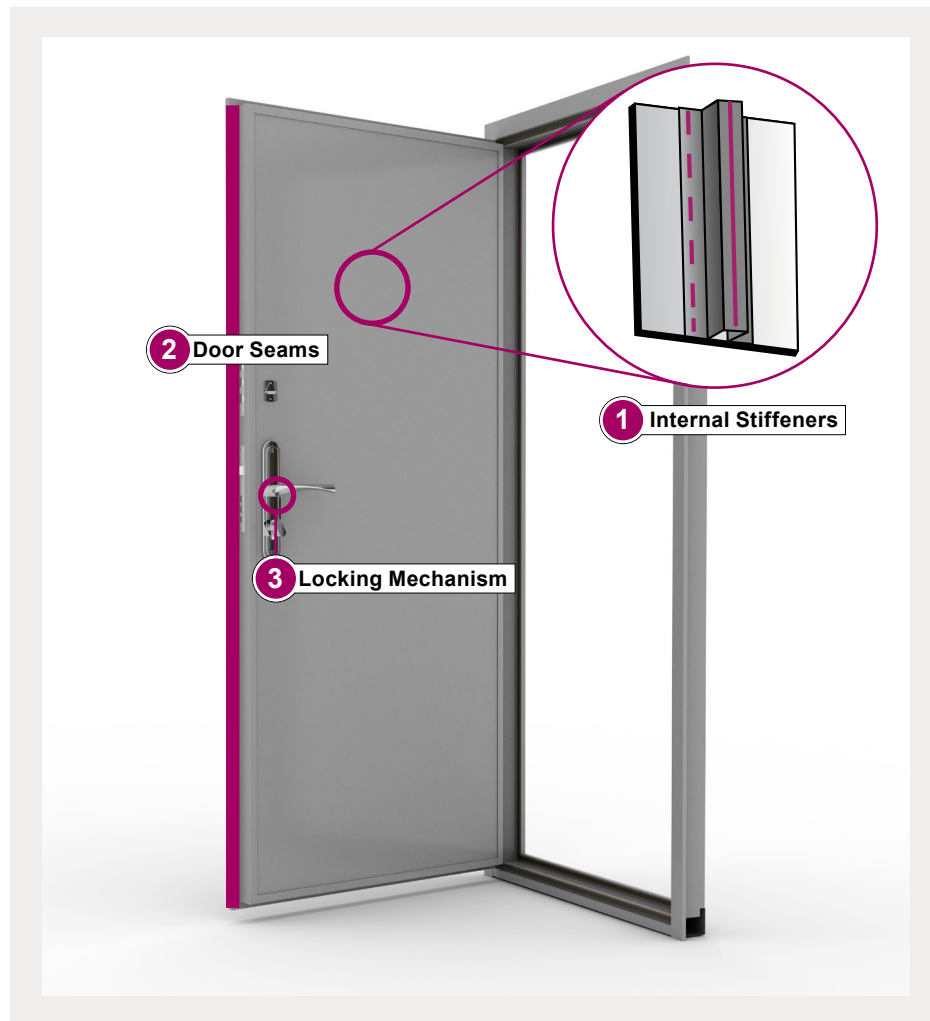




Eliminate Welding and Print Through with Fast-Curing Plexus Adhesive



Plexus MA8105 GB is the result of more than 35 years of experience creating and formulating high performance MMA adhesives. This next generation adhesive lowers assembly time resulting in high throughput and consistent, reliable production. Contains 0.012" (0.3 mm) glass beads to maintain a consistent bondline during clamping.

Applications

Door Seams

- Fast-curing primerless formulation maximizes the number of parts produced per hour
- Eliminates the need for skilled welding labor
- Easily sanded and painted following cure
- Add heat to optimize cure speed for your process

Internal Stiffeners

- Unlike spot welding, dissimilar metals may be joined and print through is eliminated when bonding internal stiffeners
- Glass beads in formulation maintain bondline thickness when stiffeners are cured under pressure

Locking Mechanism

- Quickly position and secure locking mechanism
- Eliminate print through on door panels
- Increase product quality and durability with high fatigue resistant bond



Typical Properties

Mix Ratio	1:1
Working Time, min	3 - 6
Time to 50 psi (0.34 MPa), min	12 - 14
Time to 500 psi (3.4 MPa), min	14 - 16
Time to 1000 psi (6.9 MPa), min	18 - 22
Tensile Strength, psi (MPa)	3,285 - 4,015 (22.7 - 27.2)
Tensile Modulus, kpsi (MPa)	187 - 253 (1,289 - 1,744)
Elongation at Break, %	5 - 10

Lap Shear Results, psi (MPa)

Hot Dipped Galvanized Steel	2,178 (15.0)
Aluminum	2,694 (18.6)
Aluminum 1000 hr Salt Fog	2,436 (16.8)
Stainless Steel	2,961 (20.4)
Cold Rolled Steel	3,083 (21.3)
Fiberglass	2,398 (16.5)*
ABS	628 (4.3)*
Polyamide (Nylon) 6,6 GF	2,041 (14.1)*

* - substrate failure

Packaging

Item no.	Description
81057	50 ml Cartridge
81058	400 ml Cartridge
81055	5 gal Adhesive
81053	5 gal Activator
81059	50 gal Adhesive
81054	50 gal Activator

Dispensing Equipment

Item no.	Description
3333	Static Mixer
30020	400 ml 1:1 Manual Dispenser
30010	400 ml 1:1 Pneumatic Dispenser
Bulk Dispensing	Contact ITW Sales Representative

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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