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# Plastic Welder Technical Data Sheet

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**PRODUCT DESCRIPTION:** A strong structural adhesive formulated for bonding dissimilar substrates as well as unprepared metals, ceramics, wood, concrete and hard plastics. The final adhesive bond is designed to be load bearing and resistant to weathering, humidity and wide temperature variations. Minimal surface preparation. Non-sagging formula.

**WORKS BEST ON:** Hard plastics, metal, concrete, glass, ceramics, china, acrylics, ABS, vinyl, PVC, fiberglass, glass, wood, styrene, corian. **DO NOT USE ON AREAS THAT WILL COME IN CONTACT WITH FOOD RELATED ITEMS.**

\* Does not bond to Polyethylene or Polypropylene plastics. Not recommend for use on copper or brass.

## PRODUCT FEATURES:

Tensile Strength: 3,500 psi  
Color: Cream  
Viscosity: Adhesive: 55,000 cps; Activator: 50,000 cps  
Waterproof  
Gap Filling to 0.125 in.  
Working Time: 4-5 minutes  
Set Time: 10-15 minutes  
Can be Handled In: 15 minutes  
Full Bond: 24 hours  
Temperature Range: -40°F to 200°F  
Chemical Solvent Resistance: Good chemical resistance.  
Flashpoint: 51°F

Once fully cured, can be sanded and painted **but not with an oil based paint.**

Storage: After use, pull back slightly (1/8" on plunger). Replace cap. **Store in a cool, dry environment between 55°F to 75°F. DO NOT FREEZE. Storage above 75°F will reduce the shelf life. Shelf life can be extended by storing in temperatures 45°F to 55°F.**

**SURFACE PREPARATION:** Slightly roughen, solvent-wipe to remove dirt, grease and oil; and let area dry.

## REMOVAL METHODS:

Before cure: (test inconspicuous area of product to be sure chemicals do not harm surface)

Metal, ceramic, glass, hard plastics, pvc: use acetone, isopropyl alcohol or Methyl Ethyl Ketone (MEK).

Fabric or wood: use acetone or Methyl Ethyl Ketone (MEK).

After cure:

Metal/Ceramics/Glass: Acetone, Methyl Ethyl Ketone (MEK), may need to soak, checking periodically.

Fabric/Wood: It is impossible to remove once product is cured.

**HELPFUL HINTS:** Do not thin or modify. Plastic Welder sets up so quickly that thinner will not have enough time to evaporate and will become trapped inside compromising the cured product. Mass mixing of Plastic Welder generates intense heat levels due to its rapid curing features (film thickness cures in excess of 1/8" should be avoided whenever possible) which can cause the release of volatile components as evidenced by out-gassing. Once fully cured, the Plastic Welder can be sanded and painted (do not use with stains as they will not penetrate into the adhesive.)

Heat is generated while the epoxy mixture cures; the more epoxy and hardener that is mixed together, the more heat that is generated causing the epoxy mixture to cure faster. Only mix the amount of epoxy and hardener together that can be used within the working time.

Equal portions of the hardener and resin must be thoroughly mixed together in order for this product to cure properly. The most common problem with a two-part epoxy product is not mixing it thoroughly; it will not cure and will remain tacky. It is recommended that these epoxies be mixed on a clean surface (such as a paper cup, in the inside of the blister it is packaged on or etc.); do not mix it directly on the surface to be repaired. Once the product is thoroughly mixed, it can be applied to the repair area(s). *Please note, during the mixing process, be sure to scrape the sides and bottom into the mixture so that you are mixing all of the epoxy resin and hardener together.*

**See MSDS for more complete information, safe handling instructions and first aid.**

Consumer Commodity ORM-D

Part Numbers: 22045, 47809, 47829



The technical data contained herein are intended as a reference only.