



# WELD-ON 4909

**HIGH STRENGTH CEMENT FOR RIGID VINYL (PVC) AND KYDEX**

## SUBSTRATE RECOMMENDATIONS

WELD-ON 4909 is formulated for solvent cementing flexible or rigid vinyl to itself, or a variety of other plastics, such as acrylics, ABS and porous materials such as leather, canvas, and fabrics.

## BONDING RECOMMENDATIONS

WELD-ON 4909 is recommended as a high strength cement being used by a number of companies for bonding flexible vinyl to itself, flexible to rigid vinyl, ABS and others to wood, leather, canvas and other porous materials. It is also being used to repair vinyl seats in buses, etc. and can be used to patch vinyl waterbeds.

## GENERAL DESCRIPTION

WELD-ON 4909 is a clear, medium bodied, high strength solvent cement. It cures rapidly with the dissipation of the solvent at room temperature resulting in a very strong, flexible, water resistant bond. The cure is affected by dissipation of 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. Indications are that service life for a number of years may be expected under normal use, but some yellowing may be expected.

## ADHESIVE PROPERTIES AND CHARACTERISTICS

COLOR:	Clear	
VISCOSITY:	700 cps	
WORKING TIME:	10 – 15 minutes	
FIXTURE TIME:	20 – 25 minutes	
80% STRENGTH:	72 hours	
SPECIFIC GRAVITY:	.970 ± .040	
COVERAGE:	10mil: 40 sq. ft/Pint	320sq. ft/Gallon
	20mil: 20 sq. ft/Pint	160sq. ft/Gallon

## DIRECTIONS FOR USE

- Clean surfaces to be joined.
- Coat each mating surface. WELD-ON 4909 can be applied with brush, syringe, gun, etc.
- Press parts together immediately and hold a few seconds until “grab” begins – or, for quicker initial set: coat each surface and wait 10 to 20 seconds, then press firmly together.
- If not possible to coat both surfaces, give generous coat to one and press gently to the other surface to wet it. Then apply bonding pressure.

## 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 Containers Individual 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. Purchases 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. Vapors may ignite explosively. Keep container closed when not in use. Store in the shade below 80°F. Avoid breathing of vapors. Use only in well ventilated area. If confined or partially enclosed, use forced ventilation. Atmospheric levels must 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, goggles and impervious apron should be used. Carefully read Material Safety Data Sheet and follow all precautions. Contains Tetrahydrofuran (109-99-9), Methyl Ethyl Ketone (78-93-3), Cyclohexanone (108-94-1) and PVC Resin (9002-86-2). 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.