



Extreme 310M

Moderate Open Time – Metal\Plastics Bonder

Product Description

Extreme 310M is a medium viscosity, **solvent-free** structural adhesive system which provides flexibility, toughness and surface adhesion for bonding plastics and metals in any combination. Cured performance shows excellent adhesion and bond strength to nylons, polystyrenes, fiberglass, reinforced plastics, stone, ceramics and most plain and plated metal components. This material can withstand thermal cycling and shock loading between dissimilar materials.

Although it is always best to clean and prepare most bonded surfaces for improved adhesion. **Extreme 310M** will work successfully in many applications **without preparation**.

Extreme 310M is moderate cure speed, two-component product with an open time of 13-17 minutes at 72° F after thorough mixing. For rapid cure times consider product number **Extreme 300M**.

Why You Should Select this Adhesive

- Toughness and Durability
- Excellent Adhesion to Plastics and Metals
- Impact Resistance
- Peel Strength
- 100% Reactive Solids Formulation for VOC Compliance and Safety
- Moderate Cure Speed and Excellent Gap Cure

Contact an **EXTREME ADHESIVES®** Adhesive Applications Specialist for further recommendations on adhesive selection.

Physical Properties

Typical Uncured Properties (liquid)

Applies to both the adhesive and activator sides

| | |
|-------------------|--------------------|
| Viscosity | 200,000 cps mixed |
| Specific Gravity | 1.01 (20/20C°) |
| Flashpoint | 51°F (COC Method) |
| Toxicity | Moderate, see MSDS |
| Color | Straw or Black |
| Solvent Content | None |
| Mix Ratio | 1 : 1 |
| Clean Up Solvents | MEK, Acetone |

Typical Cured Properties (solid)

Typical Film Thickness = 0.030"

| | |
|-----------------------|--|
| Shore D Hardness | 75 |
| Testing on Plastics | Glass filled nylon, Styrenes, PVC, ABS |
| Thermal Service Range | 65°F to 260°F |
| Chemical Resistance | Excellent |
| Elongation | 60% |
| Impact Resistance | 20 ftlbs/in ² on steel |
| Peel Strength | 20-25 pli on aluminum |
| Lap Shear Strength | |
| As rec'd CRS | 4200 psi |
| As rec'd Aluminum | 3300 psi |

Instructions for Use

Combine resin and activator in equal volume and mix thoroughly. For convenience and accuracy use pre-measured cartridges with disposable static mixers. Open time is 13-17 minutes at room temperature. Handling strength within approximately 35 minutes.

Shelf Life

Shelf Life is at least 6 months when properly stored in an unopened original container in a cool, dark area at least 55°F to 75°F.

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