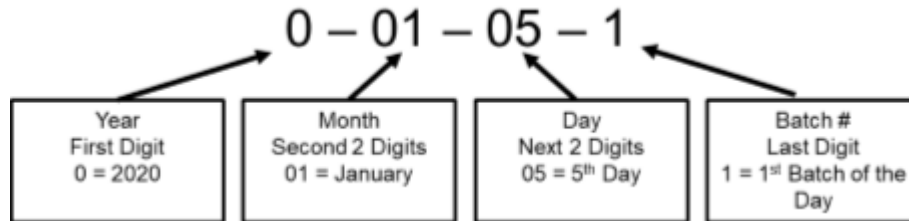


Frequently Asked Questions – PLEXUS®

- **Shelf Life** - What is the shelf life for PLEXUS® products?
 - 7 months at 24°C for most 1:1 mix ratio formulations, and up to 13 months for many 10:1 mixed systems. Please refer to each product Technical Data Sheet for specifics
<https://itwperformancepolymers.com/data-sheets/technical-data-sheets>
- **Lot Numbers** – How do I read the lot numbers for PLEXUS® products?
 - For many products, this will be part of a six-digit lot number on the packaging that reads as follows: For the first format (commonly found on Plexus and Devcon products), use lot #901231 as an example:
 - The first digit is the year after 2020, so 0 indicates 2020
 - The second and third digits are the month, so 01 indicated January
 - The fourth and fifth digits are the date, so 05 indicates the 05th
 - The sixth number is the batch number, so 1 indicates batch #1



- **SDS** - Where can I find a Safety Data Sheet for one of your products?
 - <https://itwperformancepolymers.com/data-sheets/safety-data-sheets>
- **Product Details** - Do you have more detailed product information available, such as mix ratio, operating temperatures, and application instructions?
 - These can be found in our Technical Data Sheets, which are available at
<https://itwperformancepolymers.com/data-sheets/technical-data-sheets>
- **Shore Hardness** - What is the typical Shore hardness of Plexus products?
 - 65 to 78 Shore D. The majority of Plexus products tend to be approximately 72 Shore D.
- **Frozen Product** - What happens if I Freeze Plexus? Can I still use it?
 - If frozen, Plexus products will become very rigid, but still pliable. If you allow frozen product to heat back up to room temperature, nearly all Plexus materials will return to their original form and perform as expected. As a result, they may be used. If a product does not look smooth after recovering, it is not recommended to be used without first testing to ensure a proper cure.
- **Storage** - Can I store Plexus products above 24°C (75°F)?
 - Yes, for a short period of time. The product's catalyst, which is a peroxide, degrades with time and temperature. So, the warmer you store it, the shorter it will last. Please see the specific product's

Technical Data Sheet for recommended storage conditions <https://itwperformancepolymers.com/data-sheets/technical-data-sheets>

- **Boiling** - Why is my Plexus product creating vapors when applied?
 - You are likely using the product within a joint larger than it was designed for, or you have a large amount of squeeze-out exceeding the gap capability of the particular Plexus product. Please see the product's Technical Data Sheet for recommended gap sizes.
- **Reduce usage** - How do I reduce my usage of Plexus product?
 - Try to minimize your bond line gap. A narrower bond line will not only help save on adhesive and cost but will lower your product's weight and produce a higher quality final part.
- **Compatible Cleaners** - What are the compatible cleaners for cleaning substrates prior to bonding?
 - PC120 is the recommended cleaner/conditioner, but Acetone, Isopropyl Alcohol, , Toluene, MEK and some Terpene's are all compatible cleaners with PLEXUS®.
- **Reduce Print Through** - I see an indent/warpage on my part directly above where the adhesive was applied. What is this, and how can I minimize or eliminate this effect?
 - To reduce or eliminate this phenomenon, try reducing your bond line gap. This will create a lower reaction temperature, leave less product to shrink, and lower your overall part cost.
 - If this is does not reduce or eliminate this effect, please see our product selection for a lower shrink product or contact our Technical Services department for assistance.
- **Usage per Cartridge (or Gallon)** – How many linear feet can I bond, The Table below is an approximate based on a rounded bead size as shown and is only a guide. Amounts for an application should be calculated by volume based on bead size and gap.

| | | Ft per Unit of Measure | | |
|-----------------|------|------------------------|-----------------|------------|
| Unit of Measure | | 400ml cartridge | 490ml cartridge | Per Gallon |
| Bead Size | 1/8" | 331.5 | 406.1 | 3136.8 |
| | 1/6" | 186.5 | 228.5 | 1764.8 |
| | 1/5" | 129.5 | 158.6 | 1225.4 |
| | 1/4" | 82.9 | 101.6 | 784.4 |
| | 1/3" | 46.6 | 57.1 | 441.0 |
| | 2/5" | 32.4 | 39.7 | 306.6 |
| | 1/2" | 20.7 | 25.4 | 195.9 |

