



# TECHNICAL DATA SHEET

Revision: 02/15/2022  
Supersedes: NEW  
Ref. #: 677646

## LEPAGE® EXTREME Glue



### DESCRIPTION

LEPAGE® EXTREME Glue is a true all-purpose glue that is extremely strong and easy to use in and around the house. Mixing the power and versatility of two technologies, it is the best formula for your repairing, crafting, and building projects. LEPAGE® EXTREME Glue dries crystal clear, does not wrinkle paper, and sets with no clamping. EXTREME Glue is also elastic, shock resistant, non-shrinking and water resistant. It is suitable for gap filling and can be used indoors and outdoors.

Available as:

Item #	Package	Size
2764487	Squeeze Tube	50 g

### FEATURES & BENEFITS

- Strong & durable
- Easy to use / non-foaming
- Crystal clear for invisible repairs
- Flexible
- Water and shock resistant
- Temperature resistant from -40°C (-40°F) to 80°C (176°F)

### RECOMMENDED FOR

Use LEPAGE® EXTREME Glue for DIY projects and repairs in and around the home. It is compatible with many porous and non-porous materials such as aluminum<sup>1</sup>, stainless steel, steel, copper<sup>1</sup>, brass<sup>1</sup>, bronze<sup>1</sup>, concrete, ceramic tiles, natural stones, glass, mirrors<sup>1</sup>, wood, cork, chipboard, MDF, varnished surfaces<sup>1</sup>, fiberglass reinforced polyester, unfinished leather, linen, paper, cardboard, rigid PVC, polycarbonate, sanded ABS, polystyrene foam including EPS, XPS, and Polyiso types

<sup>1</sup> see limitations below

### LIMITATIONS

- Not for use on polyethylene (PE), polypropylene (PP), polytetrafluoroethylene (PTFE) / Teflon®, ABS and rigid polystyrene
- Should not be considered for direct or indirect food contact
- Before application, carry out tests to ensure compatibility of LEPAGE EXTREME Glue with non-ferrous metals such as aluminum, copper, bronze, and brass, as well as with coatings such as paints, varnishes, and powder coatings. Variations in composition may affect adhesion
- LEPAGE EXTREME Glue is only compatible with mirrors whose reflection and protective coating complies with DIN 1238 5.1 and DIN EN 1036. See application instructions
- The cured product is water-resistant, but not suitable for water immersion
- If bonding two non-porous surfaces (i.e., metal to metal or plastic to plastic) then both surfaces should be pre-wetted with a damp cloth before applying the adhesive. Avoid wetness, pooling water or water drop formation.

### COVERAGE

For a 50 g tube: 250 g/m<sup>2</sup> when applied to one surface only

Note: The required amount of adhesive depends on the substrate porosity and thickness of any gap



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## TECHNICAL DATA

Typical Uncured Physical Properties		Typical Application Properties	
<u>Color:</u>	Transparent and colorless	<u>Application Temperature:</u>	Apply between 5°C (50°F) and 40°C (104°F)
<u>Appearance:</u>	Liquid	<u>Odor:</u>	Minimal
<u>Base:</u>	Silane moisture-curing polymer	<u>Open Time:</u>	8 – 15 minutes*
<u>Viscosity:</u>	8,000 to 20,000 cps	<u>Repositioning Time:</u>	5 minutes*
<u>Specific Gravity:</u>	1.13	<u>Clamp Time:</u>	30 minutes*
<u>Flash Point:</u>	66°C (150.8°F)	<u>Full Cure Time:</u>	Approximately 24 hours*
<u>VOC Content:</u>	5.2% by weight    CARB 105 g/L                    SCAQMD		

\*Time is dependent upon temperature, humidity, porosity of substrate and amount of adhesive used.

Typical Cured Performance Properties	
<u>Color:</u>	Clear and colorless
<u>Shelf Life:</u>	18 months from date of manufacture (unopened)
<u>Lot Code Explanation:</u>	<b>YDDD XXXX</b> Y= year of manufacture DDD= Day of manufacture based on 365 days in a year XXXX= batch number (internal) Example: <b>1020</b> 2032 = January 20, 2021 is date made
<u>Service Temperature:</u>	-40°C (40°F) to 80°C (176°F) Note: Exposure to temperatures above 50°C (122°F) will cause yellowing
<u>Cured Form:</u>	Non-flammable, flexible solid
<u>Water Resistant:</u>	Yes
<u>Paintable:</u>	Yes (see page 3 for details)

Tensile Shear Strength: 1-inch overlaps cured for 7 days at 23°C (73°F)			
Pine to Pine	392 psi	Maple to PVC (hard)	281 psi
Maple to Maple	493 psi	PVC to PVC (hard)	109 psi
Maple to Aluminum	375 psi	Maple to Polycarbonate	473 psi
Aluminum to Aluminum	243 psi	Maple to Acrylic (sanded)	234 psi
Cold rolled steel to itself	189 psi	Maple to ABS	119 psi
Maple to Stainless steel	491 psi	Maple to ABS (sanded)	371 psi
Stainless steel to itself	496 psi	Maple to Fiberglass (sanded)	450 psi
Canvas to Canvas	4 lbs./inch	Felt to Pine	9 lbs./inch
Canvas to Pine	11 lbs./inch	Leather (unfinished) to Pine	8 lbs./inch
Corduroy to Maple	6 lbs./inch		

Tensile Shear Strength: 1-inch overlaps cured for 7 days at 23°C (73°F) then 3-hour water immersion			
Maple to Maple	471 psi	Maple to Aluminum	370 psi

Compression Shear Strength: cured for 7 days	
Maple to Maple	466 psi



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## DIRECTIONS

### **Tools Typically Required:**

Wear gloves and wash hands after use.

### **Safety Precautions:**

Use in a well-ventilated area. Protect work area before and during use. Wear gloves (nitrile gloves recommended) and wash hands after use.

### **Preparation:**

Protect work area. Surfaces to be glued must be sound, clean, dry (see Application below), and free of grease, dust, old adhesive residue, paint, and other contaminants such as plasticizers and mold release agents. Remove contaminants with alcohol or acetone (test surfaces for compatibility before using). For improved adhesion, lightly sand very smooth or glossy surfaces and clean thoroughly. Pre-fit all materials before applying adhesive. When bonding two non-porous surfaces, dampen surfaces lightly before applying adhesive. Mask off the adjacent areas with tape before gluing if necessary. To open, rotate cap counterclockwise.

### **Application:**

Apply a thin layer of adhesive to one surface. Bond parts immediately after applying the adhesive and hold or clamp parts together (before skin formation) for at least 30 minutes. For best results allow 24 hours to fully cure before subjecting to stress. Unlike other adhesives, high pressure during curing is not necessary. Very porous materials will require a thicker layer of adhesive, and application to both surfaces may be required.

LEPAGE EXTREME Glue cures by absorbing moisture into the bond line from the ambient air (air humidity or water vapor) or from the substrate. If both surfaces to be joined are non-porous (i.e., metal to metal or plastic to plastic) then they can only be glued by pre-wetting both surfaces with a damp cloth before applying the adhesive. Avoid wetness, pooling water or water drop formation. For large surface areas make sure the moisture film does not dry off before applying the adhesive. Absorbent surfaces are normally water-permeable and do not require pre-wetting; however, the curing process can be considerably accelerated for both absorbent and non-absorbent substrates if the surfaces are pre-wetted by wiping the areas to be glued with a damp cloth before applying the adhesive. The adhesive can be applied to damp surfaces. The adhesive will reach its maximum strength after it has fully cured, and the substrates have fully dried.

Once fully cured the adhesive can be painted with water-based acrylic paint, polyurethane-based varnishes, and alkyd resin varnishes. When using alkyd resin paints, drying may be delayed. EXTREME Glue is not compatible with one component polyurethane paints.

### **Mirror bonding:**

Be very careful not to scratch or damage the back coating of the mirror. Protect surrounding areas and floors from drips, squeeze outs, etc. Apply the adhesive to the back of the mirror, or substrate, using vertical beads only, approximately 3 mm (1/8 inch) wide and approximately 2.5–5 cm (1–2 inches) apart. Place adhesive approximately 2.5–5 cm (1–2 inches) from edges to prevent squeeze out. Within 5-8 minutes press firmly against wall and tape in place until cured. Support the bottom of the mirror to prevent slippage until adhesive cures. For mirrors larger than 0.09 m<sup>2</sup> (1 ft<sup>2</sup>), a permanent support system must be used with this product. Place mirror into support channels or hangers and press in place within 5-8 minutes of applying glue. Tape or brace the top of the mirror until the adhesive has set at least 48 hours. For non-porous surfaces, longer curing time will be required. Do not try to reposition the mirror once in place. If sealing edges, wait a minimum of 7 days to apply sealant. Cure time will depend on temperature, humidity, type of substrate, and amount of air that can reach the adhesive.

### **Clean-up:**

Clean tools and adhesive residue immediately after use with alcohol, acetone, or cleaner's naphtha. Follow manufacturer's precautions for use and hazards. Cured sealant may be carefully cut away with a sharp-edged tool. Cured adhesive cannot be removed from clothing and is not soluble in any solvent.

## STORAGE & DISPOSAL

Store above freezing in a cool and dry place. Avoid direct sunlight. Close the tube tightly immediately after each use. Exposure to high humidity during storage will reduce shelf life. Exposure to high temperatures during storage (>50°C, 122°F) will cause the product to yellow in the bottle.

To dispose of unwanted product, squeeze out remaining material, allow to dry and discard with domestic waste. Dispose of non-hardened product residues according to applicable local regulations. Large product amounts must be disposed of separately. Empty packaging can be recycled.



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## LABEL PRECAUTIONS

**WARNING!** Methanol is released during application and cure which may affect the nervous system causing dizziness, headache, or nausea. May irritate eyes and skin. Do Not swallow. Use only in a well-ventilated area. Do not get in eyes or on skin or clothing. **KEEP OUT OF REACH OF CHILDREN.**

**FIRST AID TREATMENT:** Contains trimethoxysilanes. If swallowed, call Poison Control Centre or doctor immediately. If in eyes or on skin, rinse well with water. If breathed in, move person into fresh air.

**Refer to the Safety Data Sheet (SDS) for further information**

## DISCLAIMER

The information and recommendations contained herein are based on our research and are believed to be accurate, but no warranty, express or implied, is made or should be inferred. Henkel recommends purchasers/users should test the products to determine acceptable quality and suitability for the intended use. All adhesive/sealant applications should be tested under simulated or actual end use conditions to ensure the adhesive/sealant meets or exceeds all required project specifications. Since assembly conditions may be critical to adhesive/sealant performance, it is also recommended that testing be performed on specimens assembled under simulated or actual production conditions. Nothing contained herein shall be construed to imply the nonexistence of any relevant patents or to constitute a permission, inducement, or recommendation to practice any invention covered by any patent, without authority from the owner of the patent.



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