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**TECHNICAL DATA SHEET**  
**M5**

**Description:**

M5 is a metal bonding instant adhesive, used to bond metal to itself and other substrates. It is available in 2 gram pipettes, 1/2 ounce bottles, 1 ounce bottles, 2 ounce bottles, 1 pound bottles, 4.4 pound bottles, 5 Gallon containers, and 55 gallon drums.

**Physical Properties:**

**Appearance:** Clear to hazy  
**Viscosity:** 4-7 cps  
**Specific Gravity:** 1.08-1.1 @ 25°C  
**Refractive Index nD20:** 1.5  
**Solubility:** Soluble in Nitromethane

**Handling Characteristics:**

**Cure Speed (Seconds)**

Natural Rubber - Natural Rubber	5-10
Chloroprene - Chloroprene	5-10
Butyl Rubber - Butyl Rubber	5-10
Rigid 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	*

\* Indicates Substrate Failure

**Engineering Excellence**

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and support call **1-800-552-0299** or visit our website at

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