

PLEXUS® Structural Bonding Solutions for Specialty Vehicles



The Problem: Mechanical Fasteners

- Create potential leak paths
- May result in stress cracking leading to shortened vehicle life
- Require longer assembly time
- Require thicker gauge metals to ensure enough energy absorption in crash events

The Solution: Plexus® Adhesives

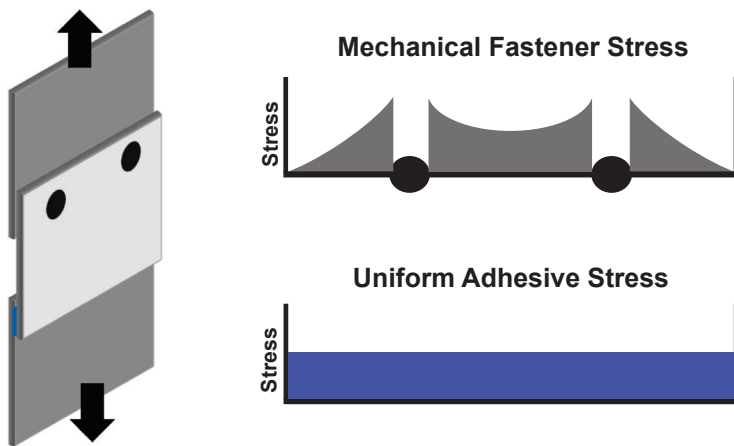
- Eliminate exterior holes by bonding and sealing
- Extend the life of the body structure with high toughness and superior fatigue resistance
- Reduce total cost of assembly with easy to use, fast curing Plexus® adhesives that can cross bond multiple substrates with no/low surface penetration
- Distribute stress with high strength and high elongation adhesives

Structural Bonding Solutions for Specialty Vehicles

Product	Description	Mixed color	Mix ratio by volume	Working time, mins	Tensile strength, psi (MPa)	Tensile elongation, %													
							Aluminum	Coil Coated	Anodized Aluminum	E-Coat	Cold Rolled Steel	HDG	EZG	Galvanneal	Powder Coated	Stainless Steel	FRP		
MA8110 GB	Next generation primerless multimaterial adhesive	Gray	1:1	8 - 12	3,285 (22.7)	25 - 45	++	++	++	++	++	++	++	++	++	++	++	++	++
MA8120 GB	Next generation primerless multimaterial adhesive	Gray	1:1	18 - 22	2,907 (20.5)	30 - 60	++	++	++	++	++	++	++	++	++	++	++	++	
MA205HV	Fastest primerless to metal adhesive	Green	10:1	3 - 5	1,980 (13.7)	15 - 30	++	++	++	++	++	-	-	+	++	++	++		
MA830	Primerless to metal adhesive	Gray	10:1	4 - 6	2,620 (18.0)	10 - 20	++	++	++	++	++	-	-	+	++	+	++		
MA832	Primerless to metal adhesive - medium open time primerless	Gray	10:1	12 - 14	2,790 (19.2)	20 - 40	++	++	++	++	++	-	-	+	++	+	++		
MA420	All purpose toughened adhesive	Blue	10:1	4 - 6	2,430 (16.8)	20 - 40	+	++	+	++	++	-	-	-	++	++	++		
MA320	Excellent low temp impact, white UV stable	White	10:1	8 - 12	1,800 (12.4)	30 - 60	+	++	+	++	+	-	-	-	++	+	++		

++ 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

Improved durability with uniform stress distribution



Improved structure strengths with tougher materials

