



IPS®

WELD·ON

INSTALLATION INSTRUCTIONS

810 A&B

2-PART HIGH STRENGTH REACTIVE ADHESIVE

GENERAL DESCRIPTION / PRODUCT USES:

Weld-On 810 A&B is a white, reduced VOC emission, thick syrupy, two-component, high strength reactive adhesive. It 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.

Note: For more detailed information on this product and its uses, refer to the 810 A&B Product Bulletin/Specification Sheet.

PREPARATION OF SUBSTRATES:

Bonding surfaces must be clean and dry. 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 for good adhesion. Chlorinated solvents, MEK, Acetone or even rubbing alcohol (Isopropyl) may be used for removing grease or dirt.

810 A&B (mix by hand) INSTALLATION INSTRUCTIONS:

1. Assemble materials for the job; 810 A&B; 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 with solvent cleaner. 3. With pre-measured 810 A&B kit, 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 a filler. 5. 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.

Miscellaneous Notes: Warmer weather will shorten pot life and cure time. Colder weather will increase time for both. When joining CPVC for service temperatures over 150°F (65°C), please contact IPS Corporation for more information.

REPAIRS USING 810 A&B :

Replacing a failed joint with new material and taking greater care in the joining process is always preferred. If the joint cannot be cut out, the following repair has proven to be successful in most applications. **This repair is for leaks only, not cases where pipe has separated from the fitting:**

1. Have materials ready; sufficient quantity of Weld-On 810 A&B; a clean stick for mixing; a spatula or stiff brush for applying Weld-On 810 A&B; fiberglass cloth mat cut to desirable size or strip for wrapping; sandpaper or emery; clean dry rags; gloves for protection. 2. Turn off water pressure; dry off the area of bond and abrade it well with sandpaper and wipe clean. 3. Mix Weld-On 810 A&B as a pre-measured kit. Add smaller container of "B" to larger container of "A" and mix thoroughly. 4. Apply a generous coat of 810 A&B to leak and surrounding area. 5. Apply 810 A&B to mating surface of cloth and wrap around leak area. Some adhesive should squeeze up through cloth. **Note:** Good results are possible without using the fiberglass cloth, but fiberglass cloth is recommended for added structural strength. 6. Apply an additional coat of 810 A&B to the top surface. 7. Allow to cure a minimum of 4 hours at 70°F (21°C). Overnight or 24 hours cure is desirable before re-pressurizing the systems.