PLEXUS®

Structural Adhesive Solutions for Recreational Marine

ITW

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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.

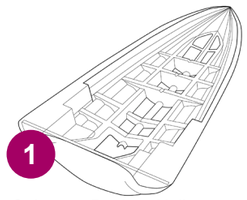
Lightweighting
Distributing stress can enable thinner laminates.

Multi-Material Bonding
Primerless adhesion to most composites, thermoplastics and metals.

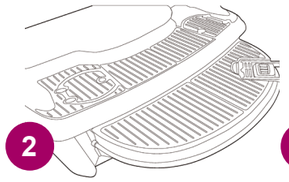
Product	Description	Chemistry	Mix Ratio	Working Time[1] min.	Fixture Time[2] min.	Tensile Strength (MPa)	Tensile Elongation %	Max. Gap Fill (mm)	Part A Viscosity, cP x 10^3	Part B Viscosity, cP x 10^3	Metals: Aluminium	Metals: Cold Rolled Steel	Metals: Galvanized / Zinc Coated	Metals: Galvaneal	Metals: Stainless Steel	Coatings: Powder coat	Coatings: E-Coat	Plastics: ABS and ASA	Plastics: Acrylics	Plastics: Polyamides (Nylons)	Plastics: Polycarbonate	Plastics: Rigid PVC	Plastics: Gelcoats	Composites: Fiberglass	Composites: RTM	Composites: 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	◐*	◐*			◐*	●	●	●	●		◐	●	●	●	●	◐
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	◐*	◐*			◐*	●	●	●	●		◐	●	●	●	●	◐
PU2105	Primerless to Metal, No Odour, Low Shrink, Non-Flammable	PU	1:1	3 - 5	25 - 30	28	5	N/A	60 - 90	60 - 90	●	●	◐	●	●	●	●	◐	◐	◐	◐	◐	◐	●	●	◐
H4110	Primerless to Metal, Elastic, Low Shrink, Non-Flammable	Hybrid	1:1	8 - 12	65 - 75	6.5	150	N/A	40 - 80	40 - 80	●	●	◐	●	●	●	●	◐	◐	◐	◐	◐	◐	●	●	◐

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.

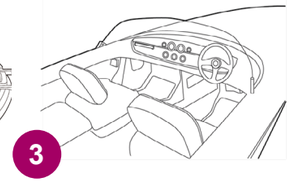
Bonding for Durability, Design Freedom and Manufacturing Efficiency



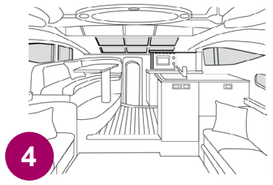
Stringers, Deck-to-Hull, Liner-to-Hull, Radar Arches, Spray Rails



Swim Platforms



Acrylic to Gel-Coat (windows)



Console Liners, Shower Stalls, Modular Furniture, Hardware, Seats, Brackets, Watercraft Subassemblies

◐ Recommend ● Highly Recommend * Use PC-120 cleaner / conditioner

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