



WELD-ON 4007

WELD-ON

**HIGH STRENGTH CEMENT
RIGID AND FOAMED VINYL (PVC)**

SUBSTRATE RECOMMENDATIONS

WELD-ON 4007 is specifically formulated for solvent cementing rigid Polyvinyl Chloride (PVC), and foamed PVC to themselves and each other.

BONDING RECOMMENDATIONS

WELD-ON 4007 is recommended for vinyl where a light 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, house-wares, large and small containers, toys, electrical or electronic assemblies, decorator items, etc.

GENERAL DESCRIPTION

WELD-ON 4007 is a clear, light bodied, syrupy, free flowing, very fast curing, high strength, solvent cement. Initial bond forms very quickly so that some parts may be handled within a few minutes of application. Bond strength continues to develop very rapidly reaching a substantial level within hours. Joints are weather resistant and will generally have physical and chemical properties similar to those of rigid vinyl.

SUBSTRATE MATERIAL	<u>2 Hours</u>	<u>24 Hours</u>	<u>1 Week</u>
PVC	260 PSI	500 PSI	900 PSI
ABS	200	650	1050

ADHESIVE PROPERTIES AND CHARACTERISTICS

COLOR:	Clear		
VISCOSITY:	850 cps		
WORKING TIME:	20 minutes		
FIXTURE TIME:	25 minutes		
80% STRENGTH:	72 hours		
SPECIFIC GRAVITY:	.980 ± .040		
COVERAGE:	10mil:	35 sq. ft./Pint	280sq. ft./Gallon
	20mil:	17 sq. ft./Pint	140sq. 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. Some molded and extruded parts may have a very hard and glossy surface which may require special priming to prepare the surface prior to cementing. In these cases, contact us for further information.
- ∞ **APPLICATION OF CEMENT:** WELD-ON 4007 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 product 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 Gallon and Above: DOT Shipping Name: Adhesive. ID #: UN1133. Packaging Group: II. Label: Flammable Liquid DOT Hazard Class: Flammable Liquid.

Shipping Information for Less than One Gallon: DOT Shipping Name: Consumer Commodity. DOT Hazard Class: ORM-D.

SAFETY AND ENVIRONMENTAL PRECAUTIONS

This product is a flammable 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.

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°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 Tetrahydrofuran (109-99-9), Methyl Ethyl Ketone (78-93-3) and Cyclohexanone (108-94-1). 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.

Curbell Plastics is a proud supplier
of IPS® Weld-On materials

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