



810™ 2-PART REACTIVE ADHESIVE

Weld-On® 810™ is a white, low VOC, thick syrupy, two-component, high-strength reactive adhesive. It has a fast cure time, withstands very high pressures and is high impact resistant. Specially formulated for bonding large diameter PVC and CPVC pipe and fittings. It also bonds ABS, styrene, acrylic, FRP (fiberglass reinforced polyester), concrete, clay and other materials to themselves or to dissimilar materials. It is ideal for repairing cracks or leaking valves and pipe fittings.

- Excellent gap filling property.
- Ideal for fabricating fittings and joining saddles to pipe.
- It provides excellent adhesion in peel, tensile or shear applications.
- For joints subjected to chemical exposure, prior evaluation must be made of the specific chemical concentration, temperature and pressure involved and the compatibility with WELD-ON 810.
- Not recommended for use on Neoprene, Delrin, PTFE, Silicone, Polypropylene, Polyethylene and other Polyolefins or joints with an interference fit.

PRODUCT SPECIFICATIONS

Use of adhesives	For bonding large diameter PVC and CPVC pipe and fittings. Also bonds ABS, Styrene, Acrylic, FRP (fiberglass reinforced polyester), concrete, clay and other materials themselves or dissimilar materials.
Color	White
Resin	Acrylic
Approximate coverage	14 square feet per pint 115 square feet per gallon *Based on laboratory evaluation @ 20 mil thickness. This data is for reference only. Actual coverage may vary.
Performance Specifications	SCAQMD Rule 1168/316A
Brookfield viscosity	Minimum 30,000 cps @ 73° ± 3.6°F
Specific gravity	1.03 ± 0.04
VOC emissions	< 50 g/L
Shelf Life	1 Year
LEED Compliant	Credit can be earned for LEED® (Leadership in Energy and Environmental Design), IEQ Credit 4.1

INSTRUCTIONS FOR USE

SUBSTRATES PREPARATION

Bonding surfaces must be clean and dry. If the surfaces are hard and glossy, abrading (sanding) and priming with a degreasing solvent is recommended. Chlorinated solvents, methyl ethyl ketone, acetone and/or rubbing isopropyl alcohol may be used to remove grease and/or dirt.

INSTALLATION

1. Assemble materials for the job: WELD-ON 810 kit, 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 surfaces with solvent cleaner.
3. WELD-ON 810 kit has a mixing ratio of 100:13 and both components are packaged and pre-measured to this ratio. Add Component B (small container) to Component 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 filler.
5. Allow the joined surfaces to cure undisturbed. 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.
Note: Warmer weather will shorten pot life and cure time. Colder weather will increase the time for both. Applying heat may speed up the cure time. When joining CPVC for service temperatures over 150 °F (65 °C), please contact WELD-ON for more information.

REPAIR

Replacing a failed joint with new material and taking greater care in the joining process is always preferred. This repair is for leaks only and ideal for area where the joint cannot be cut out. Do not use this method if the pipe has separated from the fitting.

1. Assemble materials for the job: WELD-ON 810 kit, clean mixing sticks, applicators (spatula or stiff brush), fiberglass cloth mat cut to desirable size for wrapping the leaked pipe, sandpaper or emery, clean wiping cloth, and gloves.
2. Turn off water pressure. Dry off the bonding area and abrade it well with sandpaper and wipe clean.
3. Prepare WELD-ON 810 adhesive. Add Component B (small container) to Component A (large container) and mix thoroughly.
4. Apply a generous coat of adhesive mixture to leakage and surrounding area.
5. Apply the adhesive mixture to the mating surface of fiberglass cloth. Wrap cloth around the leaked pipe. Some adhesive should squeeze up through cloth. Note: Fiberglass cloth is recommended for added structural strength to the leaked pipe. Good bonding result is also achievable without using the cloth.
6. Apply an additional coat of WELD-ON 810 adhesive to the top surface.
7. Let cure for a minimum of 4 hours at 70 °F (21 °C). Overnight or 24-hour cure is desirable before re-pressurizing the systems.

 **WARNING:** Cancer -www.P65Warnings.ca.gov

SPECIAL PRECAUTION

This product is designed to be used by expert people at their own risk. Installers must verify for themselves that they can make satisfactory joints under different conditions. It is strongly recommended that the installer review this product datasheet, application video, and instructions on the label prior to installation.

Please refer to the current safety data sheet for additional information on safety precautions, first aid, storage, handling, transport and disposal.

Storage temperature: 50 °F (10 °C) and 80 °F (27 °C). Keep away from heat sources, sunlight and humidity.

Please refer to the website for full terms and conditions.