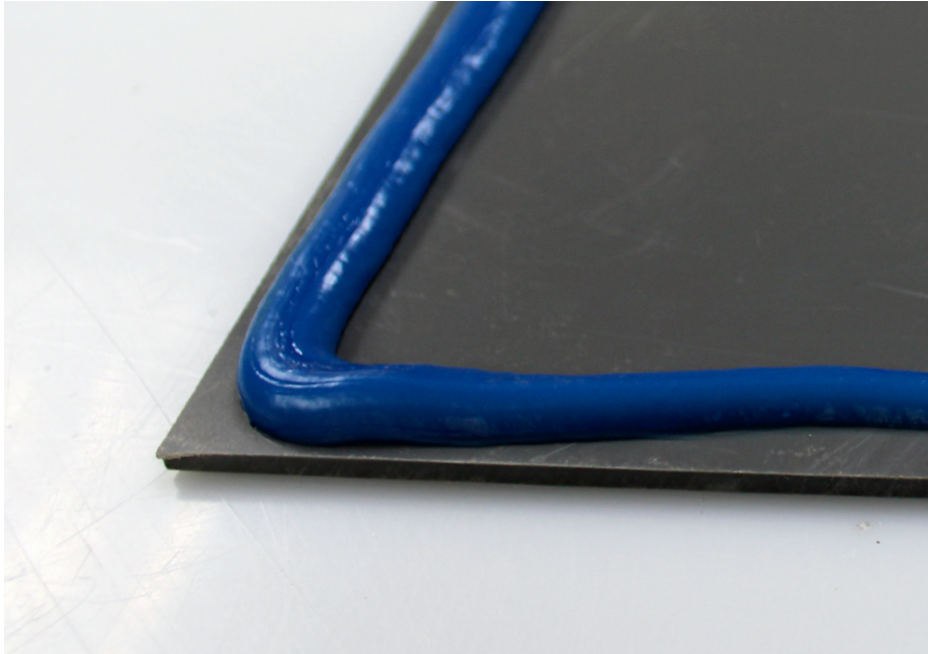


# PLEXUS<sup>®</sup> MA420W Rapid Curing Structural Adhesive



## Fast Curing, Easy to Use Structural Adhesive



Plexus MA420W is a result of more than 35 years of experience creating and formulating high performance, two-part, rapid curing methacrylate adhesives. This fast-curing adhesive reduces assembly time, resulting in higher throughput and consistent, reliable production.

### Benefits

#### Standard Choice for Structural Bonding

Bonds metals, thermoplastics, coated metals (powder-coated or e-coated), and composites with little to no surface preparation.

#### Rapid Curing

Fast, consistent strength development.

#### Faster Unclamp Times

Parts are ready to move in 10 - 14 min (50 - 1,000 psi / 0.3 - 6.9 MPa).

#### Easy to Use

Thixotropic bead that does not sag.

#### High Durability

Proven resilience, matched with excellent fatigue & impact resistance.

#### Superior Toughness

High strength formula for the toughest environments.

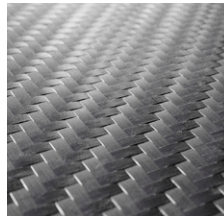
## Key Substrates



*Metals*



*Thermoplastics*



*Composites*



# MA420W Rapid Curing Structural Adhesive



## Typical Properties

Mix Ratio	10:1
Working Time	3.5 - 5 min
Time to 50 psi (0.34 MPa)	10.5 min (approx.)
Time to 500 psi (3.4 MPa)	13 min
Tensile Strength	2,700 - 3,100 psi (19 - 21 MPa)
Tensile Modulus	180 - 220 kpsi (1,241 - 1,517 MPa)
Elongation	20 - 40%

## Lap Shear Results

PU Composite	676 psi (4.7 MPa)
Painted Steel	1,372 psi (9.5 MPa)
DCPD	1,400 psi (9.7 MPa)

## Packaging

Item no.	Description	Color
42000	490 ml Cartridge	Blue
42001	5 gal. Adhesive	Off-White
42002	50 gal. Adhesive	Off-White
IT114	5 gal. Activator	Blue

## Dispensing Equipment

Item no.	Description
30076	490 ml 10:1 Static Mixer
30016	490 ml 10:1 Manual Dispenser
30013	490 ml 10:1 Pneumatic Dispenser

**Refer to our Technical Data Sheets and Safety Data Sheets for additional technical and safety information.**

The technical information, recommendations and other statements contained in this sheet 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.

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