



## 811™ 2-PART REACTIVE ADHESIVE

Weld-On® 811™ is a white, low VOC, thick syrupy, two-component, high-strength reactive adhesive. It is conveniently packaged in a dual cylinder cartridge (10:1 ratio) and can readily be applied onto bonding surfaces by attaching the cartridge to the dispensing gun and mixing tip. WELD-ON® 811™ has the same physical properties and capabilities as WELD-ON® 810™: fast cure time, withstand very high pressure and 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 great for repairing cracks or leaky pipe valves and fittings.

- Excellent gap-filling property.
- Ideal for fabricating fittings and joining saddles to pipe.
- Provides excellent adhesion in peel, tensile or sheer 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

**Adhesive usage** For bonding large diameter PVC and CPVC pipe and fittings. Also bonds ABS, styrene, acrylic, FRP (fiberglass-reinforced polyester), concrete, clay and other materials to themselves or to dissimilar materials.

**Color** White

**Resin** Acrylic

**Approximate coverage** 15 sq. ft. per pint  
\*Based on laboratory evaluation @ 20 mil thickness. This data is for reference only. Actual coverage may vary.

**Performance Specification** SCAQMD Rule 1168/316A

**Brookfield Viscosity** Minimum 40,000 cps @ 73° ± 3.6°F

**Specific Gravity** 1.03 ± 0.04

**VOC Emissions** < 50 g/L

**Shelf Life** 1.5 Years (unopened cartridge)

**LEED Compliant** Credit can be earned per LEED® (Leadership in Energy and Environmental Design), IEQ Credit 4.1

### DIRECTIONS 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.

### CARTRIDGE ASSEMBLY

1. Remove the plug from cartridge after removing the retaining nut.
2. Place cartridge into the dispensing gun channel. Press trigger until both plungers are snug against the bottom pistons. Continue to press trigger allowing both resin and catalyst components to reach the tip of cartridge nozzle. Ensure both components are flowing freely from the cartridge nozzle. Wipe off excess resin and catalyst.
3. Attach a mixing tip to cartridge and tighten the retaining nut. DO NOT OVER TIGHTEN. The mixing tip can be inserted by lining up the notch on the cartridge with the cutout on the mixing tip.

Note: To preserve unused adhesive in the cartridge, leave the mixing tip in place as it temporarily reseals the cartridge. The cartridge with the mixing tip can be removed from the dispensing gun. When you are ready to use the adhesive again:

- Remove the old mixing tip and thoroughly clean the area near the cartridge nozzle ensuring there is NO crossover of the two components. Remove any blockages that may have formed in the nozzle. DO NOT FORCE BLOCKAGES BACK INTO THE CARTRIDGE.
- Repeat cartridge assembly steps 2 and 3. Ensure there is no residual catalyzed material in the cartridge nozzle area.
- Always use a new mixing tip when the cartridge is not in use for prolonged duration. DISCARD THE FIRST 1 - 2 INCHES OF ADHESIVE AFTER THE NEW MIXING TIP IS INSERTED.

### INSTALLATION

Assemble materials for the job: WELD-ON 811 cartridge, dispensing gun, mixing tips, sandpaper, clean wiping cloth, cleaning solvent, safety glasses and gloves.

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.

Apply ample amount of WELD-ON 811 adhesive to the bonding surfaces. Pot life and working time is about 30 minutes at 70 °F (21 °C). Assemble parts and allow squeeze out to remain as filler.

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.

**⚠ 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.**