






WELD★ON®




SIGN AND DISPLAY ASSEMBLY SELECTION GUIDE



ACRYLIC SUBSTRATES

3	Non-flammable, water-thin, very fast set solvent cement for acrylics. Will also bond styrene, butyrate and polycarbonate to themselves. Not for joining dissimilar materials. FOR PROFESSIONAL USE ONLY <i>Where not for sale in California (SCAQMD), please use Weld-On #4SC.</i>
4	Non-flammable, water-thin, moderately fast set solvent cement for acrylics. Will also bond styrene, butyrate and polycarbonate to themselves. Not for joining dissimilar materials. FOR PROFESSIONAL USE ONLY <i>Where not for sale in California (SCAQMD), please use Weld-On #4SC.</i>
4SC 	Water-thin, fast set solvent cement for acrylics. Will also bond styrene, butyrate and polycarbonate to themselves. Not for joining dissimilar materials.
16 	Fast drying, high strength, medium bodied cement for acrylics. Will also bond styrene, butyrate, polycarbonate and other plastics.
28° KIT 	Hand mixed three-component, reactive, high strength acrylic based adhesive with excellent weatherability. Mil Spec A-8576C Type II. Refrigeration Recommended.
40° KIT 	Hand mixed two-component 20:1, reactive, high strength acrylic based adhesive provides "museum quality" water clear joints with excellent weatherability. Mil Spec A-8576C Type III. Refrigeration Recommended.
42° 50 ml Cartridge 	Two-component 10:1, reactive, high strength acrylic based adhesive provides "museum quality" water clear joints with excellent weatherability. Mil Spec A-8576C Type III. Refrigeration Recommended.
42° 230 ml Cartridge 	Two-component 10:1, reactive, high strength acrylic based adhesive provides "museum quality" water clear joints with excellent weatherability. Mil Spec A-8576C Type III. Refrigeration Recommended.
1802	Thin bodied, moderately fast set. For bonding acrylics, styrene, PVC, ABS and butyrate to themselves or each other.
3061° 	Thinner for Weld-On 40A (Acrylic Monomer).

VINYL, PVC, CPVC SUBSTRATES

66° 	Thin syrup, fast curing, high strength. Instant contact strength. For flexible vinyl, urethane, canvas, etc. Long working time.
1001	Thin syrup, slow set, rigid bond. For rigid or flexible vinyl to aluminum, glass, etc.
1829	Medium bodied for many plastics and non-plastic materials, e.g., vinyls, acrylics, urethane, foam, polyester, metal, etc.
1910	Medium bodied, slow set, solvent cement. For foamed, rigid and flexible PVC to themselves. Not for joining dissimilar materials.
2007° 	Water-thin, very fast set solvent cement. For foamed, rigid and flexible PVC to themselves and each other. Not for joining dissimilar materials.
4007	Medium bodied syrup, very fast set, rigid bond. For rigid vinyl.
4052° 	Medium syrup, fast set solvent cement. Multi-purpose for PVC, CPVC, ABS, styrene, nylon, foamed PVC, etc.
4784	Thin Syrup, fast set, flexible bond. For flexible or rigid vinyl to itself or other materials such as fabrics, acrylics, butyrate and polyurethane. Weather resistant.

POLYCARBONATE SUBSTRATES

55° 50 ml cartridge VOC Free	Two-component 1:1, reactive urethane based adhesive for bonding polycarbonate, butyrate, ABS and PETG. Excellent UV light resistance. Does not alter the impact resistance of polycarbonate.
58° 50 ml cartridge VOC Free	Two-component 1:1, reactive urethane based adhesive for bonding polycarbonate, butyrate, ABS and PETG. Excellent UV light resistance. Does not alter the impact resistance of polycarbonate.

STRUCTURAL ADHESIVES

10°
Kit



Two-component 10:1, structural adhesive. High viscosity. Bonds PVC, acrylics, styrene, ABS, polycarbonates, etc. Same physical properties as Weld-On 11.

11°
470 ml
Cartridge



Two-component 10:1, high strength, acrylic based adhesive packaged in a two-component cartridge for use with a mixing tip and dispensing gun. Same physical properties as Weld-On 10.

30
490 ml
Cartridge

NEW!

Two-component 10:1, fast speed adhesive. Bonds a wide variety of substrates including metals, thermoplastic and thermoset composites. Especially suited for sign & display assemblies. Bonds dissimilar materials.



UL 746C Approved

31
490 ml
Cartridge

NEW!

Two-component 10:1, medium speed adhesive. Bonds a wide variety of substrates including metals, thermoplastic and thermoset composites. Especially suited for sign & display assemblies. Bonds dissimilar materials.



UL 746C Approved

32
490 ml
Cartridge

NEW!

Two-component 10:1, slow speed adhesive. Bonds a wide variety of substrates including metals, thermoplastic and thermoset composites. Especially suited for sign & display assemblies. Bonds dissimilar materials.



UL 746C Approved

45°
43 & 400 ml
Cartridge



Two-component 4:1 high strength methacrylate structural adhesive. Bonds unprepared and corrosion resistant metals, composites and plastics.



UL 746C Approved

STYRENE

4807

Medium syrup, fast set. For bonding styrene to itself.

ABS SUBSTRATES

1707

Medium syrup, fast set. Dries milky translucent. For cementing ABS ONLY!

2354

Water-thin, fast set solvent cement. For bonding ABS and styrene to themselves. Not for joining dissimilar materials.

4707°



Heavy syrup, fast set, dries milky translucent. For cementing ABS ONLY! (Low VOC version of 1707).

CLEANER

57
Cleaner

Non-abrasive cleaner for acrylic and most other plastics.

ACCESSORIES



50 ml APPLICATOR GUN

13585 — Manual



400 ml APPLICATOR GUN

12613 — Low-Resistance Manual



400 ml APPLICATOR GUN

13302 — Manual



11715



11713



11714



11718

MICRO TIPS



470 ml / 490 ml APPLICATOR GUN

11652 — Low-Resistance Manual



470 ml / 490 ml APPLICATOR GUN

150434 — Manual

	WELD-ON® NUMBER	COLOR	NUMBER OF COMPONENTS	WORKING TIME	FIXTURE TIME	ULTIMATE BOND STRENGTH	MINIMUM EXPECTED SHELF LIFE @73°F (yr)	TYPICAL SPECIFIC GRAVITY (g/cc)	TYPICAL VISCOSITY (cps)	VISCOSITY REFERENCE
ACRYLICS	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	72 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
VINYL PVC, CPVC	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
ABS	1707	milky	1	10 min	15-20 min	72 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	72 hrs	3	0.884	4,000	syrup
POLYCARBONATE	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	3,000	syrup
STYRENE	4807	milky	1	10-15 min	20 min	72 hrs	3	0.880	600	motor oil
STRUCTURAL	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
CLEANER	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 02/20

ABS	Acrylic Cell Cast	Acrylic Cross-Linked	Acrylic Extruded	Butyrate	Fiberglass	Metal	PETG	Polycarbonate	Polyester	Polyurethane	PVC (Rigid)	PVC (Flexible)	PVC (Foamed)	Styrene	
55/58/2354 1707/4707 30/31/32	16/40/42 1802 30/31/32	10/11 40/42	16/40/42 1802 30/31/32	16/55/58 45/40/42 30/31/32	10/11 45 30/31/32	45 11 30/31/32	16/55/58 40/42 30/31/32	16/55/58 40/42 30/31/32	40/42 10/11 30/31/32	66 4784 55/58	10/11/45 16/4052 30/31/32	45 30/31/32	16 40/42 45	16 1802	ABS
16/1802 40/42 30/31/32	16/40/42 3/4/45C 30/31/32	10/11 40/42	16/40/42 3/4/45C 30/31/32	16 40/42/45 30/31/32	10/11 45 30/31/32	11 45 30/31/32	10/11/16 40/42 30/31/32	16 40/42/45 30/31/32	40/42 10/11 30/31/32	66 4784	16/40/42 4052 30/31/32	45 30/31/32	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 30/31/32	16/40/42 3/4/45C 30/31/32	10/11 40/42	16/40/42 3/4/45C 30/31/32	16 40/42/45 30/31/32	10/11 45 30/31/32	11 45 30/31/32	10/1116 40/42 30/31/32	10/11 40/42/45 30/31/32	40/42 10/11 30/31/32	66 4784	16/40/42 4052 30/31/32	45 30/31/32	16 40/42 45	16 4052 10/11	Acrylic Extruded
16/55/58 45/40/42 30/31/32	16 40/42/45 30/31/32	40/42 10/11 45	16 40/42/45 30/31/32	3/4/45C/16 2007/55/58 30/31/32	10/11 45 30/31/32	45 11 30/31/32	16/55/58 40/42 30/31/32	16 55/58 40/42	40/42/45 10/11 30/31/32	66 4784 55/58	16/55/58 40/42 30/31/32	66/4784 45 30/31/32	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 30/31/32	10/11 45 30/31/32	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 30/31/32	10/11 45	10/11 45	Fiberglass
11 45 30/31/32	11 45 30/31/32	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 45 30/31/32	11 45 30/31/32	11	11 45 30/31/32	45 30/31/32	11 45	11 45	Metal
16/55/58 40/42 30/31/32	10/11/16 40/42 30/31/32	10/11 40/42 45	10/11/16 40/42 30/31/32	16 55/58 40/42	10/11 45 30/31/32	11 45 30/31/32	40/42/55/58 3/4/45C 30/31/32	55/58 40/42/45 30/31/32	40/42 45 30/31/32	10/11	10/11 40/42 16	45 30/31/32	16 40/42 45	16 10/11	PETG
16/55/58 40/42 30/31/32	16 40/42/45 30/31/32	10/11 40/42 45	10/11 40/42/45 30/31/32	16/55/58 40/42 30/31/32	10/11 45 30/31/32	11 45 30/31/32	55/58 40/42/45 30/31/32	16/55/58 3/4/45C 30/31/32	40/42/45 10/11 30/31/32	10/11	40/42 10/11/16 30/31/32	45 30/31/32	16 40/42 45	10/11 16 1802	Polycarbonate
40/42 10/11 30/31/32	40/42 10/11 30/31/32	40/42 10/11	40/42 10/11 30/31/32	40/42/45 10/11 30/31/32	10/11 45 30/31/32	11 45 30/31/32	40/42 45 30/31/32	40/42/45 10/11 30/31/32	40/42/45 10/11 30/31/32	10/11 1829	40/42 10/11 30/31/32	45 30/31/32	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 45/4052 30/31/32	16/40/42 4052 30/31/32	10/11 40/42 45	16/40/42 4052 30/31/32	16/55/58 40/42 30/31/32	10/11 45 30/31/32	11 45 30/31/32	10/11/16 40/42 30/31/32	40/42 10/11/16 30/31/32	40/42 10/11 30/31/32	66 4784	2007/4007 10/11/40/42 30/31/32	2007 45 30/31/32	16 2007 40/42/45	10/11 16 1802	PVC (Rigid)
45 30/31/32	45 30/31/32	45	45 30/31/32	45/66 4784 30/31/32	45 30/31/32	45 30/31/32	45 30/31/32	45 30/31/32	45 30/31/32	66 4784 45	2007 45 30/31/32	2007/45 66/4784 30/31/32	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



PERFORMANCE • TRUST • VALUE • FLEXIBILITY • SCIENCE

That's the foundation that has made IPS® a world leader in dependable, advanced adhesives for more than a half century.

Whether it's transportation, marine, building and construction or product assembly, our mission at IPS is to provide the strongest, most trusted adhesive solutions with the flexibility to meet ever-changing assembly techniques.

With the vision and know-how to create scientifically advanced products that save time and energy, IPS delivers unsurpassed value and unmatched flexibility, changing the way people put things together.



Assembly Adhesives for Industrial & Commercial Applications.

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