



Technical data sheet

MD GLUE XTREME 2

medium viscosity

The values are average values. They serve merely for your information, but assume no warranty.

Basis:	Methoxyethyl Cyanoacrylate
Color:	transparent, colorless
Viskosity 25°C (Brookfield):	about 120 - 250 mPa.s
Density:	1,12 g/cm ³
Storage time at 5°C to 8°C:	12 months
Gap filling:	< 0,1 mm
Temperature resistance:	-50 to +80°C
Fixture time:	about. 10 - 120 seconds
Full Strength:	24 hours

Latest generation cyanoacrylate:

- Odorless
- no blooming
- simple application
- transparent glue of PMMA
- remains flexible
- quick hand strength
- no impairment of electronic components

Fields of application:

Newly developed production method for bonding a wide variety of material compounds (metal, rubber, wood, cardboard, ceramics and most plastics) and among each other. Despite residual flexibility MD GLUE XTREME achieves very high strengths in most materials.

Instructions for use:

The parts to be bonded must be clean, oil and grease. MD GLUE thinly on one side and add and press together the parts to be joined together. The parts should be positioned as closely as possible because of the low partial fixing time. The hand strength is around 5 - reaches 90 seconds, and the ultimate strength after about 24 hours. MD GLUE XTREME cures at room temperature in combination with humidity. The optimum relative humidity should be around 65%. In order to accelerate the curing, our activator no. 9 can be used. For materials such as PP, PE, PTFE or silicone parts such as have our MD primers are pretreated No. 7.



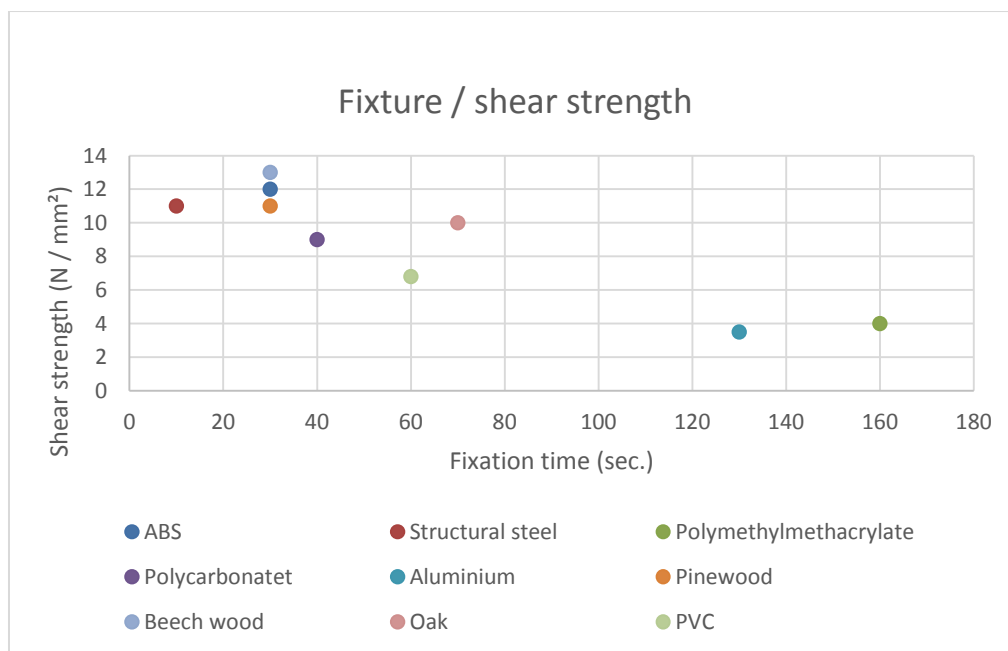
Fixture / peel strength:

	Fixation time (sec.)	Peel Strength (N / mm)
Textiles	45	0,8
Leather	15	3,7
Cork	15	X
Carton	15	X

Fixture / shear strength: Fixture / shear strength:

	Fixation time (sec.)	Shear strength (N / mm ²)
ABS	30	11,9 - 12,1
Structural steel	10	10,0 - 12,0
Polymethylmethacrylate	160	3,2 - 4,7
Polycarbonatet	40	8,3 - 9,4
Aluminium	130	2,8 - 4,6
Pinewood	35	10,0 - 12,4
Beech wood	25	12,5 - 14,9
Oak	70	9,6 - 10,1
PVC	55	6,7-6,9

Material breach



Storage:

cool, dry, dark, optimum temperature: 4°C – 8°C.

RoHS compliant

Art.-No.	MGL.X2.F25	package	12 piece
Art.-No.	MGL.X2.ST12	package	18 piece