

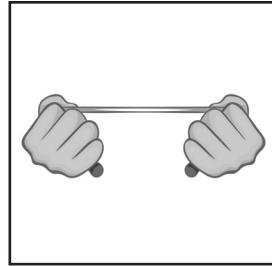
	Plexus Adhesives		Rivets		Tape	
Body Structure Stress	++	Creates stiffness and integrity	-	Concentrated stress	+	Not forgiving under torsion
Impact Resistance	++	Allows flex with impacts	-	Cause stress cracks	+	Can "pop" under sudden loads
Thermal Expansion	++	Allows for movement	-	Cause panel ripples	+	Limited fatigue resistance
Surface Preparation	++	Primerless adhesion	++	None needed	-	Primers often required
Repositionable	++	Can be repositioned	-	Cannot be repositioned	-	Cannot be repositioned
Gap Filling	++	Can handle build tolerances	-	Cause panel to ripple	-	Only 1 sized gap available
Dissimilar Materials	++	Bonds multiple materials	-	Can cause corrosion	+	Might not handle high Δ CTE
Joining and Sealing	++	One step process	-	Need secondary seal	+	Limited long term seal

* Hybrid = Silane modified polymer-Epoxy hybrid. MMA = Methyl methacrylate

PLEXUS® Improve Durability and Production Throughput

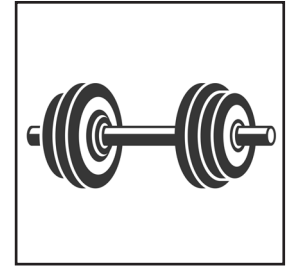
Plexus H4110

- Flexible, elastic bonds
- Consistent cure speeds independent of moisture
- Primerless adhesion
- UV resistant
- Repairable



Plexus MMA

- High strength structural bonds
- Weld replacement
- Primerless adhesion
- Fast strength buildup
- Highest fatigue resistance



	Plexus 2 component	Description	Mixed color	Mix ratio by volume	Working time, mins	Tensile strength, psi (MPa)	Tensile elongation, %	Aluminum	Coil coated	Cold rolled steel	Hot dipped galv	Electro galv	Galvanneal	Powder coated	Stainless steel	FRP
Hybrid	H4110	2K Hybrid, elastic adhesive for sheet to post	Gray	1:1	8 - 12	950 (6.5)	150	++	++	++	+	+	+	++	++	++
Methyl methacrylate	MA8110 GB	Structural adhesive for kick plates and weld replacement	Gray	1:1	8 - 12	3,285 (22.7)	25 - 45	++	++	++	++	++	++	++	++	++
	MA8120 GB	Long open time structural adhesive for kick plates and weld replacement	Gray	1:1	18 - 22	2,907 (20.5)	30 - 60	++	++	++	++	++	++	++	++	++
	MA205HV	Fastest structural adhesive for kick plates and weld replacement	Green	10:1	3 - 5	1,980 (13.7)	15 - 30	++	++	++	-	-	+	++	++	++
	MA830	Aluminum weld replacement	Gray	10:1	4 - 6	2,620 (18.0)	10 - 20	++	++	++	-	-	+	++	+	++
	MA832	Long open time structural adhesive for kick plates and weld replacement	Gray	10:1	12 - 14	2,790 (19.2)	20 - 40	++	++	++	-	-	+	++	+	++

++ 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