

## ***The Problem: Fasteners & Welding***

- Are unable to join certain dissimilar materials
- May result in stress cracking leading to shortened vehicle life
- May cause galvanic corrosion with joined aluminum and steel components
- May cause weld distortion, preventing Class A finishes

## ***The Solution: Plexus® Adhesives***

- Enable primerless adhesion to multiple materials
- Distribute stress with unparalleled durability
- Enable use of non-corrosive materials like composites, thermoplastics and aluminum
- Create clean “class A” surfaces

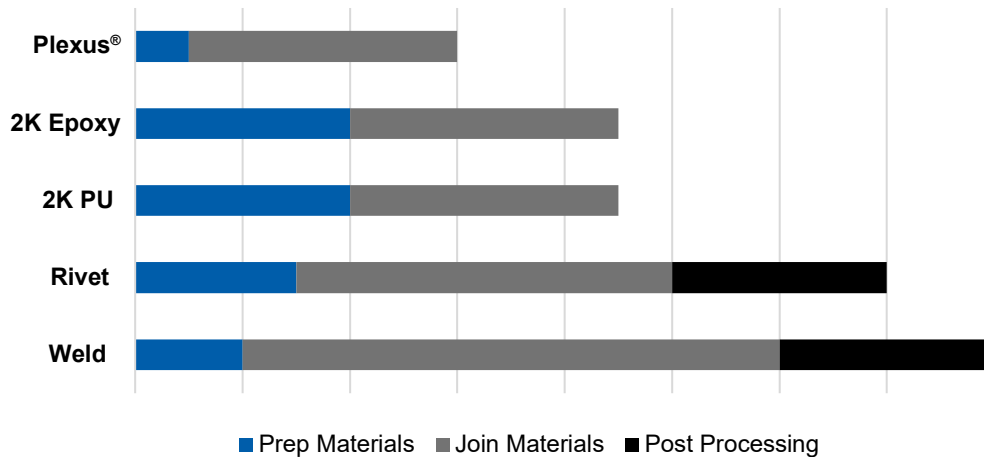


# Structural Bonding Solutions for Construction Vehicles

Product	Chemistry	Description	Mix ratio by volume	Working time, mins	Tensile strength, psi	Tensile elongation %															
							Aluminum	Raw Steel	E-Coated	Galvaneal	Stainless Steel	Cast Iron	ABS	Nylon	FRP	DCPD	SMC				
MA8110 GB	MMA	Bracket bonding, multimaterial bonding	1:1	8 - 12	3,285 (22.7)	25 - 45	++	++	++	++	++	++	++	++	++	++	++	++	++	++	+
MA8120 GB	MMA	Bracket bonding, multimaterial bonding	1:1	18 - 22	2,907 (20.5)	30 - 60	++	++	++	++	++	++	++	++	++	++	++	++	++	++	+
MA420	MMA	Composite and thermoplastic bonding	10:1	4 - 6	2,430 (16.8)	20 - 40	+*	+*	++	-	++	-	++	-	++	++	++	++	++	+	
MA320	MMA	Composite and thermoplastic bonding	10:1	8 - 12	1,800 (12.4)	30 - 60	+*	+*	++	-	++	-	++	-	++	++	++	++	++	+	
MA422	MMA	Composite bonding, aluminum to painted steel	10:1	17 - 20	2,430 (16.8)	75 - 100	+*	+*	++	-	++	-	++	-	++	++	++	++	++	+	
PU2105	PU	Rigid paintable seam sealer	1:1	3 - 4	4,060 (28.0)	5	++	+	++	++	++	-	-	-	++	++	++	++	++	+	
AC1700	Polyester	Sprayable body filler, fills pinholes on castings	2%	3 - 6	n/a	n/a	++	++	-	++	+	++	-	-	++	-	-	++	-	-	

++ Excellent adhesion with no to little surface preparation. + Good adhesion with some surface preparation. - Not recommended. \* Use PC120 Cleaner Conditioner for optimum long term environmental durability

## Relative Labor Spent to Assemble



## Plexus Adhesives

- Ensure great stress distribution and fatigue resistance for optimal durability
- Have excellent weather resistance
- Offer high elongation enabling dissimilar material joining

