



PRODUCT DATA SHEET

Product Name- Extreme 3106

Extreme 3106 is a clear, medium viscosity UV curing adhesive for bonding all transparent plastic substrates, especially polycarbonate, PVC; clear ABS to themselves or to glass. **Extreme 3106** cures rapidly, in 3 seconds or less, when exposed to ultraviolet light from medium pressure mercury or microwave lamps, but also can be cured with visible light. Cured performance shows excellent adhesion to most types of plastic substrates with good temperature and solvent resistance, and toughness at all temperatures. **Extreme 3106** is formulated especially for bonding clear plastics, such as polycarbonates, acrylates, Mylar and PVCs where high clarity is required. It is tough and flexible, and meant for dissimilar substrates like plastics and glass to accommodate different coef. of expansion.

Base Resin- modified urethane acrylate

Percent Solids- 100%

Benefits of Adhesives:

- * **Medium Viscosity For controlled migration**
- * **Cures in 5 Seconds With Medium Intensity UV Light**
- * **Excellent Adhesion To Plastics**
- * **100% Solids Formulation For VOC Compliance**
- * **Excellent Toughness And Durability**
- * **Good Temperature And Solvent Resistance**

PHYSICAL PROPERTIES

TYPICAL UNCURED PROPERTIES (LIQUID)

Viscosity-	5300 cps	
Specific Gravity-	1.08 (20/20C)	
Color-	clear, water white	
Flashpoint-	172F (TOC method)	
Toxicity-	moderate, see MSDS	
Clean Up Solvents-	IPA, MEK	
Solvents-none	Component Parts-one	Fillers- none

TYPICAL CURING PROPERTIES

UV	medium intensity, 200w/in bulb 100 mw/cm ² at 365nm
Exposure Time	5 seconds per mil of thickness, ie 20 seconds for 4 mils

TYPICAL CURED PROPERTIES (SOLID) typical film thickness 0.010.

Shore D Hardness	53-55
Thermal Service Range	-40F to 300F
Refractive index	1.50

INSTRUCTIONS FOR USE

Typical Process Methods

Apply with syringe, brush or other method or automatic applicator to bond area. Expose to UV light as below. Available in a variety of viscosities and colors.

Ultraviolet Cure

Shield sealant from UV light during application to prevent polymerization lines on the part prior to application. Expose parts to ultraviolet light intensity of minimum $150\text{mw}/\text{cm}^2$ of 240 to 400 nanometers for 5-10 seconds. Cure time depends on coating thickness, distance from energy source and the lamp's power. Wand lamps have higher intensities of up to $2000\text{mw}/\text{cm}^2$ and will cure the product in 5 seconds or less. For microwave lamps, the H bulb is recommended to produce fastest cures.

The coating will be cured immediately after UV exposure and can be handled or packaged. Cure continues for several minutes during the cool down process. Solvent, peel or temperature service testing should be done after 10 minutes when the sealant returns to room temperature.

Application Note

Material is note sensitive to moisture or oxygen, but is sensitive to UV light and heat.

Shelf Life of Packaged Product 12 months at 75°F when stored and sealed in original opaque containers.

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