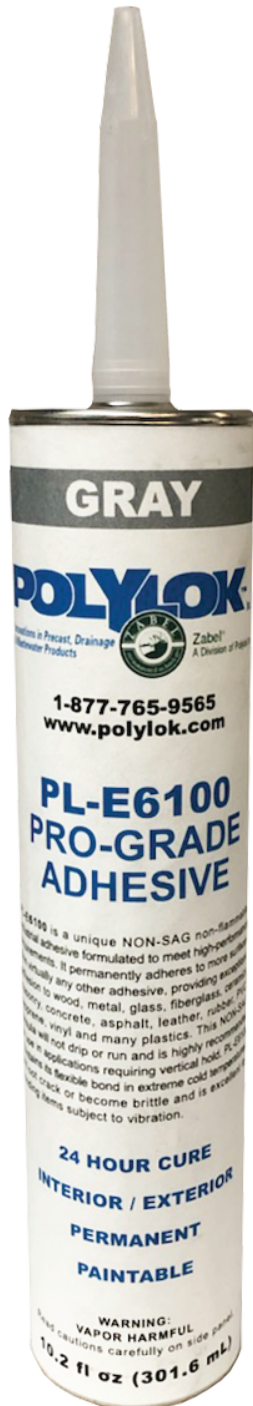


# Technical Data Sheet



**POLYLOK™** Inc.  
Innovations in Precast, Drainage & Wastewater Products  
Zabel®  
A Division of Polylok Inc.  
3 Fairfield Boulevard, Wallingford, Connecticut 06492  
Office: 1-877-765-9565 Fax: 203-284-8514  
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## PL-E6100 INDUSTRIAL ADHESIVE

### Non-Sag Formula (Gray)

PL-E6100 is a unique NON-SAG, non flammable industrial adhesive formulated to meet high-performance requirements. It permanently adheres to more surfaces than virtually any other adhesive, providing exceptional adhesion to wood, metal, glass, fiberglass, ceramics, masonry, concrete, asphalt, leather, rubber, PVC, neoprene, vinyl and many plastics. This NON-SAG formula will not drip or run and is highly recommended for use in applications requiring vertical hold. E6100 maintains its flexible bond in extreme cold temperatures, will not crack or become brittle and is excellent for bonding items subject to vibration. For applications exposed to direct sunlight, paint over E6100 after curing.

#### WHERE TO USE / APPLICATIONS

- Polylok riser and adapter ring joints
- vertical repairs to brick & mortar
- HVAC systems repair
- locking down fasteners against vibration
- roof flashing/shingles repair
- auto upholstery/paneling/molding
- and much more!

#### FEATURES AND BENEFITS

**EASY TO USE** – 10.2 fl oz cartridge fits into standard cartridge gun

**FLEXIBLE** – does not become brittle in cold weather and bonds 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

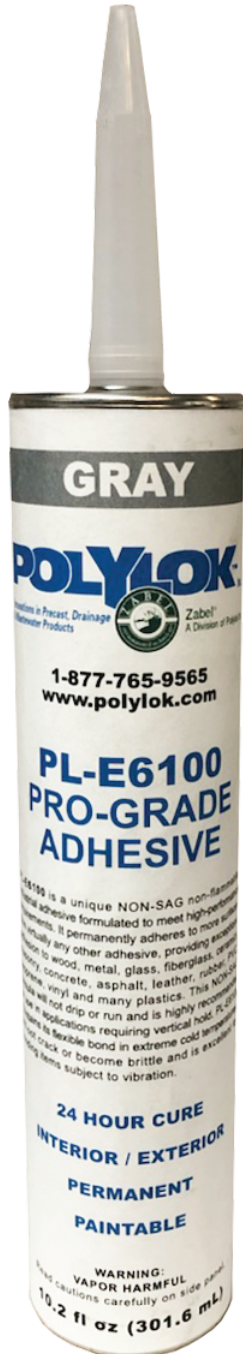
**PAINTABLE** – paint to match surrounding area or to make UV resistant

#### TECHNICAL INFORMATION

PROPERTIES	
UNCURED MATERIAL	
Color:	Gray
Solvent:	Perchloroethylene
Non-flammable:	Yes (uncured liquid state)
Density:	11.0 +/-0.1 lbs/gal
Solids:	30% by weight, 40% by volume
Viscosity:	Non-sag; 1,000,000 cps
Tack time:	~ 4 minutes
Set time:	20 minutes*
Full cure time:	Thin film: 24 hours / Thick film: 48-72 hours
Storage:	Product may thicken when stored in colder temperatures. If product thickens from colder temperatures, warm to room temperature before use.
Application Temp:	Ideal application temperature range is 50 to 90 °F (10 to 32 °C).
Freeze/thaw stability:	Stable, allow product to warm to room temperature before using
Shelf life:	2 year (unopened)

\*Depending on material, humidity and temperature.

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CURED MATERIAL	
Chemical resistance:	Excellent to dilute acids and dilute bases
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:	3800 lb/in <sup>2</sup> (ASTM D-412)
Elongation:	900% (ASTM D-412)
Temperature range:	Fully cured adhesive can withstand temperatures from -40 to 180 °F (-40 to 82 °C) intermittently.
UV resistance:	Paint-over or use E6800
Paint-over time:	24 hours

ADHESION TEST – 180° Peel Strength Test - ASTM D 903				
Aluminum	Birch (wood)	Glass	PUC	Steel
35 pli	40 pli	34 pli	38 pli	45 pli

Avg. Max Load Measured in pli (pounds per linear inch)

### CHEMICALS THAT HAVE LITTLE OR NO EFFECT ON PL-E6100

Acetic acid (5% and 10%)	PL-E6000 exhibits excellent resistance to dilute acids and dilute bases.
Ammonium hydroxide (3.4%)	Thin films of PL-E6100 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 on the left. All percentages are given by weight unless otherwise noted.
Ammonium nitrate (50%)	
Antifreeze	
Beer (3.2% alcohol by volume)	
Boric acid (3.1%)	
Distilled water	
Hydraulic oil	
Lactic acid (3.8%)	
Milk (fresh, tested at 40 °F)	
Motor oil (30w)	
Nitric acid (10% and 20%)	
Oxalic acid (3.1%)	
Phosphoric acid (30% and 60% as P <sub>2</sub> O <sub>5</sub> )	
Potassium hydroxide (3.4%)	
Sodium carbonates (2.7%)	
Sodium chloride (10%)	
Sulfuric acid (3% and 10%)	
Wine (20% alcohol by volume)	

### SOLVENTS THAT DISSOLVE PL-E6100

Chevron solvent 1100	These are common solvents that dissolve PL-E6100 when hardened samples were immersed. The dissolution with these solvents was 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.
Chlorothane NU	
Cyclohexane	
Gasoline	
Perchloroethylene	
Propyl acetate	
Toluene	

### DIRECTIONS and APPLICATION NOTES

- Step 1 Read directions and test small area before use.
- Step 1 Surface should be clean, dry and free of dirt. For best results, lightly roughen surface before use.
- Step 2 Trim end of nozzle. Puncture inner seal. Ideal application temperature range is 50 to 90 °F (10 to 32 °C). However, fully cured adhesive can withstand temperatures from 40 to 180 °F (-40 to 82 °C) intermittently.
- Step 3 Apply directly to surfaces to be bonded or repaired.
- Step 4 Allow 24 hours for curing. Depending on materials and temperature, maximum strength may not be reached for 48 to 72 hours.

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- Step 5 For prolonged storage after opening, cover or plug the opening of the nozzle.  
Step 6 Clean uncured adhesive with acetone or citrus-based solvents.

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### HEALTH and SAFETY

This product contains perchloroethylene. Before working with this product, read and become familiar with information concerning hazards, proper use and handling.

To request a hard copy of the SDS, please send an e-mail to [sales@polylok.com](mailto:sales@polylok.com).

**⚠WARNING:** This product can expose you to chemicals including perchloroethylene which is known to the State of California to cause cancer. For more information go to [www.p65warnings.ca.gov](http://www.p65warnings.ca.gov).

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### LIMITED WARRANTY

The product is warranted against any defect in materials or workmanship under normal use 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 Polylok, Inc., 3 Fairfield Blvd. Wallingford, CT 06492 or call 1-877-765-9565. This warranty gives you specific legal rights, and you also have other rights, which vary from state to state.