



# Structural Adhesive Solutions for Recreational Marine





# Structural Adhesive Solutions for Recreational Marine

## Introduction

Plexus structural adhesives are designed to help simplify assembly processes, resulting in lower production costs and higher manufacturing throughput. The wide range of advanced adhesives are suitable for bonding composites, thermoplastics, metals and dissimilar materials.

Our continued success is due to the importance we place on building strong and lasting relationships with our customers to provide the highest level of service. Our commitment to quality is reflected in every adhesive system that we produce, providing our customers with reliability and consistency in every one of our products.

## Services and Support

Comprehensive test programs developed to understand how our adhesives behave on our customers' substrates.

Invaluable technical and sales support with assistance in product selection, application guidance, dispensing methods and equipment support. Proven experience in boat-building and composite technology.

Access to the global distribution network through our strategic partners.

## Benefits

### Long-term Durability

High impact, high fatigue resistance, even stress distribution.

### Time Savings

Reduce time spent on surface preparation and cure time.

### Clean Aesthetics

Highly thixotropic, low exotherm, and low print through. White UV resistant formulas available.

### Environmental Resistance

Join & seal in one step. Designed to withstand harsh environments.

### Lightweighting

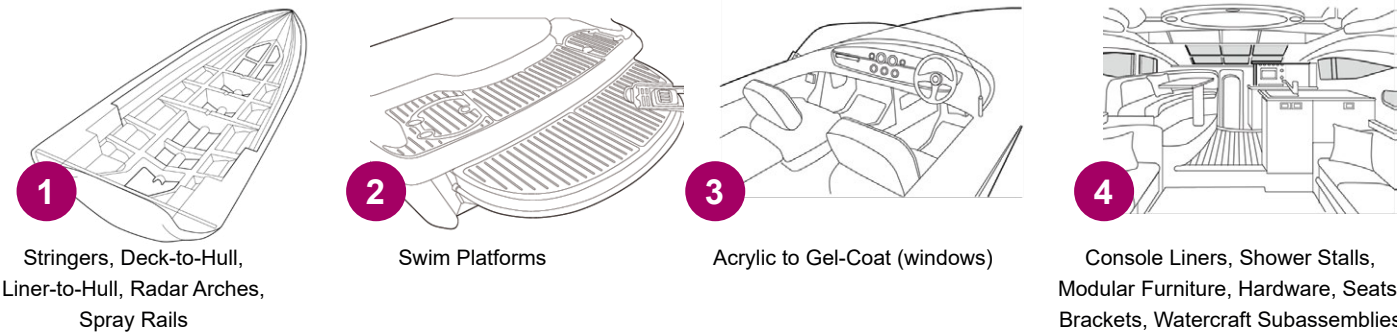
Distributing stress can enable thinner laminates.

### Multi-Material Bonding

Primerless adhesion to most composites, thermoplastics and metals.



# Bonding for Durability, Design Freedom and Manufacturing Efficiency



											Metals						Coatings		Plastics						Composites		
Product	Description	Chemistry	Mix Ratio	Working Time <sup>1</sup> min.	Fixture Time <sup>2</sup> min.	Tensile Strength (MPa)	Tensile Elongation %	Max. Gap Fill (mm)	Part A Viscosity, cP x 10 <sup>3</sup>	Part B Viscosity, cP x 10 <sup>3</sup>	Aluminium	Cold Rolled Steel	Galvanized / Zinc Coated	Galvaneal	Stainless Steel	Powder coat	E-Coat	ABS and ASA	Acrylics	Polyamides (Nylons)	Polycarbonate	Rigid PVC	Gelcoats	Fiberglass	RTM	SMC	
MA300	All Purpose, High Strength	MMA	1:1	3 - 6	10 - 13	24.2 - 29.6	20 - 40	3.2	40 - 70	40 - 70	☉*	☉*			☉*	●	●	●	●		●	●	●	●	●	☉	
MA530	Highly Thixotropic, High Toughness	MMA	1:1	30 - 40	75 - 85	17.2 - 24.1	90-160	18	130 - 180	160 - 215	☉*	☉*			☉*	●	●	●	●	☉	●	●	●	●	●	☉	
MA560-1	Highly Thixotropic, High Toughness	MMA	1:1	55 - 70	120 - 130	17.2 - 21.3	>130	25	145 - 185	170 - 205	☉*	☉*			☉*	●	●	●	●		●	●	●	●	●	☉	
MA590	Highly Thixotropic, High Toughness	MMA	1:1	90 - 105	135 -140	13.1 - 19.0	>130	38.1	140 - 230	165 - 230	☉*	☉*			☉*	●	●	●	●		●	●	●	●	●	☉	
MA2290	Low Shrink, High Gap-Fill, Primerless to Metals	MMA	10:1	106	163	15.2 - 21.2	40-100	38	120 - 180	35 - 80	●	●	●	●	●	●	●	●	●		●	●	●	●	●	●	
MA8105 GB	Low Odour, High Toughness, Primerless to Metal	MMA	1:1	3 - 6	12 - 14	22.7 - 27.2	5 - 10	12.7	70 - 140	50 - 120	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	☉	
MA8110 GB	Low Odour, High Toughness, Primerless to Metal	MMA	1:1	8 - 12	33 - 36	22.7 - 27.2	25 - 45	12.7	40 - 80	40 - 80	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	☉	
MA8120 GB	Low Odour, High Toughness, Primerless to Metal	MMA	1:1	18 - 22	50 - 60	20.4 - 25.0	30 - 60	12.7	40 - 80	80 - 120	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	☉	
MA320	Low Modulus, High Elongation, High Toughness	MMA	10:1	8 -12	27 - 30	12.4 - 15.2	30 - 60	9.5	135 - 175	30 - 70	☉*	☉*			☉*	●	●	●	●		●	●	●	●	●	☉	
MA420	All Purpose, High Strength, High Toughness	MMA	10:1	4 - 6	15 - 17	16.8 - 20.5	20 - 40	9.5	100 - 125	35 - 80	☉*	☉*			☉*	●	●	●	●		●	●	●	●	●	☉	
MA425	All Purpose, High Toughness	MMA	10:1	28 - 30	80 - 85	17.7 - 21.6	30 - 50	9.5	100 - 125	35 - 70	☉*	☉*			☉*	●	●	●	●		●	●	●	●	●	☉	

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

☉ Recommend   ● Highly Recommend   \* Use PC-120 cleaner / conditioner

# Global Operations

## North America

### ITW Performance Polymers

30 Endicott Street  
Danvers, MA 01923 USA  
Tel: +1 855-489-7262  
[cs@itwpp.com](mailto:cs@itwpp.com)  
itwpp.com

### ITW Performance Polymers

130 Commerce Drive  
Montgomeryville, PA 18936  
Tel: +1 215-855-8450  
[customerservice.na@itwpp.com](mailto:customerservice.na@itwpp.com)  
itwpp.com

## South America

### ITW PP&F

Rua Antonio Felamingo, 430  
Valinhos / SP – CEP: 18279-452  
Tel: +55 19 2138.7600  
itwppf.com.br

## Europe

### ITW Performance Polymers

Bay 150,  
Shannon Industrial Estate  
Shannon, County Clare  
Ireland  
Tel: +353 61 771500  
[customerservice.shannon@itwpp.com](mailto:customerservice.shannon@itwpp.com)  
itwpp.com

## Asia Pacific

### ITW PP&F China

2703, XingYuan Building  
No. 418, Guiping Rd.  
Cao He Jing Hi-Tech Park  
Shanghai  
China 200233  
Tel: +86-21-5426-1212  
itwppfchina.com

### ITW PP&F Japan

30-32 Enoki-cho,  
Suita, Osaka, Japan 564-0053  
Tel: +81-6-6330-7118  
itwppfjapan.com

### ITW PP&F Korea

13th floor, PAX Tower, Unit B  
231-13, Nonhyeon-Dong,  
Gangnam-Gu  
Seoul, Korea 135-010  
Tel: +82-2-2088-3560  
itwppfkorea.com

### ITW PP&F Polymers Australia

100 Hassall Street, Wetherill Park  
NSW 2164  
Tel: +800 063 511  
itwppf.com.au

### ITW India Limited

Plot no: 34 to 37, Phase-2,  
IDA, APIIC, Pashamylaram,  
Medak Dist-502307  
Andhra Pradesh, India  
Tel: +08455-224700,224701  
[cheminininfo@itwchemin.com](mailto:cheminininfo@itwchemin.com)  
itwchemin.com

© 2025 ITW Performance Polymers

All rights reserved

The technical information, recommendations, and other statements contained in this brochure are based upon 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.



**PLEXUS**

itwpp.com