



## 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.

### TENNESSEE **WELD-ON**

Customer Service/Technical Service  
500 Distribution Parkway  
Collierville, TN 38017

**Tel:** (901) 853-5001

**Fax:** (901) 853-5008

#### **Customer Service:**

(800) 888-8312

#### **Technical Service:**

(877) 477-8327 / (310) 898-3304

### IPS ADHESIVES

#### **Sales & Marketing**

600 Ellis Road  
Durham, NC 27703 USA

**Tel:** (919) 598-2400

**Fax:** (919) 598-2439

# WELD-ON<sup>®</sup>

## SIGN & DISPLAY

### 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  
*Where not for sale in California (SCAQMD), please use Weld-On #4SC.*

**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  
*Where not for sale in California (SCAQMD), please use Weld-On #4SC.*

**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<sup>o</sup> KIT** Hand mixed three-component, reactive, high strength acrylic based adhesive with excellent weatherability.

**40<sup>o</sup> KIT** Hand mixed two-component 20:1, reactive, high strength acrylic based adhesive provides "museum quality" water clear joints with excellent weatherability.  
**Refrigeration Recommended.**

**42<sup>o</sup> 50 ml Cartridge** Two-component 10:1, reactive, high strength acrylic based adhesive provides "museum quality" water clear joints with excellent weatherability.  
**Refrigeration Recommended.**

**42<sup>o</sup> 230 ml Cartridge** Two-component 10:1, reactive, high strength acrylic based adhesive provides "museum quality" water clear joints with excellent weatherability.  
**Refrigeration Recommended.**

**1802** Thin bodied, moderately fast set. For bonding acrylics, styrene, PVC, ABS and butyrate to themselves or each other.

**WELD-ON SIGN & DISPLAY IS A BRAND OF IPS ADHESIVES**

600 Ellis Road Durham, NC 27703

Tel:(919) 598-2400

Fax:(919) 598-2439

**VINYL, PVC, CPVC SUBSTRATES**

**1910** Medium bodied, slow set, solvent cement. For foamed, rigid and flexible PVC to themselves. Not for joining dissimilar materials.

**2007<sup>o</sup>** Water-thin, very fast set solvent cement. For foamed, rigid and flexible PVC to themselves and each other. Not for joining dissimilar materials.

**4052<sup>o</sup>** 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<sup>o</sup> 50 ml cartridge** 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.  
**VOC Free**

**58<sup>o</sup> 50 ml cartridge** 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.  
**VOC Free**

**ABS SUBSTRATES**

**2354** Water-thin, fast set solvent cement. For bonding ABS and styrene to themselves. Not for joining dissimilar materials.

**4707<sup>o</sup>** Heavy syrup, fast set, dries milky translucent. For cementing ABS ONLY! (Low VOC version of 1707).

**WELD-ON SIGN & DISPLAY CASE STUDY**

**46C'S TRANSLUCENT CURE A CLEAR HIT FOR AGI IN TEXAS**

**READ MORE @ ASSEMBLYADHESIVES.COM**

• These products meet requirements of California South Coast Air Quality Management District (SCAQMD) Rule 1168.

**STRUCTURAL ADHESIVES**

**30**  
50 & 490 ml Cartridges  
LOW VOC

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.

**RU**  
UL 746C Approved

**31**  
490 ml Cartridge

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.

**RU**  
UL 746C Approved

**45**  
43 & 400 ml Cartridges  
LOW VOC

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

**RU**  
UL 746C Approved

**46C**  
50 & 490 ml Cartridges

Two-component 10:1, high bond structural adhesive formulated for bonding a wide variety of substrates including metals, thermoplastic and thermoset composites. Especially suited for sign and display assemblies. Translucent cure.

**RU**  
UL 746C Approved

**400LSE**  
50 & 490 ml Cartridges

Two-component 10:1, high bond structural adhesive formulated for bonding low surface energy plastics and dissimilar substrates. Especially suited for sign and display and structural assemblies

**RU**  
UL 746C Approved

**“GAME CHANGER”**

**SG400: Bond Low Surface Energy Plastics with No Surface Prep Required**

SCIGRIP's revolutionary new SG400LSE adhesive is formulated to cross-bond multi-material assemblies such as LSE plastics like polypropylene (PP) and polyethylene to metal, composites and other plastics without the need for costly, time consuming surface preparation.

Ask your rep about SG400 today.



**ACCESSORIES**



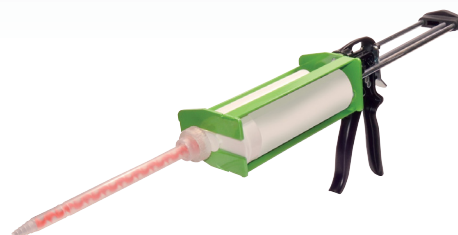
**50 ml APPLICATOR GUN**  
13585 — Manual



**50 ml 10:1 APPLICATOR GUN**  
13584 — Manual **93.60**  
Use with Weld-On 30, 42, 46C & 400LSE



**NEW**  
**SSF 52X 490 ml APPLICATOR GUN**  
185196 — Manual



**400 ml 4:1 APPLICATOR GUN**  
13302 — Manual **165.12**  
Use with Weld-On 45

• These products meet requirements of California South Coast Air Quality Management District (SCAQMD) Rule 1168.

	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
<b>ACRYLICS</b>	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	72 hrs	1*	1.0354	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
<b>VINYLS PVC, CPVC</b>	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
	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
<b>ABS</b>	2354	clear	1	3 min	15 min	72 hrs	3	0.805	–	water thin
	4707●	milky	1	10 min	10-15 min	72 hrs	3	0.884	4,000	syrup
<b>POLYCARBONATE</b>	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
<b>STRUCTURAL</b>	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
	45●	tan	2	5-6 min	15 min	24 hrs	1	1.064	500,000	peanut butter
	46C●	translucent	2	6-9 min	15-25 min	24 hrs	.75	0.99	100,000	toothpaste

★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.

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 4707 30/31/46C	16/40/42 1802 30/31	40/42	16/40/42 1802 30/31	16/55/58 45/40/42 30/31	45 30/31	45 30/31	16/55/58 40/42 30/31	16/55/58 40/42 30/31	40/42 30/31	4784 55/58	45 16/4052 30/31	45 30/31	16 40/42 45	16 1802	ABS
16/1802 40/42 30/31	16/40/42 3/4/45C 30/31/46C	40/42	16/40/42 3/4/45C 30/31/46C	16 40/42/45 30/31	45 30/31	45 30/31 46C	16 40/42 30/31	16/30/31 40/42/45 46C	40/42 30/31	4784	16/40/42 4052 30/31	45 30/31	16 40/42 45	16 4052	Acrylic Cell Cast
40/42	40/42	40/42	40/42	40/42 45	45	45	40/42 45	40/42 45	40/42	40/42	40/42 45	45	40/42 45	40/42	Acrylic Cross-Linked
16/1802 40/42 30/31	16/40/42 3/4/45C 30/31/46C	40/42	16/40/42 3/4/45C 30/31/46C	16 40/42/45 30/31	45 30/31	30/31 45 46C	16 40/42 30/31	40/42/45 30/31 46C	40/42 30/31	4784	16/40/42 4052 30/31	45 30/31	16 40/42 45	16 4052	Acrylic Extruded
16/55/58 45/40/42 30/31	16 40/42/45 30/31	40/42 45	16 40/42/45 30/31	3/4/45C/16 2007/55/58 30/31	45 30/31	30/31 45	16/55/58 40/42 30/31	16 55/58 40/42	40/42/45 30/31	4784 55/58	16/55/58 40/42 30/31	4784 45 30/31	40/42 45	1802 16 45	Butyrate
45 30/31	45 30/31	45	45 30/31	45 30/31	45 30/31	30/31 45 46C	45 30/31	45 30/31	45 30/31	45	45 30/31	45 30/31	45	45	Fiberglass
45 30/31	30/31 45 46C	45	30/31 45 46C	45 30/31	45 30/31	30/31 45 46C	30/31 45	45 30/31	45 30/31	45	45 30/31	45 30/31	45	45	Metal
16/55/58 40/42 30/31	16 40/42 30/31	40/42 45	16 40/42 30/31	16 55/58 40/42	45 30/31	45 30/31	40/42/55/58 3/4/45C 30/31	55/58 40/42/45 30/31	40/42 45 30/31	40/42	40/42 16	45 30/31	16 40/42 45	16	PETG
16/55/58 40/42 30/31	16/30/31 40/42/45 46C	40/42 45	30/31 40/42/45 46C	16/55/58 40/42 30/31	45 30/31	45 30/31	55/58 40/42/45 30/31	16/55/58 3/4/45C 30/31/46C	40/42/45 30/31	40/42	40/42 16 30/31	45 30/31	16 40/42 45	16 1802	Polycarbonate
40/42 30/31	40/42 30/31	40/42	40/42 30/31	40/42/45 30/31	45 30/31	45 30/31	40/42 45 30/31	40/42/45 30/31	40/42/45 30/31	40/42	40/42 30/31	45 30/31	40/42 45	40/42	Polyester
4784 55/58	4784	40/42	4784	4784 55/58	45					4784 55/58	4784	4784 45	4784	45	Polyurethane
16 45/4052 30/31	16/40/42 4052 30/31	40/42 45	16/40/42 4052 30/31	16/55/58 40/42 30/31	45 30/31	45 30/31	16 40/42 30/31	40/42 16 30/31	40/42 30/31	4784	30/31 40/42/46C 2007	2007 45 30/31	16 2007 40/42/45	16 1802	PVC (Rigid)
45 30/31	45 30/31	45	45 30/31	45/ 4784 30/31	45 30/31	45 30/31	45 30/31	45 30/31	45 30/31	4784 45	2007 45 30/31	2007/45 4784 30/31	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	45	45	16 40/42 45	16 40/42 45	40/42 45	4784	16 2007 40/42/45	2007 45	2007 16 40/42/45	1802 16 45	PVC (Foamed)
16 1802	16 4052	40/42	16 4052	1802 16 45	45	45	16	16 1802	40/42	45	16 1802	2007 45	1802 16 45	16 1802	Styrene