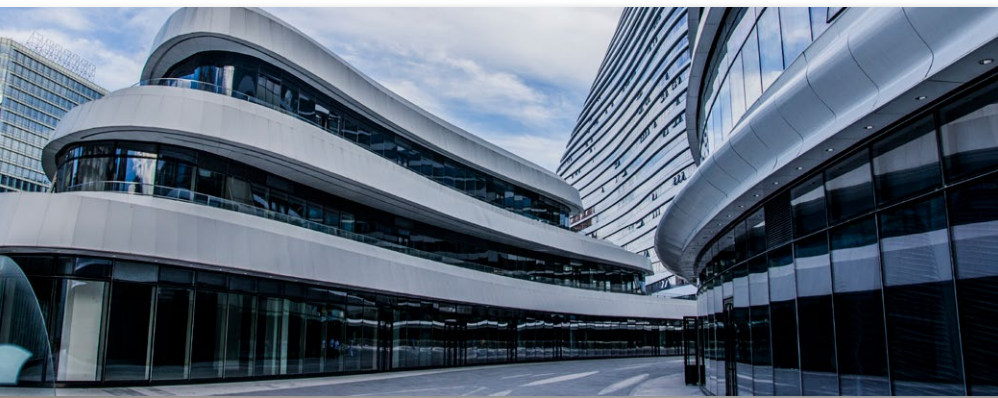


PLEXUS

Devcon

Permatex

Adhesive Solutions for OEM Structural and Assembly Applications



TW

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Introduction

ITW Performance Polymers provides a broad range of advanced structural and semi-structural adhesives that help simplify assembly processes, resulting in lower production cost and higher manufacturing throughput. Our portfolio of adhesive solutions comprises proven brands including Plexus methylmethacrylate adhesives, Devcon epoxy adhesives and Permatex cyanoacrylate adhesives. These products are well suited for bonding a wide range of composites, thermoplastics, metals and dissimilar substrates in several end-markets including transportation, wind, marine, signs and general industrial.

Our continued success is due to the importance we place on building strong and lasting relationships with our customers to provide the highest level of service. Our commitment to quality is reflected in every adhesive system that we produce providing our customers with reliability and consistency in every one of our products.

Services and Support

Comprehensive test programs developed to help in the understanding of how our adhesives will behave on our customers substrates.

Invaluable technical and sales support with assistance in product selection, application guidance, dispensing methods, and equipment support.

Access to the global distribution network through our strategic partners. Our customers have access to the high-quality products and services around the world. We understand the challenges in today's production environments and are always available to demonstrate the wide range of bonding solutions for any application.



Substrate Guide

Product	Metals						Plastics						Composites					Other
	Aluminium	Cold Rolled Steel	Painted / Coated Metals	Hot Dipped Galvanized	Stainless Steel	ABS	Acrylics	Polyamides (Nylons)	Polycarbonate	Polyesters	Vinyls (PVC)	Gelcoats	Fibreglass	Phenolics	RTM	SMC	Rubbers	
MA205HV	●	●	●		●	●	●	○	●		●	●	○		○	○	●	
MA300	○	○	●		○	●	●		○	○	●	●	●	●	●	○	●	
MA310	○	○	●		○	●	●	○	○	●	●	●	●	●	●	○	●	
MA320	○	○	●		○	●	●			●	●	●		●	●	○		
AO/MA420	○	○	●		○	●	●		○	●	●	●	●	●	●	○	●	
MA420FS	○	○	●		○	●	●		○		●	●	●		●	○		
MA420	○	○	●		○	●	●		○	●	●	●	●	●	●	○	●	
MA422	○	○	●		○	●	●		○		●	●	●		●	○		
MA425	○	○	●		○	●	●		○		●	●	●		●	○		
MA530	○	○	●		○	●	●	○			●	●	●		●	○		
MA560-1	○	○	●		○	●	●	○			●	●	●		●			
MA550	○	○	●		○	○	●		○		●	●	●		●			
MA590	○	○	●		○	●	●	○			●	●	●		●			
MA830	●	●	●		●	●	●				●	●	●		●	○	●	
MA832	●	●	●		●	●	●				●	●	●		●	○	●	
MA8110	●	●	●	●	●	●	●	●	○	●	●	●	●	●	●	○	○	
MA8120	●	●	●	●	●	●	●	●	○	●	●	●	●	●	●	○	○	
MA920	○	○	●		○	●	●		○		●	●	●		●	○		
MA1020	○	○	●		○	●	●		●		●	●	●		●	○		
MA1025	○	○	●		○	●	●		○		●	●	●		●	○		
MA2015 WHITE		○	●			●		○		●	●	●		●				
MA2030 WHITE		○	●			●	●		○		●	●	●		●			
MA2045 WHITE			●			●	●		○		●	●	●		●			
MA2045			●			●	●		○		●	●	●		●			
MA2230	●	●	●		●	●	●		○			●	●		●			
MA2245	●	●	●		●	●	●		○		●	●	●		●			

● = Preferred | ○ = Good (May require PC120 on metals) | Blank = Contact ITW PP Technical Services.

The technical information, recommendations, and other statements contained in this brochure are based upon good faith tests or experience that ITW Performance Polymers believes are reliable, but the accuracy or completeness of such information is not guaranteed The information provided is not intended to substitute for the customers' own testing.

Substrate Guide

	Metals										Plastics					Composites				
Product	Aluminium	Cast Iron	Copper	Cold Rolled Steel	Painted/Coated Metals	Plated Metals	Brass	Stainless Steel	ABS	Acrylics	Polyamides (Nylons)	Polycarbonate	Polyesters (PET, PBT)	Vinyls (PVC)	Gelcoats	Fibreglass	Phenolics	RTM	SMC	
Epoxy																				
1 Minute Epoxy Gel	○	●	○	●	●		○	○			○		○							
5 Minute Epoxy	○	●	○	●	●		○	○					○							
5 Minute Epoxy Gel	○	●	○	●	●		○	○					○							
10 Minute Epoxy	○	●	○	●	●	○	○	○	○				○		○					
2-Ton Epoxy	○	●	○	●	●	○	○	○					○		○					
HP 250	○	●	○	●	●	○	○	○		○		○	○		○	●			○	
Epoxy Plus 25	○	●	○	●	●	○	○	○		○	○		○	○	○	○	●		○	
Food Grade Pot & Seal	○	●	○	●	●		○	○					○							
MMA																				
Plastic Welder White	○	○		○	●			○	●	●	●	●	●	●	●	●	●	●	○	
PU																				
Devthane-2	○	○		○	●	○		○	●	●					●	●				
● = Preferred ○ = Good Blank = Contact ITW PP Technical Services.																				
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Substrate Guide																				
	Metals						Plastics						Composites					Other		
Product	Aluminium	Cold Rolled Steel	Painted / Coated Metals	Hot Dipped Galvanized	Stainless Steel	ABS	Acrylics	Polyamides (Nylons)	Polycarbonate	Polyesters	Vinyls (PVC)	Gelcoats	Fibreglass	Phenolics	RTM	SMC	Rubbers			
GPE 3	●	●	●		●	●	●	○	○	●	●	●	○	○	○	○	●			
GPE 30	●	●	●		●	●	●	○	○	●	●	●	○	○	○	○	●			
TE 2400	●	●	●	○	●	●	●	○	○	●	●	●	○	○	○	○	●			

● = Preferred | ○ = Good | Blank = Contact ITW PP Technical Services.

The technical information, recommendations, and other statements contained in this brochure are based upon good faith tests or experience that ITW Performance Polymers believes are reliable, but the accuracy or completeness of such information is not guaranteed The information provided is not intended to substitute for the customers' own testing.

Featured Products

Plexus MA8000 GB Series

Ideal for bonding galvanized & dissimilar materials

Plexus MA8000 GB series adhesives are advanced direct-to-metal, low halogen two-part methacrylate structural adhesives. They are designed for the structural bonding of various metals, coatings, plastics, and composite assemblies. They do a superb job of bonding metals without primers to other metals, engineered thermoplastics, and composite assemblies with little to no surface preparation. Combined at a 1:1 ratio by volume, MA8000 series adhesives can bond hot-dip and electrogalvanized zinc steel and other metals to dissimilar substrates. They provide an exceptional combination of high strength, toughness, environmental resistance, and fatigue endurance.

Plexus MA8105 GB

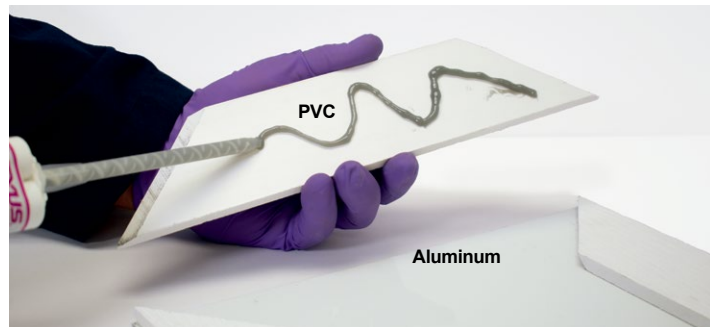
- Fast fixture time means more parts produced per hour

Plexus MA8110 GB

- Forms high strength bonds on more materials than any other product in the line.
- Requires little to no surface preparation.

Plexus MA8120 GB

- All the features of **MA8110** with a longer working and fixture time.
- Great for applications that need slightly longer elongation.



Plexus MA205HV

A high strength adhesive with an extremely fast working and fixture time

- Changes from blue to green indicating it's ready to be unclamped or sanded.
- Bonds to a wide variety of materials.
- Perfect for A-surfaces that may need to be painted or sanded.



Plexus MA2000 White Series

A UV and yellowing resistant adhesive that cures white

Plexus MMA white adhesives are two-part methacrylate adhesives formulated as an excellent UV and yellowing resistant white solution. Highly thixotropic with an ability dispense large non-sag beads. These products are designed for structural bonding of thermoplastic, metal, and composite assemblies in the marine and transportation industries. Combined at a 10:1 ratio, they require minimal, or no surface preparation and provide an exceptional combination of fatigue endurance, impact resistance and superior toughness.

Plexus MA2015 White

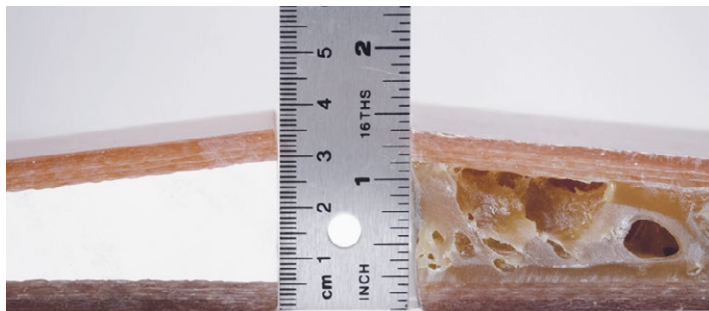
- Great for A-surface applications.
- Incredible strength and toughness on Fiber Reinforced Plastics.

Plexus MA2030 White

- Working time 26-34 mins.

Plexus MA2045 White

- A formulation of the **MA2015** with a longer working and fixture time.



MA2000 White (left) can fill 1" gaps without boiling

Plexus MA420W

A high strength, rapid curing adhesive with an extremely fast working and fixture time.

A two-part rapid-curing methacrylate adhesive designed for structural bonding of thermoplastic, metal, and composite assemblies providing a faster fixture time. Ideal for composite bonding applications in the transportation industry because it requires virtually no surface preparation. In addition, this product provides a unique combination of excellent fatigue endurance, outstanding impact resistance, and superior toughness.

- Excellent fatigue endurance, impact resistance and toughness.
- Outstanding shear strength on a variety of materials.



Product Properties

Product	Description	Working Time ¹ , min.	Fixture Time ² , (min.)	Tensile Strength, psi (MPa)	Tensile Elongation, %	Maximum Gap Fill, in. (mm)	Part A Viscosity, cP * 10 ³	Part B Viscosity, cP * 10 ³
MA205HV	Primerless to aluminum, ultra-fast fixture times	3 - 5	7 - 8	1,980 - 2,420 (13.8 - 17.2)	15 - 30	0.250 (6.35)	100 - 130	15 - 50
MA300	All purpose, high strength	3 - 6	10 - 13	3,510 - 4,290 (24.2 - 29.6)	20 - 40	0.125 (3.20)	40 - 70	40 - 70
MA310	All purpose, high strength	15 - 18	38 - 40	4,410 - 5,390 (24.1 - 31.0)	20 - 40	0.125 (3.20)	40 - 70	40 - 70
MA320	Low modulus, high elongation, high toughness	8 - 12	27 - 30	1,800 - 2,200 (11.7 - 15.2)	30 - 60	0.375 (9.52)	135 - 175	30 - 70
AO/MA420	All purpose, high strength, high toughness	4 - 6	15 - 17	2,430 - 2,970 (18.60 - 22)	20 - 40	0.375 (9.52)	80 - 100	50 - 80
MA420W	Rapid curing, high strength, high toughness	3 - 4	8 - 12	2,610 - 3,190 (18.6 - 20.7)	30 - 50	0.375 (9.52)	100 - 125	35 - 80
MA420FS	Ultra-fast for robotic applications	1 - 2	3 - 4	1,260 - 1,520 (8.6 - 10.3)	5 - 15	0.125 (3.17)	100 - 125	50 - 80
MA422	All purpose, high toughness	17 - 20	35 - 40	1,260 - 1,520 (18.6 - 20.7)	40 - 70	0.125 (9.52)	100 - 125	35 - 70
MA425	All purpose, high toughness	28 - 30	80 - 85	2,565 - 3,315 (13.8 - 17.9)	30 - 50	0.375 (9.52)	100 - 125	35 - 70
MA530	Highly thixotropic, high toughness	30 - 40	70 - 85	2,500 - 3,500 (17.2 - 24.1)	90-160	0.700 (17.78)	130 - 180	160 - 215
MA550	UV stable white	39 - 42	70 - 75	2,175 - 2,374 (14.9 - 16.4)	20 - 40	0.375 (9.52)	130 - 160	30 - 70
MA560-1	Highly thixotropic, high toughness	55-70	120 - 130	2,500 - 3,100 (17.2 - 21.3)	>130	1.000 (25)	145 - 185	170 - 205
MA590	Highly thixotropic, high toughness	90 - 105	135 - 140	2,000 - 2,500 (13.8 - 17.2)	>130	1.500 (38.10)	140 - 230	165 - 230
MA830	Primerless to aluminum, high strength	12 - 14	15 - 17	3,200 - 3,800 (22,0 - 26,2)	10 - 20	0.500 (12.70)	80 - 120	35 - 80
MA832	Primerless to aluminum, high strength	12 - 14	55 - 60	2,700 - 3,410 (19.2 - 23.5)	20 - 40	0.500 (12.70)	80 - 130	35 - 80
MA8110 GB	Next generation multi-material bonder, low odor	8 - 12	12 - 14	3,285 - 4,105 (22.4 - 27.2)	25 - 45	0.500 (12.70)	40 - 90	40 - 70
MA8120 GB	Next generation multi-material bonder, low odor	18 - 22	50 - 60	2,907 - 3,580 (17.2 - 20.6)	30 - 60	0.500 (12.70)	40 - 80	80 - 120
MA920	Low odor, high toughness	4 - 6	16 - 17	2,585 - 2,915 (16.4 - 20.1)	30 - 50	0.375 (9.52)	80 - 120	35 - 80
MA1020	Low odor, low shrink	5 - 8	8 - 10	1,305 - 1,585 (9.0 - 11.08)	10 - 20	0.375 (9.52)	100 - 130	35 - 80
MA1025	Low odor, low shrink	20 - 25	40 - 45	1,305 - 1,595 (9.7 - 12.4)	90 - 110	1.000 (25.40)	180 - 220	35 - 70
MA2015 White	UV stable white, highly thixotropic	15 - 18	25 - 30	2,875 - 3,603 (18.6 - 22.1)	21 - 54	1.500 (38.10)	180 - 220	35 - 70
MA2030 White	Highly thixotropic, high toughness	32 - 35	50 - 55	3,098 - 3,350 (21.4 - 23.2)	36 - 77	1.500 (38.10)	180 - 220	35 - 70
MA2045 White	UV stable white, highly thixotropic	45 - 50	90 - 95	2,200 - 2,900 (22.0 - 230.0)	36 - 77	1.500 (38.10)	180 - 220	35 - 70
MA2230	Low shrink, highly thixotropic, high toughness	40 - 42	70 - 90	2,160 - 2,640 (14.9 - 18.2)	40 - 80	1.500 (38.10)	180 - 220	35 - 70
MA2245	Low shrink, highly thixotropic, high toughness	40 - 50	100 - 130	2,160 - 2,640 (14.9 - 18.2)	40 - 80	1.500 (38.10)	180 - 220	35 - 70
MA2290	Low shrink, highly thixotropic, high toughness	100 - 110	160 - 165	2,340 - 2,860 (16.1 - 19.7)	40 - 80	1.500 (38.10)	180 - 220	35 - 80

1. The maximum allowable time to apply adhesive, mate, and position parts after mixing adhesive and activator at room temperature.

2. Time required for adhesive to generate sufficient bond strength to allow the parts to be handled without deformation of the bond line.

Featured Products

Devcon 5 Minute® Epoxy

A rapid-curing, general-purpose adhesive that forms hard, rigid bonds in minutes.

Devcon 5 Minute® Epoxy

- Cures fast for quick metal to metal bonds.
- Also suitable for wood, fabrics, ceramics, glass, and concrete.
- Easy to dispense and reaches functional strength within 1 hour.

Devcon 5 Minute® Epoxy Gel

- All the features of 5 Minute® Epoxy in a gel.
- Thixotropic, non-migrating gel adhesive.
- Excellent gap filling properties.



Devcon 2-Ton Epoxy

Two-part high strength, non-shrinking, weather resistance epoxy system.

- Once cured, adhesive has excellent resistance to water, solvents, and wide temperature cycles.
- Excellent impact resistance.
- Suitable for bonding ceramics, ferrous and non-ferrous metals, ferrites, wood, glass, and concrete.



Devcon Dev-Thane™ 2

Two-part urethane adhesive for high-performance bonding and sealing.

- Primerless solution joins and seals in one easy step.
- High tensile elongation makes it great for dissimilar substrates.
- Bonds to aluminum, steel, ABS, urethane, wood, glass and concrete.



Permatex TE 2400

Exceptional flexibility and thermal shock resistance

- High-viscosity, rubber-toughened, instant adhesive.
- Capable of bonding dissimilar materials.
- Provides enhanced toughness to peel and shock loads, even while filling large gaps.
- Humidity and water resistant.



Product Properties

Product	Working Time ¹ , min.	Fixture Time ² , min.	Shear Strength, psi (MPa)	Tensile Elongation, %	Impact Strength, ft-lb/in ² (J/cm ²)	Maximum Gap Fill, in. (mm)	Mixed Viscosity, cP * 10 ³	Operating Temperature, °F (°C)
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Epoxy

1 Minute Epoxy Gel	45 sec.	1	1,600 (11.0)	1	4.5 (0.95)	0.500 (12.70)	70	-40°F - 200°F (-40°C - 93°C)
5 Minute Epoxy	3 - 6	10 - 15	1,900 (13.1)	5	5.5 (1.16)	0.137 (3.48)	10	-40°F - 200°F (-40°C - 93°C)
5 Minute Epoxy Gel	4 - 7	10 - 15	2,500 (17.2)	1	6.5 (1.37)	0.137 (3.48)	Gel	-40°F - 200°F (-40°C - 93°C)
10 Minute Epoxy	10	20	2,400 (16.6)	5	10 (2.10)	0.500 (12.70)	80 - 90	-40°F - 200°F (-40°C - 93°C)
2-Ton Epoxy	8 - 12	30 - 35	2,250 (15.5)	1	6.5 (1.37)	0.500 (12.70)	8	-40°F - 200°F (-40°C - 93°C)
HP 250	65	360	3,200 (22.1)	25	12.3 (2.58)	0.980 (24.89)	105	-67°F - 250°F (-19°C - 121°C)
Epoxy Plus 25	25	120	2,750 (19.0)	20	10 (2.10)	0.700 (17.78)	70	-40°F - 200°F (-40°C - 93°C)
Food Grade Pot & Seal	42	10	1,940 (13.4)	1	5.2 (1.09)	0.375 (9.52)	100	-40°F - 275°F (-40°C - 135°C)

MMA

Plastic-Welder White	2-3	8 - 10	1,300 - 3,000 (9.0 - 20.7)	15 - 25	22 (4.62)	0.125 (3.17)	50	-67°F - 250°F (-19°C - 121°C)
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PU

Dev-Thane 2	2	20	630 - 2,750 (4.3 - 19.0)	100	N/A	1.000 (25.40)	45	-40°F - 200°F (-40°C - 93°C)
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Substrate Guide

Product	Viscosity, cP	Mixed Color	Type	Maximum Gap Fill, in. (mm)	Adhesive Tensile Shear, psi (MPa)	Operating Temperature, °F (°C)	Cure Speed, sec Steel / Plastic / Rubber
GPE 3	3	Clear	Ethyl	0.003 (0.08)	3,200 (22.1)	-65°F - 200°F (-54°C - 90°C)	5 - 10 / 3 - 5 / <2
GPE 30	30	Clear	Naomer Ethyl	0.004 (0.10)	3,200 (22.1)	-65°F - 200°F (-54°C - 90°C)	5 - 12 / 5 - 13 / <6
TE 2400	2400	Clear	Ethyl	0.009 (0.23)	3,700 (25.5)	-65°F - 280°F (-54°C - 138°C)	40 - 70 / 25 - 50 / 25 - 50

1. The maximum allowable time to apply adhesive, mate, and position parts after mixing adhesive and activator at room temperature.
2. Time required for adhesive to generate sufficient bond strength to allow the parts to be handled without deformation of the bond line.

Ordering Guide

Product	Available Sizes	Color	Item Number	Items Per Case	Mix Ratio	Dispenser	Nozzle
MA205HV	490 ml Cartridge	BLUE	IT025X	12	10:1	30016/30013	30076/30077
MA300	25 ml Twin Cartridge	STRAW	14300	12	1:1	N/A	N/A
	50 ml Twin Cartridge	BLACK	IT410	12	1:1	14280	14285
	50 ml Twin Cartridge	STRAW	30500	12	1:1	14280	14285
	400 ml Twin Cartridge	BLACK	IT412	12	1:1	30020/30010	30095/3333
	400 ml Twin Cartridge	STRAW	30000	12	1:1	30020/30010	30095/3333
	5 gal Pail Adhesive	STRAW	IT405	1	1:1	Consult ITWPP Technical Services	
	5 gal Pail Activator	STRAW	IT406	1	1:1		
	50 gal Drum Adhesive	STRAW	IT407	1	1:1		
	50 gal Drum Activator	STRAW	IT408	1	1:1		
MA310	50 ml Twin Cartridge	STRAW	31500	12	1:1	14280	14285
	400 ml Twin Cartridge	STRAW	31000	12	1:1	30020/30010	30095/3333
	5 gal Pail Adhesive	STRAW	IT435	1	1:1	Consult ITWPP Technical Services	
	5 gal Pail Activator	STRAW	IT406	1	1:1		
	50 gal Drum Adhesive	STRAW	IT437	1	1:1		
	50 gal Drum Activator	STRAW	IT408	1	1:1		
MA320	490 ml Cartridge	BLACK	32000BX	12	10:1	30016/30013	30076/30077
	490 ml Cartridge	STRAW	32000X	12	10:1	30016/30013	30076/30077
	490 ml Cartridge	WHITE	32000WX	12	10:1	30016/30013	30076/30077
	5 gal Pail Adhesive	STRAW	32200	1	10:1	Consult ITWPP Technical Services	
	5 gal Pail Activator	STRAW	32420	1	10:1		
	5 gal Pail Activator	BLACK	32910	1	10:1		
	5 gal Pail Activator	WHITE	35420	1	10:1		
	50 gal Drum Adhesive	STRAW	32800	1	10:1		
A0/MA420	490 ml Cartridge	BLACK	35701	12	10:1	30016/30013	30076/30077
	490 ml Cartridge	BLUE	IT101BX	12	10:1	30016/30013	30076/30077
	490 ml Cartridge	STRAW	IT101X	12	10:1	30016/30013	30076/30077
	5 gal Pail Adhesive	STRAW	IT102	12	10:1	Consult ITWPP Technical Services	
	5 gal Pail Activator	STRAW	IT112	1	10:1		
	5 gal Pail Activator	BLUE	IT114	1	10:1		
	5 gal Pail Activator	BLACK	IT140	1	10:1		
	50 gal Drum Adhesive	STRAW	IT100	1	10:1		
MA420FS	490 ml Cartridge	BLUE	IT800X	12	10:1	30016/30013	30076/30077
	490 ml Cartridge	BLACK	IT804X	12	10:1	30016/30013	30076/30077
	5 gal Pail Activator	STRAW	IT112	1	10:1	Consult ITWPP Technical Services	
	5 gal Pail Activator	BLUE	IT114	1	10:1		
	5 gal Pail Activator	BLACK	IT140	1	10:1		
	50 gal Drum Adhesive	STRAW	IT801	1	10:1		
MA420W	490 ml Cartridge	BLUE	42000	12	10:1	30016/30013	30076/30077
	50 gal Drum Adhesive	STRAW	42002	1	10:1	Consult ITWPP Technical Services	
	5 gal Pail Activator	BLUE	IT114	1	10:1		
MA422	490 ml Cartridge	BLUE	IT133	12	10:1	30016/30013	30076/30077
	5 gal Pail Adhesive	STRAW	IT132	1	10:1	Consult ITWPP Technical Services	
	5 gal Pail Activator	BLUE	IT159	1	10:1		
MA425	490 ml Cartridge	BLUE	IT151X	12	10:1	30016/30013	30076/30077
	5 gal Pail Adhesive	STRAW	IT152	1	10:1	Consult ITWPP Technical Services	
	5 gal Pail Activator	BLUE	IT159	1	10:1		
	50 gal Drum Adhesive	STRAW	IT150	1	10:1		

Product	Available Sizes	Color	Item Number	Items Per Case	Mix Ratio	Dispenser	Nozzle
MA530	400 ml Twin Cartridge	GRAY	53000	12	1:1	30020/30010	30095/3333
	400 ml Twin Cartridge	WHITE	53500	12	1:1	30020/30010	30095/3333
	5 gal Pail Adhesive	WHITE	IT203	1	1:1	Consult ITWPP Technical Services	
	5 gal Pail Activator	BLACK	IT205	1	1:1		
	50 gal Drum Adhesive	WHITE	IT200	1	1:1		
	50 gal Drum Activator	BLACK	IT206	1	1:1		
MA550	490 ml Cartridge	WHITE	35000X	12	10:1	30016/30013	30076/30077
	5 gal Pail Adhesive	STRAW	35200	1	10:1	Consult ITWPP Technical Services	
	5 gal Pail Activator	WHITE	35420	1	10:1		
	50 gal Drum Adhesive	STRAW	35800	1	10:1		
MA560-1	400 ml Twin Cartridge	GRAY	56000	12	1:1	30020/30010	30095/3333
	400 ml Twin Cartridge	WHITE	56500	12	1:1	30020/30010	30095/3333
	5 gal Pail Adhesive	WHITE	IT213	1	1:1	Consult ITWPP Technical Services	
	5 gal Pail Activator	BLACK	IT219	1	1:1		
	50 gal Drum Adhesive	WHITE	IT210	1	1:1		
	50 gal Drum Activator	BLACK	IT211	1	1:1		
MA590	400 ml Twin Cartridge	GRAY	59000	12	1:1	30020/30010	30095/3333
	5 gal Pail Adhesive	WHITE	IT177	1	1:1	Consult ITWPP Technical Services	
	5 gal Pail Activator	BLACK	IT178	1	1:1		
	50 gal Drum Adhesive	WHITE	IT170	1	1:1		
	50 gal Drum Activator	BLACK	IT175	1	1:1		
MA830	35 ml Cartridge	GRAY GB	35839	25	10:1	14280	14285
	490 ml Cartridge	GRAY	IT186X	12	10:1	30016/30013	30076/30077
	490 ml Cartridge	GRAY GB	IT187X	12	10:1	30016/30013	30076/30077
	5 gal Pail Adhesive	STRAW	IT185	1	10:1	Consult ITWPP Technical Services	
	5 gal Pail Activator	GRAY	IT262	1	10:1		
	5 gal Pail Activator	GRAY GB	IT284	1	10:1		
	50 gal Drum Adhesive	STRAW	IT188	1	10:1		
MA832	490 ml Cartridge	GRAY	IT332X	12	10:1	30016/30013	30076/30077
	490 ml Cartridge	GRAY GB	IT331X	12	10:1	30016/30013	30076/30077
	5 gal Pail Adhesive	STRAW	IT330	1	10:1	Consult ITWPP Technical Services	
	5 gal Pail Activator	GRAY	IT262	1	10:1		
	5 gal Pail Activator	GRAY GB	IT284	1	10:1		
	50 gal Drum Adhesive	STRAW	IT333	1	10:1		

Contact Technical Services for equipment recommendations: NA: +1 855 489 7262 | EMEA: +353 61 771 500

Ordering Guide

Product	Available Sizes	Color	Item Number	Items Per Case	Mix Ratio	Dispenser	Nozzle
MA8105 GB	50 ml Cartridge	GRAY	81057	12	1:1	14280	14285
	400 ml Cartridge	GRAY	81058	12	1:1	30020/30010	30095/3333
	5 gal Pail Adhesive	GRAY	81055	1	1:1	Consult ITWPP Technical Services	
	50 gal Drum Adhesive	GRAY	81059	1	1:1		
	5 gal Pail Activator	GRAY	81053	1	1:1		
	50 gal Drum Activator	GRAY	81054	1	1:1		
MA8110 GB	50 ml Cartridge	GRAY	81111	12	1:1	14280	14285
	400 ml Twin Cartridge	GRAY	81108	12	1:1	30020/30010	30095/3333
	5 gal Pail Adhesive	GRAY	81105	1	1:1	Consult ITWPP Technical Services	
	5 gal Pail Activator	GRAY	81103	1	1:1		
	50 gal Drum Adhesive	GRAY	81109	1	1:1		
	50 gal Drum Activator	GRAY	81104	1	1:1		
MA8120 GB	50 ml Cartridge	GRAY	81211	12	1:1	14280	14285
	400 ml Twin Cartridge	GRAY	81208	12	1:1	30020/30010	30095/3333
	5 gal Pail Adhesive	GRAY	81105	1	1:1	Consult ITWPP Technical Services	
	5 gal Pail Activator	GRAY	81203	1	1:1		
	50 gal Drum Adhesive	GRAY	81109	1	1:1		
	50 gal Drum Activator	GRAY	81204	1	1:1		
MA920	490 ml Cartridge	BLUE	35900X	12	10:1	30016/30013	30076/30077
	5 gal Pail Activator	STRAW	IT112	1	10:1	Consult ITWPP Technical Services	
	5 gal Pail Activator	BLUE	IT114	1	10:1		
	5 gal Pail Activator	BLACK	IT140	1	10:1		
	50 gal Drum Adhesive	STRAW	35910	1	10:1		
MA1020	490 ml Cartridge	BLUE	IT222X	12	10:1	30016/30013	30076/30077
	5 gal Pail Adhesive	STRAW	IT220	1	10:1	Consult ITWPP Technical Services	
	5 gal Pail Activator	BLUE	IT114	1	10:1		
	50 gal Drum Adhesive	STRAW	IT225	1	10:1		
MA1025	490 ml Cartridge	BLUE	IT232X	12	10:1	30016/30013	30076/30077
	5 gal Pail Adhesive	STRAW	IT236	1	10:1	Consult ITWPP Technical Services	
	5 gal Pail Activator	BLUE	IT237	1	10:1		
	50 gal Drum Adhesive	STRAW	IT235	1	10:1		
MA2015 WHITE	490 ml Cartridge	WHITE	20155	12	10:1	30016/30013	30076/30077
MA2030 WHITE	490 ml Cartridge	WHITE	20305	1	10:1	30016/30013	30076/30077
MA2045 WHITE	490 ml Cartridge	WHITE	20455	12	10:1	30016/30013	30076/30077
MA2045	490 ml Cartridge	BLUE	IT248X	12	10:1	30016/30013	30076/30077
	5 gal Pail Activator	BLUE	IT247	1	10:1	Consult ITWPP Technical Services	
	50 gal Drum Adhesive	STRAW	IT209	1	10:1		
MA2230	5 gal Pail Activator	BLUE	IT247	1	10:1	Consult ITWPP Technical Services	
	5 gal Pail Activator	BLACK	IT496	1	10:1		
	50 gal Drum Adhesive	CREAM	22303	1	10:1		
MA2245	490 ml Twin Cartridge	BLUE	22450	12	10:1	30016/30013	30076/30077
	490 ml Twin Cartridge	BLACK	22451	12	10:1	30016/30013	30076/30077
	5 gal Pail Activator	BLUE	IT247	1	10:1	Consult ITWPP Technical Services	
	5 gal Pail Activator	BLACK	IT496	1	10:1		
	50 gal Drum Adhesive	CREAM	32245	1	10:1		
MA2290	490 ml Twin Cartridge	BLUE	22901	12	10:1	Consult ITWPP Technical Services	
	50 gal Drum Adhesive	CREAM	22903	1	10:1		

Ordering Guide

Product	Available Sizes	Mixed Color	Item Number	Items Per Case	Mix Ratio	Dispenser	Nozzle
Epoxy							
1 Minute® Epoxy Gel	50 ml Cartridge	CLEAR	14277	12	1:1	14280 (manual)	14285
5 Minute® Epoxy	25 ml Dev-Tube™	CLEAR	14250	24	1:1	N/A	N/A
	50 ml Cartridge	CLEAR	14270	12	1:1	14280 (manual)	14285
	2.5 oz	CLEAR	14210	24	1:1	N/A	N/A
	400 ml Cartridge	CLEAR	DA051	12	1:1	30020 (manual)	3333
	15 oz	CLEAR	14200	6	1:1	N/A	N/A
	9 lb	CLEAR	14630	1	1:1	N/A	N/A
5 Minute® Epoxy Gel	25 ml Dev-Tube™	OPAQUE	14240	24	1:1	N/A	N/A
	50 ml Cartridge	OPAQUE	14265	12	1:1	14280 (manual)	14285
	400 ml Cartridge	OPAQUE	DA052	12	1:1	30020 (manual)	30095
10 Minute® Epoxy	50 ml Cartridge (Clear)	BLACK	14251	12	1:1	14280 (manual)	14285
	50 ml Cartridge (Black)	CLEAR	14255	12		14280 (manual)	14285
2-Ton Epoxy	25 ml Dev-Tube™	CLEAR	14310	24	1:1	N/A	N/A
	50 ml Cartridge	CLEAR	14260	12	1:1	14280 (manual)	14285
	400 ml Cartridge	CLEAR	14355	12	1:1	30020 (manual)	3333
	9 lb	CLEAR	14360	1	1:1	N/A	N/A
HP 250	50 ml Cartridge	STRAW	14315	12	2:1	14280 (manual)	14285
	400 ml Cartridge	STRAW	14415	1	2:1	30020 (manual)	30095
Epoxy Plus 25	50 ml Cartridge	GRAY	14278	12	1:1	14280 (manual)	14285
Food Grade Pot & Seal	400 ml Cartridge	WHITE	DA999	6	4:1	15043	15047
MMA							
Plastic-Welder White	50 ml Cartridge	WHITE	DA291	12	1:1	14280 (manual)	14285
	400 ml Cartridge	WHITE	DA160	12	1:1	30020	3333
PU							
Dev-Thane-2	400 ml Cartridge	GRAY	14510	10	1:1	30020	3333

Contact Technical Services for equipment recommendations: NA: +1 855 489 7262 | EMEA: +353 61 771 500



Ordering Guide

Product	Available Sizes	Item Number	Items Per Case
GPE 3	14g bottle	70144	12
GPE 30	1 oz. bottle	70350	10
TE 2400	1 oz. bottle	72250	10

Why Choose Plexus Adhesives?

Engineers are always looking for better ways to assemble parts and design joints. When evaluating joining methods, there are several critical factors:

- How much force will the joint see?
- How long is the joint expected to last?
- Will the joint be permanent?
- How long will it take to assemble?
- How much will it cost to assemble?
- What type of labor will it require?

When it comes to permanent joints, engineers have traditionally relied on two choices: Mechanical fasteners or welding. But today, there is a third proven choice that offers several advantages over traditional fastening methods: Adhesives.

Adhesives Join Materials without Adding Holes or Heat Affected Zones

Like rivets or welding, Plexus adhesives provide a permanent way to bond to materials. In fact, there are many occasions when a Plexus adhesive will prove to be a stronger joint than these methods.

However, strength isn't the only important property. Engineers must still consider numerous factors like: How long the joint is expected to last, how long the joint takes assemble, and how much the joining method costs in terms of both materials and labor.

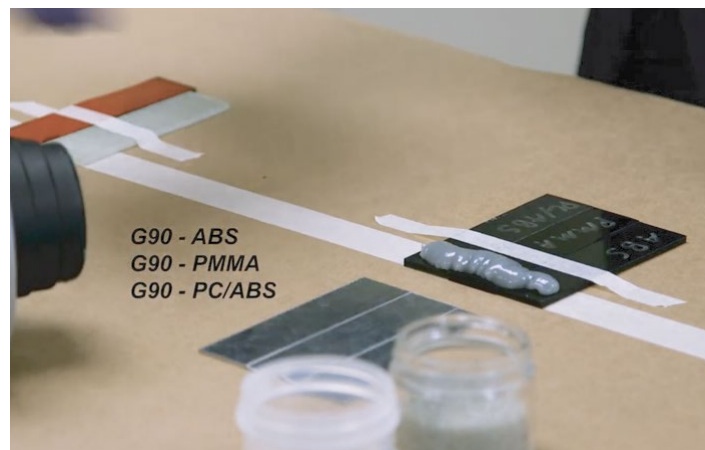
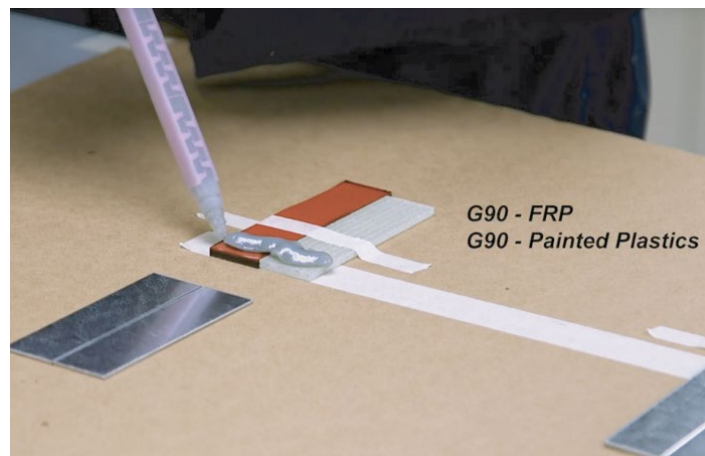
Across many of these factors, Plexus adhesives perform better than mechanical fasteners for several reasons:

Continuous Connections

Adhesives uniformly distribute stress, improving not only the joint strength, but overall durability. Rivets concentrate the stress, weakening the joint and reducing the overall durability.

Fast Assembly

Dispensing an adhesive is fast; often they are significantly faster surface distortions. Just a clean, smooth surface.



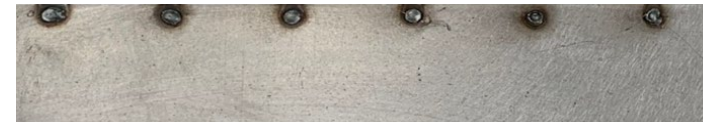
Plexus MA 8100 testing shows bonding of composites, metals and dissimilar substrates

Contact Technical Service Department for help replacing inconsistent welds or weak rivets with Plexus adhesive:
NA: +1 855 489 7262 | EMEA: +353 61 771 500

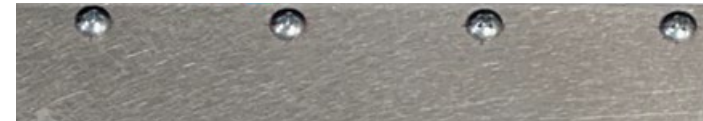
Benefits of Plexus Adhesives



Welding



Rivets



Screws



Bolts



Adhesives

Strength of Plexus Adhesives vs. Welding

Plexus adhesives have successfully replaced welding in a variety of structural applications. Continuous weld lines often lead to significant heat distortion and heat affected zones on the sheet metal. These distortions can weaken the overall strength and durability of the joint. As a result, the strength of a weld can vary significantly compared to bonding metal to metal with an adhesive. Welding thin sheet metal to thick gauge can cause serious distortion, whereas with Plexus there is no warping.

Eliminate Welding Distortion



The Right Design is Important When Switching to Plexus Adhesives to Glue Metal to Metal

Butt, Corner and Tee Joints may be suitable for welding, but the design will likely need to be modified to accommodate adhesive bonding. Fortunately, the changes are usually minor, and we have an expert staff of engineers in our Technical Service Department that would be happy to help you select the right design.

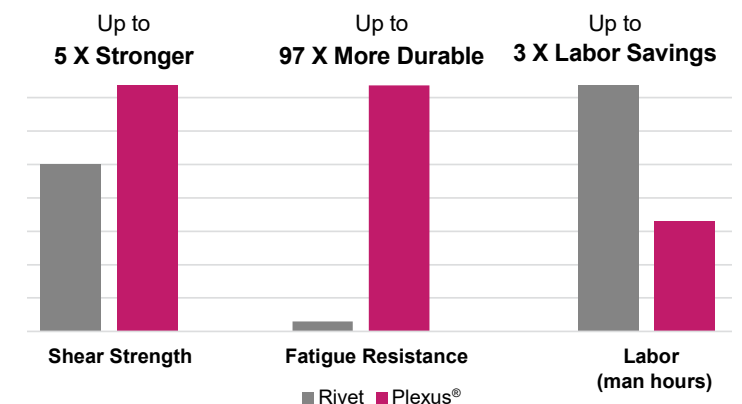
Strength of Plexus Adhesives vs. Rivets

Plexus adhesives have successfully replaced rivets in a variety of structural applications. The strength of a joint with rivets depends on the size of the rivet, the spacing of the rivet, and the gauge of the metal.

The Biggest Challenge Related to Durability with Rivets is Stress Concentration

Drilling a hole through the material to place the rivet concentrates any loads experienced by the joint on that rivet.

Contrast that with a Plexus metal to metal adhesive. The adhesive provides a continuous connection, so the load can be evenly distributed across the joint. As such, Plexus adhesive achieves a much higher joint strength. One customer replaced rivets for joining their roof and found Plexus adhesives to be stronger, more durable and reduce their labor. Significantly stronger than rivets when joining metal to thermosets, thermoplastics, and fiber reinforced plastics.



Stiffer Structures with Thinner Materials

The continuous bond line and increased surface area of connection means you can use a thinner metal or plastic without losing stiffness.

Corrosion Protection

Plexus adhesives join and form a watertight seal in one step. No leak paths will be able to form. Additionally, the adhesive provides a barrier to electron transfer between the two different materials, preventing galvanic corrosion.

Chemistry Guide

Chemistry	MMA	Epoxy	Urethane	Cyanoacrylate
Temperature Resistance, °F (°C)				
Typical Temp Resistance	-40 - 180 (-40 - 82)	-40 - 250 (-40 - 121)	-40 - 180 (-40 - 82)	-40 - 200 (-40 - 93)
Chemical Resistance				
Polar Solvents	++	++	++	+
NonPolar Solvents	++	+++	++	++
Adhesion				
Raw Metals	+++	++	+	++
Coated Metals	+++	++	+++	+++
Thermoplastics	+++	+	++	+++
Composites	+++	++	++	
Wood	++	++	+++	+++
Urethane Foam	+	+	+++	+
Lapshear Strength	++	+++	+	++
Peel Strength	++	+	+++	+
Elongation	++	+	+++ / ++	+
Hardness	Semi-Rigid	Rigid	Semi-Rigid	Rigid
Gap Fill, inches (mm)				
Ideal	0.01 - 0.04 (0.25 - 1)	≤0.01 (<0.25mm)	0.005 – 0.03 (0.12 – 0.75)	0.001 – 0.009 (0.03 – 0.23)
Max Gap	0.250 (6.35)	0.250 (6.35)	0.250 (6.35)	0.250 (6.35)
Processing				
Room Temp Cure	++	+	+	+++
Heat Accelerated Cure		++	+++	N/A
Surface Prep Metals	++	++	+	++
Surface Prep Plastics	++	+	++	+++
Surface Prep Composites	+++ / ++	++	++	N/A
Exo-Therm Temp	High	Low-Med	Low	Med-High
Odor	High	Med-Low	Low	Med

+++ = Preferred | ++ = Good | + = Not Recommended

The technical information, recommendations, and other statements contained in this brochure are based upon good faith tests or experience that ITW Performance Polymers believes are reliable, but the accuracy or completeness of such information is not guaranteed. The information provided is not intended to substitute for the customers' own testing.

Dispensing Equipment

Dispensers	Adhesive Sizes	Adhesive Ratios	Manual or Pneumatic	Item Number
Mark V™ Manual Dispensing Gun	50/35 ml cartridges	1:1, 2:1, 10:1	Manual	14280
Manual Cartridge Dispensing Gun	400 ml	1:1, 2:1	Manual	30020
Pneumatic Cartridge Dispensing Gun	400 ml	1:1, 2:1	Pneumatic	30010
Manual Cartridge Dispensing Gun	490 ml	10:1	Manual	30016
Pneumatic Cartridge Dispensing Gun	490 ml	10:1	Pneumatic	30013

Mix Tips	Adhesive Sizes	Adhesive Ratios	Amount Per Pack	Item Number
Mark V™ Mix Nozzle	50/35 ml cartridges	1:1, 2:1, 10:1	12	14285
Static Mix Nozzle	400 ml	1:1, 2:1, 10:1	12	3333
Stati Mix Nozzle 500 Series	400 ml	1:1, 2:1	200	30095
Static Mix Nozzle	490 ml	10:1	12	30076
Mix Nozzle	490 ml	10:1	600	30077



Approved Equipment Manufacturers

For more information, please contact:

GS Manufacturing
985 W. 18th Street
Costa Mesa, CA 92627
Phone: (949) 642-1500
E-mail: gsmfg@pacbell.net
gsmfg.com

MVP Corporate Headquarters
10535 Hardin Valley Road
Knoxville, TN 37932
Phone: (865) 686-5670
E-mail: info@mvpind.com
mvpind.com

References

Devcon® Mil-Spec, UL and Other Government Specifications

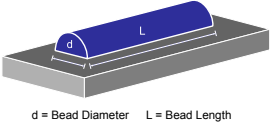
Product Category	Specifications	Product	Part #	Size
Devcon® Silicone Adhesive Sealants	A-46106A	Silite® Silicone RTV-Clear	17150	10.3 oz Cartridge
		Silite® Silicone RTV (High Temp.)	17130	10.3 oz Cartridge
Devcon® Metal Repair Compounds	MIL-PRF-24176C, Type I	Plastic Steel® Putty (A)	10110	1 lb
			10120	4 lb
		Titanium Putty	10760	1 lb
			10770	2 lb
		Ceramic Repair Putty	11700	3 lb
	MIL-PRF-24176C, Type II	Aluminum Putty (F)	10610	1 lb
			10620	3 lb
	MMM-A-1754	Plastic Steel® Liquid (B)	10210	1 lb
			10220	4 lb
		Aluminum Liquid (F-2)	10710	1 lb
			10720	3 lb

Devcon® ABS Type Approved Products

Product Category	ABS	Product	Part #	Size
Devcon® Urethane Repair Compounds	ABS	Flexane Brushable	15350	1 lb
Devcon® Metal Repair Putties	ABS	Plastic Steel® Putty (A)	10110	1 lb
			10120	4 lb
			10130	25 lb
		Plastic Steel® 5 Minute® Putty (SF)	10240	1 lb
		Aluminum Putty (F)	10610	1 lb
			10620	3 lb
		Titanium Putty	10760	1 lb
			10770	2 lb
		Stainless Steel Putty (ST)	10270	1 lb
		Bronze Putty (BR)	10260	1 lb
Devcon® Metal Repair Liquids/ Wearing Compounds	ABS	Ceramic Repair Putty	11700	3 lb
		Plastic Steel® Liquid (B)	10210	1 lb
			10220	4 lb
			10230	25 lb
		Aluminum Liquid (F2)	10710	1 lb
			10720	3 lb
		Brushable Ceramic Red	11760	2 lb
			11762	12 lb
		Brushable Ceramic Blue	11765	2 lb
			11767	12 lb
		Brushable Ceramic White	11770	2 lb

Bead Length² (inches)

Bead Diameter	50 ml	300 ml	490 ml	400 ml	1 lb	1 gal ³
1/4"	10.3"	61.7"	82.7"	78.8"	89.4"	787.5"
3/8"	4.7"	27.9"	37.3"	35.0"	39.8"	350.0"
1/2"	2.5"	15.0"	20.0"	19.2"	22.1"	196.7"
5/8"	1.7"	10.0"	13.3"	12.6"	14.3"	125.8"



Devcon® Registered Products

Product Category	NSF Approval	Product	Part #	Size
Devcon® Silicone Adhesive Sealants	NSF/ ANSI 51	Silite® Silicone RTV-Clear	17150	10.3 oz Tube
		Silite® Silicone RTV (High Temp.)	17130	10.3 oz Tube
Devcon® Metal Repair Compounds	NSF/ ANSI 61	Stainless Steel Putty	10270	1 lb
		Brushable Ceramic (White)	11770	2 lb
Devcon® Flooring Repair	R2	Floor Patch™	13100	10 lb
		Epoxy Coat™ 7000 Non VOC	13120	40 lb
			12710	2 gal



Plexus® ABS Type Approved Products

Product Category	ABS	Product	Part #	Size
Plexus® Adhesives	ABS	MA425 Cartridge	IT151X	490 ml
		MA425 Adhesive	IT152 / IT150	5 / 50 gal
		MA425 Activator	IT159	5 gal
		MA530 Cartridge Gray / White	53000 / 53500	400 ml
		MA530 Adhesive	IT203 / IT200	5 / 50 gal
		MA530 Activator	IT205 / IT206	5 gal
		MA550 Cartridge	35000X	490 ml
		MA550 Activator	35420	5 gal
		MA550 Adhesive	35200 / 35800	5 / 50 gal
		MA560-1 Cartridge Black /White	56000 / 56500	400 ml
		MA560-1 Adhesive	IT213 / IT210	5 / 50 gal
		MA560-1 Activator	IT219 / IT211	5 / 50 gal
		MA590 Cartridge	59000	400 ml
		MA590 Adhesive	IT177 / IT170	5 / 50 gal
		MA590 Activator / Activator White	IT178 / 50003	5 gal
		MA590 Activator	IT175	50 gal
		MA2245 Cartridge Blue / Black	22450 / 22451	490 ml
		MA2245 Adhesive	32245	50 gal

Permatex® Mil-Spec, UL and Other Government Specifications

Product Category	Specification	Product	Part #	Size
Permatex® ZIP GRIP® Instant Adhesives	A-A-3097, Type II, Class 1	GPE 3 Wicking	70144	14 g bottle
			70145	2 g tube
	A-A-3097, Type II, Class 3	GPE 30 All Purpose	70350	1 oz bottle
		TE 1000 Gap Filling	72161	1 lb bottle
Permatex® Threadlockers Liquids	S-46163A, Type II, Grade N	TE 2400 Gap Filling-Hi Temp	72250	1 oz bottle
	S-46163A, Type II, Grade O	Medium Strength Threadlocker BLUE	24210	10 ml bottle
			24250	50 ml bottle
	S-46163A, Type I, Grade K	Permanent Strength Threadlocker RED	26210	10 ml bottle
			26250	50 ml bottle
	S-46163A, Type III, Grade R	High Strength Threadlocker RED	27110	10 ml bottle
			27150	50 ml bottle
		Penetrating Grade Threadlocker GREEN	29025	250 ml bottle
Permatex® Silicone Adhesive Sealants	A-46106B, Type I	Clear RTV Silicone Adhesive Sealant	80050	3 oz tube
			81913	7.25 oz Automatic Tube®
			80855	11 oz cartridge
		High Temp Red RTV Silicone Gasket	85915	7.25 oz PowerBead™ can
			81409	11 oz cartridge
			81158	3 oz tube
		Black Silicone Adhesive Sealant	81173	12.9 oz cartridge

Permatex® NSF Registered Products

Product Category	NSF® Approval	Product	Part #	Size
Permatex® Liquid Threadlockers	P1	Medium Strength Threadlocker BLUE	24210	10 ml Bottle
			24250	50 ml Bottle
		Permanent Strength Threadlocker RED	26210	10 ml Bottle
			26250	50 ml Bottle
Permatex® Gel Threadlockers	P1	Medium Strength Threadlocker BLUE	24010	10 g Gel Twist™ Carded
		High Strength Threadlocker RED	27010	10 g Gel Twist™ Carded
Permatex® Thread Sealants	P1	High Performance Thread Sealant	56521	50 ml tube, Carded
			56525	250 ml Tube
Permatex® Retaining Compounds	P1	Bearing Mount for Relaxed Fits	68050	50 ml Bottle
Permatex® Gasket Makers	P1	ULTRA BLUE® RTV Silicone Gasket Maker	81724	3.35 oz tube, Carded
			81725	13 oz Cartridge
		The Right Stuff ® Gasket Maker	25224	7 oz Automatic Tube
			29208	5 oz Cartridge
			85224	9.5 oz PowerBead™ Can
			33694	10.1 fl oz Cartridge
		Anaerobic Gasket Maker	51813	50 ml tube, Carded

SDS/TDS: Access SDSs and TDSs from our website: itwpp.com. Select the product brand to search.

Exclusions of warranties:

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