



# Extreme S-300

## EXTREME SignWelder™ High Impact Plastic Metal Bonder

### Product Description

**Extreme S-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 S-300** will work successfully in many applications **without preparation**.

**Extreme S-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 S-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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