



## Reduce Assembly Time with Fast-Curing Plexus Adhesives



The Plexus® range of advanced adhesives are most suitable for bonding a variety of furniture applications. Plexus adhesives enable primerless bonding of mixed materials, including composites, wood, rubbers, and metals. Furniture manufacturers choose Plexus adhesives to help create more robust products and to speed up their assembly process.

### Benefits

#### Fast Strength Development

Unclamps faster than current solutions.  
Longer open time.

#### Improve Durability

Excellent fatigue resistance.  
High strength, elongation, and impact resistance.

#### Reduce Surface Preparation

No primers or adhesion promoters required.  
Wide adhesion range of substrates.

#### Mixed Material Bonding

Primerless to metals, thermoplastics & composites.  
Enables new engineering designs.

#### Easy to Use

Handles off-ratio mixing.  
Thixotropic beads that don't sag.

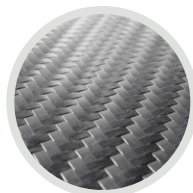
### Key Substrates



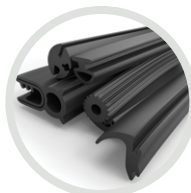
*Metals*



*Thermoplastics*



*Composites*



*Rubber*



# Furniture Bonding Applications



| Product   | Applications  | Chemistry | Mix Ratio | Working Time min. | Fixture Time min. | Tensile Strength psi (MPa)  | Tensile Elongation % | Substrate Adhesion |               |                    |            | Unique Properties   |            |          |
|-----------|---|-----------|-----------|-------------------|-------------------|-----------------------------|----------------------|--------------------|---------------|--------------------|------------|---------------------|------------|----------|
|           |   |           |           |                   |                   |                             |                      | Raw Metal          | Coated Metals | Amorphous Plastics | Composites | Primerless to Metal | Low Shrink | Low Odor |
| MA300     | All Purpose, High Strength                              | MMA       | 1:1       | 3 - 6             | 12 - 15           | 3,000 - 4,000 (20.7 - 27.6) | 5 - 15               | ●*                 | ●             | ●                  | ●          |                     |            |          |
| MA310     | All Purpose, High Strength                              | MMA       | 1:1       | 15 - 18           | 45 - 55           | 3,500 - 4,500 (24.1 - 31)   | 5 - 15               | ●*                 | ●             | ●                  | ●          |                     |            |          |
| MA8105    | Low Odor, High Toughness, Primerless to Metal           | MMA       | 1:1       | 3 - 6             | 12 - 16           | 3,000 - 3,500 (20.7 - 24.1) | 20 - 40              | ●                  | ●             | ●                  | ●          | ●                   | ●          | ●        |
| MA8110    | Low Odor, High Toughness, Primerless to Metal           | MMA       | 1:1       | 8 - 12            | 35 - 50           | 3,100 - 3,600 (21.4 - 24.8) | 40 - 70              | ●                  | ●             | ●                  | ●          | ●                   | ●          | ●        |
| MA8120    | Low Odor, High Toughness, Primerless to Metal           | MMA       | 1:1       | 18 - 22           | 75 - 90           | 2,500 - 3,000 (17.2 - 20.7) | 50 - 80              | ●                  | ●             | ●                  | ●          | ●                   | ●          | ●        |
| MA420     | All Purpose, High Strength, High Toughness              | MMA       | 10:1      | 4 - 6             | 18 - 22           | 2,700 - 3,000 (18.6 - 20.7) | 30 - 50              | ●*                 | ●             | ●                  | ●          |                     |            |          |
| MA205 HV  | Primerless to Aluminum, Ultrafast Fixture Times         | MMA       | 10:1      | 3 - 5             | 7 - 9             | 2,000 - 2,500 (13.8 - 17.2) | 20 - 50              | ●                  | ●             | ●                  | ●          | ●                   |            |          |
| MA3940 LH | All Purpose, High Strength, High Toughness              | MMA       | 10:1      | 4 - 5             | 8 - 10            | 1,160 - 1,740 (8.0 - 12.0)  | 75 - 100             | ●*                 | ●             | ●                  | ●          |                     |            |          |
| PU2105    | Primerless to Metal, No Odor, Low Shrink, Non-Flammable | PU        | 1:1       | 4 - 6             | 18 - 22           | 3,700 - 4,350 (13.8 - 19.3) | ~5                   | ●                  | ●             | ●                  | ●          | ●                   | ●          | ●        |
| H4110     | Primerless to Metal, Elastic, Low Shrink, Non-Flammable | Hybrid    | 1:1       | 8 - 12            | 50 - 65           | 800 - 1,000 (13.8 - 19.3)   | 150                  | ●                  | ●             | ●                  | ●          | ●                   | ●          | ●        |

● Preferred    ● Good    \* PC120 Cleaner/Conditioner Recommended