



Extreme 310

Moderate Open Time – Metal\Plastics Bonder

Product Description

Extreme 310 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 310** will work successfully in many applications **without preparation.**

Extreme 310 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 300.**

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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