



Technical Data Sheet



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Loctite Extreme Glue

CHARACTERISTICS

- Water and solvent free repair adhesive based on FlexTec® technology
- High final strength and initial grip
- Flexible and vibration-resistant
- Gel texture
- Gap filling
- Safe and easy to use
- Solvent-free, no shrinkage
- 1-component, moisture-curing
- For interior and exterior application
- Water and ageing resistant.
- Not suitable for polypropylene polyethylene and Teflon®

APPLICATION FIELD

- For DIY, repair and modelling work in and around the house
- Glues many absorbent and non-absorbent materials like:
 - *Metals (aluminium, stainless steel, brass, steel, copper, zinc, etc.)
 - *Glass, concrete, ceramic, tiles, stone
 - *Wood, cork, paper, cardboard
 - *Textiles, leather, rubber, varnished surfaces.
 - *Plastics like rigid PVC, rigid polystyrene, polycarbonate, polymethylmethacrylat (PMMA, Plexiglas®), glass-fibre reinforced plastics such as reinforced polyester or polyamide, polystyrene foam (Styrofoam®). Not suitable for polyethylene (PE), polypropylene (PP), polytetrafluoro-ethylene (PTFE) (Teflon®) and sensitive textiles.



INSTRUCTIONS FOR USE

Pretreatment

The material to be bonded should be clean and free of grease and dust. Clean laminates, metal etc. with solvent (washing benzene or alcohol). Additional abrading increases bonding strength with metals. The adhesive cures by absorbing moisture from the environment, so make sure the applied glue film has contact to ambient air. In case of gluing two non absorbent surfaces curing time can be slowed down. To optimize curing time you can previously clean surface with a damp cloth but make sure to avoid wetness, pooling water or drop formation.

For coated materials pretest adhesion and roughen if necessary

Application

Depending on the nature of your repair job you can choose among three different ways of applications:

1. Transparent bonding.

Apply Loctite Extreme Glue in a thin layer to get a transparent film. Keep the items pressed for approx. 1 hour.

2. Fill gaps.

Apply Loctite Extreme Glue in a thick layer to fill gaps up to 5mm max. Fix or clamp the items together for 1 – 3 hours and do not touch or move them. In 24 hours, 70% of the full adhesion strength is achieved.

3. High initial grip.

Apply Loctite Extreme Glue on both surfaces in thin and even layers. Leave for 3 minutes. Use as a contact adhesive. After Loctite Extreme Glue become tacky, like pressure sensitive tape, bring the items together immediately and press firmly. Make sure the glue does not get a skin before assembling parts. Fixation is not necessary in many cases. Please note that final strengths can decrease when used as contact glue.

By all applications, please make sure to keep the tube nozzle and cap clean and immediately tightly close cap to avoid curing of the glue at the nozzle.

Cleaning tools

Clean tools with thinner, alcohol or wash white spirit immediately after use. Once cured Loctite Extreme Glue is not soluble in any solvent and it can only be removed mechanically.

TECHNICAL DATA

Composition	Flextec® polymer based
Density	ca. 1,1 g/cm ³ at 25°C
Colour	Translucent
Final lapshear strength (acc. DIN EN 205)	3-11 N/mm ² dep. on material
Heat resistance	-50 to +120°C
Application temperature	+5°C up to +40°C
Gap filling	Up to 5mm
Open time	3-5 min, depending on temperature and relative humidity
Shelf Life	18 months From date of production, stored in cool, dry conditions
Cure through speed	2mm every 24 hours, depending on temperature and humidity conditions

LIMITATIONS

Not suitable for use on waxy or soft plastics, e.g. PP, PE, Teflon® (PFTE), vinyl. Though adhesive is water resistant, no long term water immersion is recommendable. Put the cap back immediately after applying the glue since it cures very fast.

**Cleaning tools**

Clean tools with white spirit immediately after use. Once cured Loctite Extreme Glue is not soluble in any solvent and it can only be removed mechanically.

STORAGE

Store tightly close and at room temperature. Avoid humidity and temperatures lower +5°C and above +50°C.

PACKAGING

20ml Aluminium tube

HEALTH AND SAFETY

Before using the product please see related Material Safety Data Sheet that is available on request.

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

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