



# Extreme 300

## High Peel \ High Impact Metal \ Plastics Bonder

### Product Description

**Extreme 300** is a medium viscosity, **solvent-free** structural adhesive system that 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 300** will work successfully in many applications **without preparation**.

**Extreme 300** is moderate cure speed, two-component product with an open time of 5-6 minutes at 23° C after thorough mixing. For a longer open time consider product number **Extreme 310**.

### 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
- Fast 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     |
| Solvents          | None               |
| Mix Ratio         | 1 : 1              |
| Fillers           | Yes                |
| 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 (side impact) | 20 ftlbs/in <sup>2</sup>               |
| Peel Strength                   | 20-25 pli on aluminum                  |
| Lap Shear Strength              |                                        |
| As rec'd CRS                    | 2340 psi                               |
| Grit blasted steel              | 3365 psi                               |
| Aluminum                        | 3390 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 5 minutes at room temperature. Handling strength within approximately 10-15 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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