PRODUCT REFERENCE GUIDE

WELD-ON®
IPS CORPORATION
STRUCTURAL ADHESIVES

Series	Features, Benefits & Applications	Adhesive	Working Time[1] min.	Fixture Time[1] min.	Ratio A:B Volume Weight	Mixed Density gm/ml lb/gal	Viscosity (10^3 cps) A-Comp. B-Comp.	Tensile Strength[2] psi % Elongation	Shear Strength[3] psi
SS100	**Color Stabilized (White)** **UV Stabilized** Intermediate Shear Strength High Toughness • 490 ml Cartridge or Bulk • Composites, Plastics, Primed Metals	**SS115** **SS140**	12-18 35-45	>30 >80	10:1 5.68:1	1.02 8.45	A: 150-220 B: 90-130	2,800-3,200 >140	2,000-2,400
SS200	**General Purpose (Off White)[6]** **Maximum Toughness** High Shear Strength • 490 ml Cartridge or Bulk • Composites, Plastics, Primed Metals	**SS208** **SS214** **SS218**	8-12 17-22 35-45	>25 >35 >80	10:1 7.69:1	0.99 8.22	A: 170-220 B: 70-180	2,000-2,500 >200	2,400-2,800
SS230 HV	**Large Structures (Gray)[6]** **Gap Fill up to 1.5", Non Sag** Intermediate Shear Strength Maximum Toughness • Bulk, 5 and 50-gallons • Composites, Plastics, Primed Metals	**SS230 HV**	25-130	45-260[4]	10:1 8.4:1	0.99 8.25	A: 900-1300 B: 80-180	3,000-4,000 150-230	1,400-1,500[3] 1,850-2,200[5]
SS300	**Metal Bonder (Black)[6]** **Primerless Metal Bonding** Low Read Through High Shear Strength High Toughness • 490 ml Cartridge or Bulk • Composites, Plastics, Metals	**SS305** **SS315** **SS316** **SS340**	4-6 13-17 14-18 35-45	>15 >30 >25 >80	10:1 8.75:1	1.02 8.51	A: 180-250 B: 80-120	2,000-2,200 100-125	2,500-2,800
SS500	**High Strength Adhesive (Amber)** **Thermoplastics and Composites** Maximum Shear Strength Tough • 400 ml Cartridge or Bulk • Composites, Plastics, Primed Metals	**SS505** **SS515**	4-6 15-20	>15 >30	1:1 1.05:1	1.00 8.29	A: 40-70 B: 40-70	4,000-5,000 >50	3,500-4,000
SS600	**General Purpose (Black)[6]** **Ease of Manual Dispensing** High Shear Strength High Toughness • 490 ml Cartridge or Bulk • Composites, Plastics, Primed Metals	**SS605** **SS610** **SS620**	4-6 8-12 15-20	>15 >25 >35	10:1 8.44:1	0.99 8.24	A: 150-200 B: 80-120	2,600-3,000 >140	2,700-3,200
SS1100[p]	**General Purpose 1:1 (Black or Off White)** **Difficult to Bond Plastics & Galvanized** High Shear Strength High Toughness • 50 and 400 ml Cartridges or Bulk • Composites, Plastics, Primed Metals	**SS1105** **SS1115**	4-6 13-17	>15 >35	1:1 1.05:1	1.013 8.45	A: 70-100 B: 80-120	2,500-3,500 >100	2,500-3,000
SS1300[p]	**General Purpose Composite (Black)[6]** **Reduced Shrinkage & Read Through** High Shear Strength High Toughness • 490 ml Cartridge or Bulk • Composites, Plastics, Primed Metals	**SS1305** **SS1310**	4-6 13-17	>15 >30	10:1 8.75:1	1.02 8.50	A: 180-250 B: 80-120	1,700-2,200 100-170	2,500-3,000
SS1500[p]	**General Purpose 1:1 (Amber)** **Primerless Metal Bonding** Maximum Shear Strength High Toughness • 50 and 400 ml Cartridges or Bulk • Composites, Plastics, Metals	**SS1505** **SS1515** **SS1530** **SS1560**	4-6 12-16 25-35 50-70	>15 >30 >60 >140	1:1 1.08:1	0.98 8.17	A: 80-120 B: 100-140	2,500-3,100 >80	2,700-3,200

Notes:
1. Working/fixture times at 75°F unless noted. Fixture time is minimum recommended time in fixture.
2. All mechanical properties are based on post cure cycle, 1 hour @ 82°C.
3. ASTM D1002 - 6061 Aluminum treated with MP100 Metal Primer (no primer needed with SS300 and SS1500 series). Bond strength attainable on other materials is limited and controlled by the strength and stiffness of the substrate.
4. Single adhesive, selection of four activators. Please refer to the product data sheet for more specific information.
5. ASTM D5868 - typical single lap shear strength of FRP to FRP bond.
6. Cured adhesive colors are for products offered in cartridges. Several other colors are possible with products sold in bulk.
p. Preliminary data - New Product Series.

Visit our website at: www.ipscorp.com
Toll-free: 1-877-IPS-GLUE (1-877-477-4583)
FAX: (919)-598-2439
IPS Structural Adhesives, Inc.
600 Ellis Road, Durham, NC 27703

Ref-Guide 09/07