



Extreme S-315UC

Transparent Plastics Bonder

Product Description

Extreme S-315UC is a 1:1 meter mix methacrylate-based structural adhesive designed to provide clear bond lines. **Extreme S-315UC** forms tough, durable bonds to many diverse substrates including pigmented and clear engineering plastics, composites, and as-received metals, fritted glass, laminated woods, and ceramics. Surface preparation or the use of primers, or chemical wipes is not required in most cases. **Extreme S-315UC** has a medium cure speed with a working time of 12 - 15 minutes and fixture in less than 25 minutes on most substrates at room temperature.

Extreme S-315UC has a low viscosity to allow for small bead formation and to form thin clear bond lines or small bead fillets and retain clarity. It is best used to bond polycarbonate, acrylics, PVC, and ABS to each other or to metal or composite substrates in any combination.

Extreme S-315UC is easily dispensed from two component cartridges or commercial dispensing equipment using static mixer tubes. It is not recommended for styrene or easily solvated surfaces without extensive testing.

Why You Should Select this Adhesive

- Clear Bond Lines in Thin Sections
- Excellent Adhesion to Plastics and Metals
- Low Viscosity
- 100% Solids Formulation for VOC Compliance and Safety
- 1:1 Meter Mix

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	25,000 cps mixed
Specific Gravity	0.95 (20/20C°)
Color	Clear
Flashpoint	51°F (COC Method)
Toxicity	Moderate, see MSDS
Solvent content	None
Fillers	Yes
Clean Up Solvents	MEK, Acetone

Typical Cured Properties (solid)

Typical Film Thickness = 0.030"

Shore D Hardness	75
Adhesive testing on Plastics	ABS, PVC
Thermal Service Range	-60°F to 125°C
Chemical Resistance	Very Good
Elongation	10%
Tensile Shear Strength	
PVC	>500 psi
Steel	1600 psi

Instructions for Use

Combine resin and activator in equal volume and mix thoroughly. For convenience and accuracy use pre-measured cartridges with a disposable static mixer. Open application time is 15 minutes at room temperature. Handling strength develops within approximately 25 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.

The properties represented herein are TYPICAL VALUES and not intended for use in specifications. **Extreme Adhesives, Inc.** MAKES NO EXPRESS OR IMPLIED WARRANTIES OF MERCHANTABILITY, FITNESS OR OTHERWISE. While the information presented is believed to be accurate, no warranty or recommendation is made as to application. Determination of product suitability is the sole responsibility of the user. Suggestions made do not constitute any guarantee in as much as use conditions are beyond our control.