



Manufactured by:
Eclectic Products, Inc.
Pineville, LA 71361

Made in the USA

800.767.4667 - Technical Services

www.eclecticproducts.com

www.e-6000.com

TECHNICAL DATA SHEET

***E-6000® Adhesive
Industrial Strength***

PRODUCT DESCRIPTION

E-6000® is a unique, adhesive formulated to meet high-performance industrial requirements. **E-6000®** has exceptional adhesion to wood, metal, glass, fiberglass, ceramics, masonry and concrete. It also adheres strongly to leather, rubber, vinyl and many plastics. **E-6000®** maintains its flexible bond in cold temperatures and may be used to bond items subject to vibration. The clear **E-6000®** is not formulated for exposure to sunlight. For these applications, paint over **E-6000®** after it has cured or try **E-6000®** adhesive specially formulated for outdoor use.

PRODUCT CHARACTERISTICS and BENEFITS

Flexible	Does not become brittle in cold weather; can bond items subject to vibration
Chemical resistant	Safe for applications exposed to dilute acids and dilute caustics
Abrasion resistant	Great for bonding objects subject to normal wear
Waterproof	Can be submerged in fresh and salt water after complete cure
Paintable	Paint to match surrounding area or make UV-resistant

PROPERTIES OF UNCURED MATERIAL

Color(s)	Clear, white, gray, black
VOC	1.198 grams/liter
Solvent	Perchloroethylene
Non-flammable	Yes
Density	11.0 +/- 0.1 lbs/gal
Solids	30% by weight, 40% by volume
Viscosity	High: 200,000 cps; Medium: 100,000 cps; Low: 50,000 cps
Tack time	~4 minutes
Full cure time	Thin film: 24 hours; Thick film: 48-72 hours
Storage	Store in dry area between 50 °F (10 °C) and 80 °F (27°C)
Freeze/thaw stability	Stable; allow product to warm to room temperature before using
Shelf life	2 years (unopened)

PROPERTIES OF CURED MATERIAL

Chemical resistance	Excellent to water, dilute acids and dilute bases
UV resistance	No; paint over for UV resistance
Hardness	80 Shore A
Dielectric strength	400V/mil (ASTM D-149); this is the maximum voltage that can be applied to a given material without causing it to break down
Tensile strength	3500 lb/in ² (ASTM D-412)
Elongation	900% (ASTM D-412)
Service temperature	-40 °F (-40°C) to 150 °F (66 °C)
Paint-over time	24 hours

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ADHESION TEST - Average values, 180° peel, ASTM D 903

ABS	32 pli	Acrylic	36 pli	Aluminum	30 pli
Cement/Brick	25 pli	Glass	40 pli	Leather	20 pli
Neoprene	32 pli	Polycarbonate	37 pli	PVC	27 pli
Rubber	30 pli	Steel	25 pli	Tile	25 pli
Urethane	32 pli	Wood	29 pli		

SOLVENTS THAT DISSOLVE E-6000® SERIES ADHESIVES

The following lists common solvents that dissolve E-6000® Series when hardened samples are immersed. The dissolution with these solvents is not instantaneous and therefore does not preclude usage in all cases. Applications where an occasional splash or brief exposure is expected may be acceptable. Test a small area before full use.

Gasoline	Cyclohexane	Perchloroethylene	1,1,1-Trichloroethane
Methylene chloride	Chloroethane NU	Chevron solvent 1100	Propyl acetate
Toluene			

CHEMICALS THAT HAVE LITTLE OR NO EFFECT ON E-6000® SERIES ADHESIVES

E-6000 exhibits excellent resistance to water, dilute acids and dilute bases. Thin films of E-6000 were immersed in various chemicals for two weeks and exhibited weight gains of less than 2% and tensile strength loss of less than 10%. These chemicals are listed below. All percentages are given by weight unless otherwise noted.

Wine (20% alcohol by volume)	Beer (3.2% alcohol by volume)	Acetic acid (5% and 10%)
Sulfuric acid (3% and 10%)	Boric acid (3.1%)	Oxalic acid (3.1%)
Lactic acid (3.8%)	Distilled water	Sodium chloride (10%)
Sodium carbonate (2.7%)	Potassium hydroxide (3.4%)	Ammonium hydroxide (3.4%)
Ammonium nitrate (50%)	Nitric acid (10% and 20%)	Milk (fresh, tested at 40°F)
Motor oil (30w)	Hydraulic oil	Antifreeze
	Phosphoric acid (30% and 60% as P ₂ O ₅)	

DIRECTIONS FOR USE and APPLICATION NOTES

Always test a small area before full use. For tube: use point of cap to puncture neck of tube to flow product.

For 10.2 oz cartridges: clip nozzle tip and puncture cartridge inside nozzle to flow product.

Cartridge gun is required.

- Step 1** Surface should be clean, dry and free of dirt. Roughen surface for optimum adhesion.
- Step 2** Apply E-6000® directly to each surface to be bonded or repaired. Bring surfaces together.
- Step 3** For maximum strength bond, allow to dry for 24 to 72 hours.
- Step 4** Clean uncured adhesive with acetone or naphtha sparingly. The adhesive will ball up and brush off. Cured material may be removed by cutting or scraping.
- Step 5** Store unused E-6000® adhesive in a dry area at room temperature.

For technical assistance, call 800.767.4667.

- Please read all directions before using. Use in well-ventilated area only.
- Product can be used between 50 °F (10 °C) and 90 °F (32 °C). Dry time decreases when used between 70 °F (21 °C) and 90 °F (32 °C).
- E-6000® hardens by solvent evaporation.
- If using E-6000® to adhere articles to fabric, DO NOT DRY CLEAN FABRIC.
- E-6000® is not recommended for any items that come into contact with food, drinking water or animals.
- E-6000® is not recommended for use on Styrofoam™, polystyrene, polyethylene or polypropylene plastics, aquariums or refrigeration units.
- Paint-over for added UV resistance or use UV-6800®.

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HAZARDS

This product contains perchloroethylene. Before working with this product, read and become familiar with information concerning hazards, proper use and handling. To request an MSDS, please send an Email to msds@eclecticproducts.com or call 800.333.9826.

LIMITED WARRANTY

The product is warranted against any defect in materials or workmanship under normal use and service for a period of 180 days after the date of purchase. The product is also warranted under any implied warranties provided under applicable state law, including, without limitation, the implied warranty of merchantability and the implied warranty of fitness for a particular purpose, for a period of 180 days after the date of purchase. This warranty covers only the original buyer of the product. For warranty service, the buyer should contact the store where the product was purchased, or write Eclectic Products, Inc. P.O. Box 4450, Pineville, LA 71360 or call 800.767.4667. This warranty gives you specific legal rights, and you also have other rights, which vary from state to state.