



PVC Window

GET IT TOGETHER™

Mull & Key Adhesives™

From EXTREME Adhesives, Inc.

Structural Adhesive Systems for Window Manufacturers

Fast, Medium & Slow Cure Speeds

Product Descriptions

EXTREME Adhesives, LLC is the industry leader in Structural Adhesives for PVC and Aluminum. These 100% solids, plural component, methyl methacrylate adhesives are available in three different cure speeds to fit your individual production requirements. All **EXTREME Window Systems Adhesives™** properties (except cure speed) are similar. Choose the cure speed that fits your production rate.

EXTREME Window Systems Adhesives™ demonstrate strengths up to 3,400 psi and work equally well on PVC, fiberglass, aluminum and many other substrates. They are stronger than the PVC or fiberglass they can bond.

EXTREME Window Systems Adhesives™ do not require special surface preparation and do not contain solvents. These adhesives are of a creamy non-sag consistency, and they won't foam, run, or drip.

Features and Benefits

- Permanent Unitizing Structural Adhesives
- Superior Adhesion to Plastics And Metals
- High Impact Resistance and Peel Strength
- UV Resistant and Paintable
- Thixotropic, Slump Resistant
- Cure Speeds Matched to Production Requirements
- Easy to Apply With a Creamy Consistency
- Fills Gaps from 1/8" (FC) up to 3/8" (SC)
- Meets 2009 EPA VOC & CARB requirements

EXTREME Window Systems Adhesives™ Specifications

Product Series	Work Time in Minutes	Handling Time in Minutes	Functional Strength In Minutes
Fast Cure	4 - 7	14 - 18	60 - 90
Medium Cure	10 - 12	22 - 27	60 - 90
Slow Cure	20 - 25	60 - 90	120 - 150

Shelf Life

Shelf Life is 12 months when properly stored in an unopened original container in a cool, dark area between 55°F to 75°F.

Contact an **EXTREME ADHESIVES® Applications Specialist** for further recommendations on adhesive selection. 800-888-GLUE

Typical Uncured Properties (LIQUID)

Applies to both adhesive and activator sides

Viscosity	150,000 cps Mixed - Creamy
Specific Gravity	1.01 (20/20C°)
Mixed Color	White
Flashpoint	51°F (COC method)
Toxicity	Moderate, see MSDS
Solvents	None
Mix Ratio	1: 1
Clean Up Solvents	IPA, MEK, Acetone
Solids Content	100%

Typical Cured Properties (SOLID)

Shore D Hardness	75 at .030" thickness
Tensile Shear Strength on: PVC, ABS, glass filled nylon, and styrene	Substrate Failure
Lap Shear Strength	3390 psi – aluminum
Chemical Resistance	Excellent
Elongation	30%
Impact Resistance	20 ftlbs/in ² on Steel
Peel Strength	20-25 psi Aluminum
Thermal Service Range	-65°F to +260°F
UV & Weathering Resistance	Excellent

Instructions For Use

Combine resin and activator in equal volumes and mix thoroughly. Use pre-measured cartridges with disposable static mixers for convenience. Open or working time is at room temperature. Handling strength is generally the time in which the bonded parts can be removed from clamps and fixtures. Test your parts to be sure. Apply the proper adhesive to the parts to be joined using enough to fill the joint. Clamp or fixture in place until handling strength is attained. Available in premeasured cartridges as shown below or in bulk for use with EXTREME dispensing equipment.

To To Order Call **EXTREME Adhesives, LLC** at 800-888-4583

Item #	50 ml	220 ml	400ml
Fast	EXT-MK/FC-50ML	EXT-MK/FC-220ML	EXT-MK/FC-400ML
Medium	EXT-MK/MC-50ML	EXT-MK/MC-220ML	EXT-MK/MC-400ML
Slow	EXT-MK/SC-50ML	EXT-MK/SC-220ML	EXT-MK/SC-400ML

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A Division of Royal Adhesives & Sealants, LLC

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