



Extreme 5395GB

High Strength Metal / Composite Adhesive

Product Description

EXTREME 5395GB is a solvent free, VOC Compliant, plural component, methacrylate-based, structural adhesive formulated to bond metals for use in severe environments. It will also bond engineered thermo- and thermosetting plastics, composites to metals or various substrate combinations. It has excellent adhesion to as-received metal surfaces including aluminum, stainless steel, galvanized steel, and plated steels. **EXTREME 5395GB** forms tough, high strength bonds usually with little to no surface preparation. For use on bond areas contaminated with water based cutting oils, cleaner-primer **EXTREME Metal Prep** is an alcohol based system highly recommended for optimum performance.

EXTREME 5395GB develops handling strength in as little as 12 minutes and a functional cure within 90 minutes. Ultimate strength exceeds 3500 psi of tensile shear strength on aluminum with remarkable impact and peel strengths. **EXTREME 5395GB** has outstanding durability and environmental resistance to many common industrial solvents, and environmental conditions such as fresh water immersion, or high humidity. This product has excellent low temperature performance.

Why Should You Select This Adhesive?

EXTREME Toughness And Durability
Excellent Adhesion To Metals
EXTREME Impact and Peel Strength
100% Solids Formulation For VOC Compliance
Rapid RT Cure Speed And Excellent Gap Cure
Bond line management with Glass Microspheres

Instructions For Use

Combine resin and activator in equal volumes and mix thoroughly. For convenience and accuracy use pre-measured cartridges with disposable static mixers or Meter-Mix equipment designed for use with MMA's. Open time is 10-12 minutes at room temperature. Handling strength is within approximately 20 minutes. Full cure is 8 hours.

Physical Properties - Adhesive and Activator

Typical Uncured or Mixed Properties (LIQUID)

Viscosity - 2.5RPM / 20 RPM	140,000cps/45,000 mixed
Density	8.05 lbs/Gal
Color	Natural Resin (light tan)
Flashpoint	51°F (COC method)
Toxicity	Moderate, see MSDS
Solvents	None
Mix Ratio	1:1
Fillers	Glass Microspheres
Clean Up Solvents	IPA, MEK, Acetone

Typical Cured Properties (SOLID)

Typical film thickness 0.030".

Shore D Hardness	65
Adhesive Testing on	Plastics, glass filled nylon, styrene, ABS, PVC
Thermal Service Range	-40°F to 225°F
Chemical Resistance	Excellent
Elongation	55%
Side Impact Resistance	>6.78 J/in sq - AL - No Failure
Peel Strength	>60 pli on steel ASTM
Lap Shear Strength	3800 psi – as rec'd aluminum
	Stock Break - PVC
	Stock Break - ABS

Shelf Life:

Shelf Life is at least 6 months when properly stored in an unopened original container in a cool, dark area at-least 55°F to 75°F

Contact an **EXTREME ADHESIVES**® Application Specialist for further recommendations on adhesive selection and application tips.

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