Characteristics



- FOR INDUSTRIAL AND PROFESSIONAL USE ONLY.
- NOT FOR CONSUMER USE.
- This product can expose you to Styrene, which is know to the State of California to cause cancer.

WELD-ON

Adhesive Weld-On #30 (Off-White Color)

- Weld-on 30 is specially suited for sign and display fabrication. Formulated for bonding a wide variety of substrates including metals, thermoplastic and thermoset composites.
- Fast speed two-component 10:1 structural adhesive, when mixed on ratio and applied; it cures at room temperature to form high strength bond within minutes.
- The adhesive has xcellent corrosion and chemical resistance, gap-filling capabilities, in addition to xcellent impact and fatigue resistance.
- UL 746C Approval for use in electrical equipment assemblies for indoor and outdoor signage applications
- Working Time: 5-6 Minutes / Fixture Time: 10 Minutes / Store between 55ºF-75ºF (Do not Freeze)

Physical

(Typical Bond Strength)

Tensile Lap Shear Strength after 24-hour cure			
Substrate	**Strength pls (Mpa)**	**Substrate**	**Strength pls (Mpa)**
Aluminum	2,400 (16.5)	Woven FRP (Vynil Ester)	1,750 (12.0)
Cold Roll Steel	2,550 (17.6)	Woven FRP (Epoxy)	1,430 (9.9)
Stainless Steel	2,150 (14.8)	Woven FRP (Polyester)	1,400 (9.7)
Epoxy Coated Steel	2,330 (15.9)	Carbon Fiber (Epoxy)	2,800 (19.3)
ABS	800 (5.5)	Polycarbonate	1,270 (8.8)
PVC	1,150 (7.9)	PMMA (Acrylic)	750 (5.1)

Directions for Use

- The cartridge must be insert in the dispensing gun and mixting tip attached prior to dispensing.
- Before inserting the cartridge in the dispesing gun, open nose plug and clean obstructions
- Insert cartridge into dispesing gun. Dispense a small amount of adhesive making sure that both components freely flow out of the cartridge cylinders.
- Attach the mixting tip to the cartridge. Press the dispensing gun to dispense and discard aproximately 1-2 inches of the product, ensuring that the product is mixed properly in the mixting tip before use.
- ** If the mixing tip is left on the cartridge for a sufficient length of time without additional use, the adhesive may cure in the tip. If this happens, keep the mixing tip on the cartridge. When you are ready to dispense more adhesive, replace the mixing tip on the cartridge with a new one. Be sure to discard 1 – 2 inches of the product before use.

Product Storage and Stability

- Self life is based on steady state storage between 55ºF and 80ºF (13ºC and 27ºC).
- Exposure, intermittent or prolonged, above 80ºF (27ºC) will result in a reduction of the stated self life
- Exposures above 100ºF (38ºC) during shipping or storage can quickly degrade component B in cartridges or bulk containers, and must be prevented.
- Self life of both components can be extended by air-conditioned or refrigerated storage between 55ºF and 65ºF (13ºC and 18ºC). Keep from freezing.

Safesty and Environmental Precautions

This product is a flammable, reactive adhesive. 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.

- Keep out of the reach of children. Do not take internally.
- Keep away from heat, spark, open flame and other sources of ignition
- Contact with hot surfaces may produce toxic effects.
- Keep container closed when not in use. Store away from direct sunlight between 55º-80º F.
- Use only in adequate ventilation.
- Avoid breathing of vapors.
- Atmospheric levels should be maintained below established exposure limit values.
- If airborne concentrations exceed these limits, use a supplied air respirator.
- Do not use a chemical cartridge respirator.
- For emergencies and other conditions where short-term exposure may be exceeded, use an approved positive pressure self-contained breathing apparatus.
- In confined areas, use a positive pressure self-contained breathing apparatus (SCBA).
- 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 Safety Data Sheet and follow all precautions.
- Component A contains Methyl Methacrylate Monomer. Component B contains Catalyst-initiator and Benzoyl Peroxide. Do not use this product for other than intended uses.

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.