

Revised  
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## TECHNICAL DATA SHEETS

### M5

#### Description:

M5 is a methyl based metal bonding instant adhesive, used to bond metal to itself and other substrates.

It is available in 2 gram pipettes, ½ ounce bottles, 1 ounce bottles, 2 ounce bottles, 1 pound bottles, 4.4 pound containers, 20 kilo containers and 55 gallon drums.

#### Physical Properties:

APPEARANCE: Colorless Transparent Liquid  
VISCOSITY: 4 — 7 cps  
SPECIFIC GRAVITY: 1.08 - 1.10 @ 25°C  
REFRACTIVE INDEX nD20 1.50  
SOLUBILITY: Soluble in Nitromethane  
MAIN CONSTITUENTS: Methyl Alpha Cyanoacrylate

#### Handling Characteristics:

(SECONDS)

	CURE SPEED
NATURAL RUBER – NATURAL RUBBER	5 -- 10
CHLOROPRENE – CHLOROPRENE	5 – 10
BUTYL RUBBER – BUTYL RUBBER	5 – 10
RIDGE PVC – RUBBER PVC	10 – 30
BAKELITE – BAKELITE	30 – 40
ABS – ABS	20 – 40
BRASS – BRASS	30 – 60
STEEL – STEEL	60 – 90

TENSILE SHEAR STRENGTH	(kgf/cm <sup>2</sup> )
STEEL – STEEL	161
BRASS – BRASS	140
STAINLESS STEEL – STAINLESS STEEL	172
RIGID PVC – RIGID PVC	*
ABS – ABS	*
SOFT PVC – ABS	*

\* INDICATED MATERIAL FAILURE

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