



Extreme 5375HS

High Strength Metal / Composite Adhesive – Long Open Time

Product Description

Extreme 5375HS is a 1:1 medium viscosity, **solvent-free** structural adhesive system that provides flexibility, toughness and surface adhesion for bonding plastics and metals in any combination. Cured performance shows excellent adhesion and bond strength to as received plain and plated metal components, nylons, polystyrenes, fiberglass, reinforced plastics, stone, ceramics. This material can withstand thermal cycling and shock loading between dissimilar materials.

Although it is always best to clean and prepare most bonded surfaces for improved adhesion. **Extreme 5375HS** will work successfully in many applications **without preparation**.

Extreme 5375HS is moderate cure speed, two-component product with an open time of 25-30 minutes at 72° F after thorough mixing. It exhibits a lower viscosity for machine dispensing. For rapid cure times consider product number **Extreme 5315HS**.

Why Should You Select This Adhesive?

- Toughness And Durability
- Excellent Adhesion To Plastics and Very High Metal Adhesion
- Impact Resistance
- Peel Strength
- 100% Reactive Solids Formulation For VOC Compliance and Safety
- Moderate Cure Speed And Excellent Gap Cure

Contact an **EXTREME ADHESIVES®** Adhesive Applications Specialist for further recommendations on adhesive selection.

Physical Properties

Typical Uncured Properties (LIQUID)

Applies to both adhesive and activator sides

Viscosity	190,000 cps mixed (Thixo)
Specific Gravity	1.01 (20/20C°)
Color	Straw or Black
Flashpoint	51°F (COC method)
Toxicity	Moderate, see MSDS
Solvents	None
Mix Ratio	1 : 1
Fillers	Yes
Clean Up Solvents	MEK, Acetone

Typical Cured Properties (SOLID)

Typical film thickness 0.010".

Shore D Hardness	70
Adhesive Testing Plastics	Glass filled nylon, styrene, ABS, PVC
Thermal Service Range	-40°F to 275°F
Chemical Resistance	Excellent
Elongation	25-35%
Impact Resistance	>6.78 J stops hammer (side Impact)
Peel Strength	34 pli on untreated steel
Lap Shear Strength	4800 psi - as rec'd CRS

Instructions For Use

Combine resin and activator in equal volume and mix thoroughly. For convenience and accuracy use pre-measured cartridges with disposable static mixers. Open time is 25-30 minutes at room temperature. Handling strength is within approximately 2 hours. Full cure is 8 hours.

Shelf Life

6 months at 72°F when stored and sealed in original containers, 12 months when refrigerated at 40°F in 5 gallon pails or drums.

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