

**SUBSTRATE RECOMMENDATIONS:**

WELD-ON® 66™ is formulated for bonding flexible or rigid vinyl (PVC) to itself or to urethane, leather, canvas, ABS, foamed PVC, butyrate and wood.

**SUGGESTED BONDING APPLICATIONS AND RECOMMENDATIONS:**

WELD-ON 66 is recommended for fabricating or repairing flexible vinyl in numerous applications: pond liners, shower pans, pool liners, moisture barriers, waterbeds, upholstery and wearing apparel. WELD-ON 66 also bonds urethane, leather and canvas to themselves and to wood, cardboard, Kydex®, cellulose acetate butyrate and ABS.

**GENERAL DESCRIPTION:**

WELD-ON 66 is a clear, light bodied, fast drying solvent cement. It is used as a contact cement, providing instant, high strength which will increase as solvent dissipates. The longer the open time (5 to 10 min) and with sufficient assembly pressure, the greater the immediate strength will be. WELD-ON 66 may also be used on surfaces that are wet to wet or wet to dry; but its special advantage is its high initial strength on contact. Whatever the bonding technique used, it will provide high strength, long lasting, water resistant bonds under normal use, but some yellowing may be expected.

**ADHESIVE PROPERTIES AND CHARACTERISTICS:**

COLOR:	Clear
VISCOSITY:	Water Thin
WORKING TIME:	2 – 20 minutes
FIXTURE TIME:	45 - 60 minutes
TIME TO REACH 80% OF ULTIMATE BOND STRENGTH:	2 hours
SPECIFIC GRAVITY:	0.85 ± 0.04

**DIRECTIONS FOR USE:**

- Clean and dry surfaces to be joined.
- Coat each mating surface. Use a dauber or brush to apply an even coating with sufficient thickness for good contact.
- Let each coating dry from 2 to 5 minutes.
- Press firmly together. The longer the drying time, the greater the pressure required to effect a bond and the higher the immediate strength will be.
- **For optimum strength on contact:** After coating each mating surface, wait 10-15 minutes. Assemble parts with strong pressure, e.g., a pinch roller or other line pressure over a hard surface. Even pliers have been used successfully.
- **Long working time:** Apply slightly thicker coatings to each substrate. Coatings may dry for 15 minutes or more. As noted above, extra pressure will be needed to fuse the two surfaces together.
- **Light pressure assembly:** Where it is not practical to apply strong pressure for contact fusion, apply a normal coating to each mating surface. Wait 1 to 2 minutes and apply as much pressure as possible.
- **Bonding thin PVC (less than 15 mm):** Apply a very thin coat rapidly, use a brush to attain a thin coating, or apply a normal coating, then thin it down by scrapping an edge of a card over it, removing the excess content. Let dry for at least 2 minutes and then assemble with strong pressure.
- **Bonding to porous surfaces:** Apply at least 2 coats where strike-in or soak-in appears to starve the surface of porous materials---wood, foam, etc.

**AVAILABILITY:**

This product is available in pint (473 ml) and gallon (3.785 l) metal cans. For detailed information on containers and applicators, refer to the current Product Catalog and Price List.

**SHELF LIFE:**

3 years in tightly sealed containers. The date code of manufacture is stamped on the bottom of the container. Stability of the product is limited by the evaporation of the solvent when the container is opened. Evaporation of solvent will cause the cement to thicken and reduce its effectiveness. Adding of thinners to change viscosity is not recommended and may significantly change the properties of the cement.

**QUALITY ASSURANCE:**

WELD-ON 66 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:

### 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 a flammable, fast evaporating solvent cement. It is considered a hazardous material. In conformance with the Federal Hazardous Substance Labeling Act, the following hazards and precautions are given. Purchasers who may re-package this product must also conform to all local, state, and federal labeling, safety and other regulations. VOC emissions do not exceed 600 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. Keep container closed when not in use. Store in the shade between 40° - 110°F (5° - 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 Sheets and follow all precautions. Contains Methyl Ethyl Ketone (78-93-3) and Tetrahydrofuran (109-99-9). 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 MSDS's 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.



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