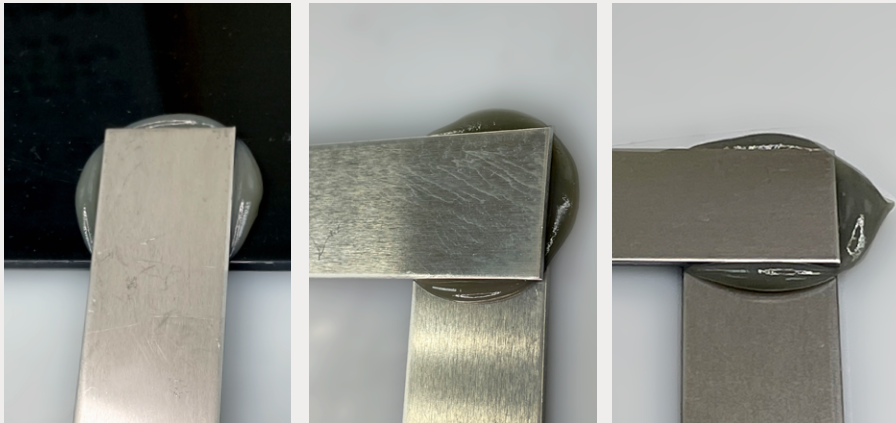




Superior Strength, All-Purpose Adhesives that Bond Even the Toughest Materials!



Plastic to stainless steel bonding

Aluminum to aluminum

Cold rolled steel to cold rolled steel

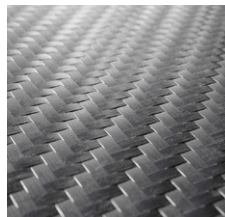
Key Substrates



Metals



Thermoplastics



Composites



Rubber

Highly Versatile

- Bonds the toughest plastics, composites, coatings, rubbers and metals including galvanized metals
- Superior adhesion involving dissimilar materials
- Aesthetically clean finish
- Prevents galvanic corrosion on metals

Increased Throughput

- 1:1 Mix ratio that can handle off ratio cure
- Thixotropic bead that does not sag
- Minimal-to-no surface preparation
- Faster assembly time vs mechanical fasteners

Excellent Strength Retention

- High impact resistance
- Greater than 75% strength retention after 1,000 hours of salt fog exposure
- Excellent under dynamic loads
- Uniform stress distribution
- Superior elongation



MA8000 GB Series Structural Adhesives



	MA8105 GB	MA8110 GB	MA8120 GB
Mix Ratio	1:1	1:1	1:1
Working Time ¹ , min. (@75°F, 23.9°C)	3 - 6	8 - 12	18 - 22
Handling Time ² , min. (@75°F, 23.9°C)	12 - 14	33 - 36	50 - 60
Shear Strength psi (MPa) (0.030 in (0.76 mm) gap) - Plastics	628 - 2041 (4.3 - 14.1)	650 - 700 (4.5 - 4.8)	963 - 1290 (6.6 - 8.9)
Shear Strength psi (MPa) (0.012 in (0.31 mm) gap) - Metals	2178 - 3083 (15.0 - 21.3)	2215 - 2800 (15.3 - 19.3)	2416 - 2656 (16.7 - 18.3)
Tensile Strength psi (MPa)	3,500 - 3,800 (24.1 - 26.2)	3,500 - 3,800 (24.1 - 26.2)	3,100 - 3,500 (21.4 - 24.1)
Tensile Elongation %	5 - 11	25 - 45	45 - 55
Viscosity, cP Adhesive	70,000 - 140,000	40,000 - 80,000	40,000 - 80,000
Viscosity, cP Activator	50,000 - 120,000	40,000 - 80,000	40,000 - 120,000
Operating Temperature °F (°C)	-40°F - 180°F (-40°C - 82°C)	-40°F - 180°F (-40°C - 82°C)	-40°F - 180°F (-40°C - 82°C)

Packaging

Product	Description	Item no.	Color
MA8105 GB	50 ml Cartridge	81057	Gray
MA8105 GB	400 ml Cartridge	81058	Gray
MA8110 GB	50 ml Twin Cartridge	81111	Gray
MA8110 GB	400 ml Twin Cartridge	81108	Gray
MA8120 GB	50 ml Twin Cartridge	81211	Gray
MA8120 GB	400 ml Twin Cartridge	81208	Gray

Dispensing Equipment

Item no.	Description
14285	Mark V™ Mix Nozzle
14280	Mark V™ Manual Dispensing Gun (50 ml)
3333	Static Mix Nozzle
30020	Manual Cartridge Dispensing Gun (400 ml)
30010	Pneumatic Cartridge Dispensing Gun (400 ml)

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

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

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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