIFICATIONS:**

COLOR:	White
RESIN:	Acrylic
SPECIFIC GRAVITY:	1.03 ± 0.040
BROOKFIELD VISCOSITY:	Minimum 40,000 cps @ 73°F ± 3.6°F
APPROXIMATE COVERAGE:	14 sq. ft. per pint*
	115 sq. ft. per gallon*

\*Based on laboratory evaluation @ 20 mil thickness. This data is for reference only.  
Actual coverage may vary

**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.

**INSTALLATION:**

1. Assemble materials for the job: WELD-ON 810 kit, clean mixing sticks, applicators (spatula or stiff brush), sandpaper, clean wiping cloth, cleaning solvent 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.
3. WELD-ON 810 kit has a mixing ratio of 100:13 and both components are packaged and pre-measured to this ratio. Add Catalyst B (small container) to Resin A (large container). Mix thoroughly and apply to each mating surface. Pot life and working time is about 30 minutes at 70°F (21°C).
4. Assemble parts and allow squeeze out to remain as filler.
5. Allow the joined surfaces to cure undisturbed. Recommended set time is 1 hour. Recommended cure time is 2 hours to reach 80% bond strength (resin layer cures to a hard gel), 24 hours to reach near ultimate strength. The cured layer is a tough, chemical and water resistant plastic.

**Note:** Warmer weather will shorten pot life and cure time. Colder weather will increase the time for both. Applying heat may speed up the cure time. When joining CPVC for service temperatures over 150°F (65°C), please contact IPS® Corporation for more information.

**REPAIR:**

Replacing a failed joint with new material and taking greater care in the joining process is always preferred. This repair is for leaks only and ideal for area where the joint cannot be cut out. Do not use this method if the pipe has separated from the fitting.

1. Assemble materials for the job: WELD-ON 810 kit, clean mixing sticks, applicators (spatula or stiff brush), fiberglass cloth mat cut to desirable size for wrapping the leaked pipe, sandpaper or emery, clean wiping cloth, and gloves.
2. Turn off water pressure. Dry off the bonding area and abrade it well with sandpaper and wipe clean.

3. Prepare WELD-ON 810 adhesive. Add Catalyst B (small container) to Resin A (large container) and mix thoroughly.
4. Apply a generous coat of adhesive mixture to leakage and surrounding area.
5. Apply the adhesive mixture to the mating surface of fiberglass cloth. Wrap cloth around the leaked pipe. Some adhesive should squeeze up through cloth. Note: Fiberglass cloth is recommended for added structural strength to the leaked pipe. Good bonding result is also achievable without using the cloth.
6. Apply an additional coat of WELD-ON 810 adhesive to the top surface.
7. Allow to cure for a minimum of 4 hours at 70°F (21°C). Overnight or 24 hours cure is desirable before re-pressurizing the systems.

#### **SHELF LIFE & STORAGE:**

1 year in unopened containers when stored between 50°F (10°C) and 80°F (27°C). Keep away from sources of heat, sunlight and moisture.

#### **QUALITY ASSURANCE:**

WELD-ON 810 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 used in manufacturing this product.

#### **SHIPPING:**

##### **For One Liter 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

#### **SAFETY AND ENVIRONMENTAL PRECAUTIONS:**

This product is flammable and considered a hazardous material. In conformance with the Federal Hazardous Substances Labeling Act, the following hazards and precautions are given. Purchasers who repackage this product must also conform to all local, state and federal labeling, safety and other regulations. VOC emissions do not exceed 75 grams per liter.

***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. Vapors may ignite explosively. Solvent cement vapors are heavier than air and may travel to source(s) of ignition at or near ground or lower level(s) and flash back. Keep container closed when not in use. Store between 50°F (10°C) and 80°F (27°C). Avoid breathing of vapors. Use only in well-ventilated area. If confined or partially enclosed, use forced ventilation. When necessary, use local exhaust ventilation to remove harmful airborne contaminants from employee breathing zone and to keep contaminants below 25 ppm TWA. Atmospheric levels must be maintained below established exposure limits contained in Section II of the Material Safety Data Sheet (MSDS). 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. Do not use this product for other than intended use.

"SARA 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 (EPCRA) of 1986 and of 40CFR372. This information must be included in all MSDS 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. 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 IPS® Corporation or your supplier for additional information or instructions.

**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.



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