



IPS®

WELD-ON

WELD-ON 4707

ACRYLONITRILE-BUTADIENE-STYRENE (ABS)

SUBSTRATE RECOMMENDATIONS

WELD-ON 4707 is formulated to form high strength bonds in joining ABS material to itself only.

BONDING RECOMMENDATIONS

WELD-ON 4707 is recommended in general usage for ABS where a bodied cement is desired. It is suitable for a wide variety of applications. It may be used on both large and small assemblies, large displays, signs, lighting fixtures, housewares, large and small containers, toys, electrical or electronic assemblies, decorator items, etc.

GENERAL DESCRIPTION

WELD-ON 4707 is a milky, syrupy, bodied, fast drying solvent cement. The bonds formed are high strength, rigid and generally free from crazing. Chemical, physical, and electrical properties are similar to those of ABS materials. Cure is affected by dissipation of the solvent from the cement and surrounding parts softened by it. Initial bond will usually take place within minutes and may be of sufficient strength for handling. Bond strength will be considerable in a few hours and will reach high strength in 24 to 72 hours. Thereafter, strength will continue to increase gradually for some weeks.

SUBSTRATE MATERIAL	<u>2 Hours</u>	<u>24 Hours</u>	<u>1 Week</u>
ABS	400 PSI	1000 PSI	1100 PSI

ADHESIVE PROPERTIES AND CHARACTERISTICS

COLOR:	Milky		
VISCOSITY:	2,900 cps		
WORKING TIME:	10 minutes		
FIXTURE TIME:	10-15 minutes		
80% STRENGTH:	24 hours		
SPECIFIC GRAVITY:	.870 ± .040		
COVERAGE:	10mil: 25 sq. ft/Pint	200sq. ft/Gallon	
	20mil: 12 sq. ft/Pint	100sq. ft/Gallon	

DIRECTIONS FOR USE

- ∞ JOINT PREPARATION: Parts to be joined should fit without forcing. Surfaces should be clean and smooth. A good machine finish or sanding with 200-400 grit sandpaper should be satisfactory. Surfaces "as molded or extruded" should not require additional preparation.
- ∞ APPLICATION OF CEMENT: Weld-On 4707 can be applied by brush, spray, roller coating, pump-type oil cans, polyethylene squeeze bottles and other devices. Cement may be applied to one or both surfaces.
- ∞ ASSEMBLY OF PARTS: Assemble while parts are still wet. If cement is applied to one surface, let the two surfaces be in gentle contact for a few seconds to allow the cement to soften the dry surface. Then press parts together in firm contact. If both of the parts have been coated, they may be brought firmly together immediately. The application of pressure of 2 to 10 lbs per square inch should materially increase bond strength. Spring-loaded clothespins may be very suitable as clamps. The length of time required for clamp or jig pressure will vary. A few hours or more may be needed for difficult joints, but only a few minutes for parts that fit well and have modest load requirements.

SHELF LIFE

Three years expectancy in tightly sealed containers. Stability of the products is limited by the permanence of the container and the evaporation of the solvent when container is open. Evaporation of solvent will cause the cement to thicken and reduce its effectiveness.

SHIPPING

Shipping Information for Individual Container Larger than One Liter: DOT Shipping Name: Adhesive. DOT Hazard Class: 3. ID #: UN1133. Packaging Group: II. Label: Flammable Liquid.

Shipping Information for Less than One Liter: DOT Shipping Name: Consumer Commodity. DOT Shipping 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 Substances 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.

CAUTION! – 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°F and 80°F. 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). 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 ill effects from inhalation, remove to fresh air. If not breathing, give artificial respiration. If breathing is difficult, give oxygen. Call physician.

Eye or Skin Contact: Flush with plenty of water for 15 minutes. If irritation persists, get medical attention.

Ingestion: If swallowed, do not induce vomiting. Contact physician immediately.

QUALITY ASSURANCE

Every batch of this cement is checked to assure that consistent quality is maintained. An infrared absorption curve is recorded for each batch to ensure that this cement is properly formulated. Samples are taken from all batches and kept for a period of at least one year. A batch identification code is stamped on each can.

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, are suited to their application. Since specific use, materials and handling are not controlled by IPS, our warranty is limited to the replacement of defective IPS products.

