



Extreme 350M

Long Open Time Metal \ Plastics Bonder

Product Description

Extreme 350M is a medium viscosity, **solvent-free**, structural adhesive system, which provides flexibility, toughness and surface adhesion for bonding plastics and metals in any combination. Offering low exotherm for thin plastic bonding applications, cured performance shows excellent adhesion and bond strength to polystyrenes, fiberglass, reinforced plastics, gel coats, vinyl esters, thermoplastics and most plain and plated metal components. The adhesive will withstand the thermal cycling and shock loads between dissimilar materials without embrittling at **lower temperatures**.

Although it is always best to clean and prepare most bonded surfaces for improved adhesion. **Extreme 350M** will work successfully in many applications **without preparation**.

Extreme 350M is moderate cure speed, two-component product with an open time of 40-50 minutes at 23° C after thorough mixing.

Why You Should Select this Adhesive

- Low Temperature Toughness and Strength
- Excellent adhesion to Plastics and Metals
- Impact Resistance
- Peel Strength
- 100% Reactive Solids Formulation for VOC Compliance and Safety
- Long 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	300,000 cps mixed
Specific Gravity	1.35 (20 / 20°C)
Color	White
Flashpoint	51°F (COC Method)
Toxicity	Moderate, see MSDS
Solvents	None
Mix Ratio	1:1
Fillers	Yes
Cleanup Solvents	MEK, Acetone

Typical Cured Properties (solid)

Typical Film Thickness = 0.030"

Shore D Hardness	60
Testing on Plastics	Glass filled Nylon, Styrene, ABS, PVC
Thermal Service Range	-65°F to 260°F
Chemical Resistance	Excellent
Elongation	60%
Impact Resistance (side impact)	20 ftlbs/in ²
Peel Strength	20 – 25 pli on steel
Lap Shear Strength	2340 psi – as rec'd CRS; 2340 psi – grit blasted steel; 3390 psi - aluminum

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 45 minutes at room temperature. Handling strength is achieved within approximately 120 minutes after assembly.

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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