

PLEXUS®

SprayCore®

Structural Adhesives & Sprayable Syntactics for Recreational Marine



ITW

Advanced adhesives and sealants for bonding composites, thermoplastics, metals and dissimilar substrates

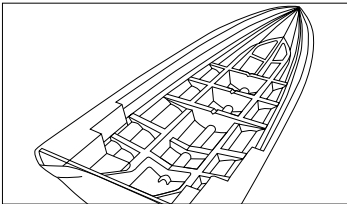
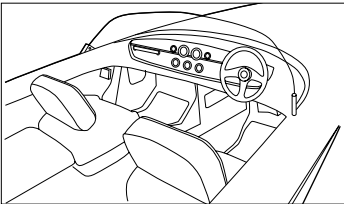
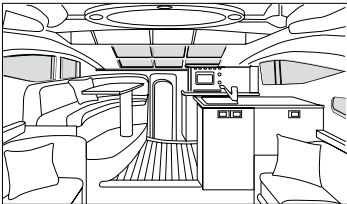
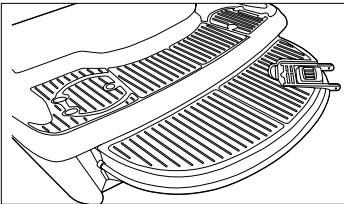
- Over 30 years of innovative technology
- Global manufacturing and distribution network
- Little to no surface preparation
- Room temperature cure
- Demonstrate superior gap fill and sag resistance on vertical or inverted surfaces

Primary Bonding

- Stringer bonding
- Deck to hull mating
- Hard tops
- Liner to hull bonding
- Acrylic to gel-coat (windows)
- Swim platforms
- Radar arches
- Spray rails

Secondary Bonding

- Shower stalls
- Center console finish liners
- Modular furniture attachment
- Hardware
- Plastic seats
- Plastic to metal hardware
- Watercraft subassembly



A pioneer and leading manufacturer of innovative sprayable syntactic materials and sprayable industrial coatings

- Sprayable coring materials and barrier coats
- Sprayable filler/primers for use on many substrates
- Polyester adhesive putties for filling and bonding
- Sprayable mold and plug building materials
- Brushable and sprayable radius materials

Structural Adhesives



Product	Description	Mixed Color	Gap Fill	Mix Ratio by Vol.	Viscosity, cP	Working Time (min)	Fixture Time (min)	Tensile Strength (psi)	Tensile Elongation (%)
MA320	All purpose, high elongation, non-sag, short open-time	Black, Cream, White	0.03" - 0.375"	10:1	A: 135,000 -175,000 B: 30,000 - 70,000	8 - 12	27 - 30	1,800 - 2,200	60 - 100
MA530	All purpose, high strength, high toughness, medium open time	Gray	0.03" - 0.7"	1:1	A: 130,000 - 180,000 B: 160,000 - 215,000	30 - 40	75 - 85	2,500 - 3,500	90 - 160
MA560-1	All purpose, high strength, high toughness, long open time	Gray	0.03" - 1.0"	1:1	A: 145,000 - 185,000 B: 170,000 - 205,000	55 - 70	120 - 130	2,500 - 3,100	>130
MA590	All purpose, high strength, high toughness, long open time	Gray	0.03" - 1.5"	1:1	A: 140,000 - 230,000 B: 165,000 - 230,000	90 - 105	135 - 140	1,880 - 2,750	>130
MA2015 White	Non sag, short work time, non yellowing - highest UV resistance	White	0.03" - 1.5"	10:1	A: 180,000 - 220,000 B: 35,000 - 70,000	15 - 18	25 - 30	2,875 - 3,600	21 - 54
MA2045 White	Non sag, medium work time, non yellowing - highest UV resistance	White	0.03" - 1.5"	10:1	A: 180,000 - 220,000 B: 35,000 - 70,000	45 - 50	90 - 95	2,200 - 2,900	36 - 77
MA2230	Lower exotherms non-sag	Blue	0.03" -1.5"	10:1	A: 180,000 - 220,000 B: 35,000 - 70,000	40 - 42	75 - 77	2,160 - 2,640	40 - 80
MA2245	Lower exotherms non-sag	Blue	0.03" -1.5"	10:1	A: 180,000 - 220,000 B: 35,000 - 70,000	40 - 50	80 - 85	2,160 - 2,640	40 - 80
MA2290	Lower exotherms non-sag	Blue	0.03" - 1.5"	10:1	A: 180,000 - 280,000 B: 35,000 - 80,000	80 - 110	160 - 165	2,340 - 2,860	40 - 100
MA8105 GB	Low Odor, High Toughness, Primer-less to Metal	Gray	0.01" - 0.5"	1:1	A: 70,000 - 140,000 B: 50,000 - 120,000	3 - 6	12 - 14	3,285 - 4,015	5 - 10
MA8110 GB	Low Odor, High Toughness, Primer-less to Metal	Gray	0.01" - 0.5"	1:1	A: 40,000 - 80,000 B: 40,000 - 80,000	8 - 12	33 - 36	3,285 - 4,015	25 - 45
MA8120 GB	Low Odor, High Toughness, Primer-less to Metal	Gray	0.01" - 0.5"	1:1	A: 40,000 - 80,000 B: 80,000 - 120,000	18 - 22	50 - 60	2,907 - 3,630	30 -60

Sprayable Syntactics

Product	Description	Mix Ratio	Preferred Red-Dye Catalyst	Styrene (%)	Approx. Gel Time (min)	Approx. Gel to Peak Range (min)	Density Range (lbs/gal)	Viscosity (cP)	Peak Exotherm Product (100g mass)
BARRIER COAT									
1500-LS	Fast cure time	1.5% MEKP	DHD-9 MEKP 925	22	1 - 3	3 - 5	6.20 - 6.80	6,000 - 8,000 (HB #4 @ 20rpm)	360°F - 400°F
1800-LS	Medium cure time	1.5% MEKP	DHD-9 MEKP 925	22	3 - 5	3 - 7	6.20 - 6.80	4,000 - 7,000 (HB #4 @ 20rpm)	360°F - 400°F
CORING/BULK PRINT BLOCKER									
2045*	Ceramic compounded resin with a very fast gel and cure cycles; Adjustable high and low densities	1.5% MEKP 2.0% MEKP/ 1.5% MR-100	MEKP 925 MEKP 925-H	30	4 - 80 0.5 - 1.5	5 - 8 4 - 8	10.00 - 10.50 (~8.70 - 9.14)	3,000 - 5,000 (RvF #4 @ 20rpm)	250°F - 325°F 325°F - 375°F
2000-OS LS**	Effectively blocks bulk print through in minimum thickness of .090" and can be used to imbed plywood or other sheetcore materials	1.75% - 2.25% MEKP	MEKP 925 MEKP 925-H MEKP 900 DHD-9	27	2.5 - 3.5	6 - 9	5.60 - 6.00	13,000 - 15,000 (HB #4 @ 20rpm)	285°F - 345°F
6000	Economical solution for a variety of applications	1.5% MEKP	MEKP 925 MEKP 925-H MEKP 900 DHD-9	31	5 - 10	15 - 25	5.80 - 6.30	13,000 - 15,000 (RvF #5 @ 20rpm)	200°F - 250°F
7315*	Unique micro balloon ceramic resin with adjustable low and high densities	1.5% MEKP 2.0% MEKP/ 1.5% MR-100	MEKP 925 MEKP 925-H	32	4 - 8 0.5 - 1.5	6 - 10 4 - 8	5.80 - 6.30 (~4.29 - 4.67)	10,000 - 14,000 (RvF #5 @ 20rpm)	300°F - 350°F
RADIUS COMPOUND									
900	Longer gel time allows good working time with rollers	1.5% MEKP	MEKP 925 MEKP 925-H MEKP 900 DHD-9	25	21 - 26	21 - 26	10.80 - 11.30	20,000 - 25,000 (RvF #6 @ 20rpm)	250°F - 300°F
1050	Can be sprayed and chopped while wet	1.5% MEKP	MEKP 925 MEKP 925-H MEKP 900 DHD-9	27	25 - 35	10 - 17	10.80 - 11.30	15,000 - 20,000 (RvF #6 @ 20rpm)	250°F - 300°F
1070	Low Odor, High Toughness, Primer-less to Metal	1.5% - 2.5% MEKP	MEKP-9 Kadox-L50 Kadox-D50	27	25 - 125	10 - 75	18.20 - 8.80	180,000 - 400,000 (T-E @ 5 rpm)	240°F - 275°F
ADHESIVE PUTTIES									
PDR 6000	Formulated for slow gel time	1.5% MEKP	DDM-9 MEKP-9 DDM30****	25	75 - 105	15 - 30	6.10 - 6.60	600,000 - 700,000 (RvF T-E @ 5rpm)	200°F - 250°F
PDR 9000	Formulated for 3 different gel times	1.5% MEKP	DDM-9 MEKP-9 DDM30****	20	10 - 20 40 - 50 80 - 105	5 - 15 10 - 25 25 - 50	8.70 - 9.50	650,000 - 750,000 850,000 - 1,000,000 850,000 - 1,000,000 (RvF T-E @ 5rpm)	180°F - 250°F 180°F - 225°F 150°F - 225°F
AlphaFill Lighweight	Excellent adhesion and featheredge	2% MEKP	BPO	15 - 20	3 - 5	N/A	9.7	102,000 - 120,000 (SSA W/T-E Bar @ 20rpm)	N/A
PLUG BUILDING									
2000-HS	Developed for easy routing with CNC equipment	1.75% - 2.25% MEKP	MEKP 925 MEKP 925-H MEKP 900 DHD-9	33	2.5 - 3.5	7-9	4.80 - 5.20	16,000 - 18,000 (HB #4 @ 20rpm)	290°F - 325°F
SC-4500	High HDT	1.75% - 2.25% MEKP	MEKP 925 MEKP 925-H	26	8 - 13	14 - 20	5.30 - 6.00	9,000 - 15,000 (HB #4 @ 20rpm)	280°F - 320°F
MOLD BUILDING									
SC-4750	High Performance shrink controlled filled Tooling Resin	1.5% MEKP	MEKP-900, MEKP-925, MEKP 925H	29	30 - 45	5 - 12	12.3 - 12.8	2,500 - 4,000 (LVT #3 @ 30 rpm)	280°F - 330°F
4000 HDT	Coring material w/ high heat tolerance when used with MR-100 Blowing Agent****	1.5% - 2.2% MEKP	DHD-9 MEKP 925	29	3 - 4	5 - 8	5.25 - 5.75	12,000 - 14,000 (HB #4 @ 20rpm)	300°F - 350°F
4055****	Can be applied at 20-30 mils directly onto the gelcoat	1.5% MEKP 2.0% MEKP 1.5% MR-100	DHD-9 MEKP 925	26	8 - 13	5 - 15	9.7 - 10.7	8,000 - 11,000 (RvF #5 @ 20rpm)	275°F - 305°F
VELR 4000	Rapidly wets out and cures uniformly with a low exotherm	1.5% MEKP	DHD-9 MEKP 925	32	15 - 25	4 - 10	8.80 - 9.20	450 - 650 (RvF #2 @ 20rpm)	325°F - 375°F
SPRAYABLE FILLER									
AlphaCoat 1700	Extremely fast cure time and high built	2% MEKP	MEKP 9H DDM-9	20	3 - 6	60 - 90	9.10 - 9.60	1200 - 1400 (Lvt #3 @ 30rpm)	N/A
SPECIALTY PRODUCTS									
2000-CM	For compression molding. Makes parts stronger, lighter, void free application. Makes a product stiffer without adding fiberglass laminates. Greatly reduces fiberglass transfer.	1.75 - 2.25% MEKP	DHD-9 DDM-9 MEKP 900	28	20 - 30	20 - 30	4.80 - 5.20	18,000 - 22,000 (HB #4 @ 20rpm)	>220°F

*Can be used **with or without** the MR-100 Blowing Agent for density weight reduction. **Does not use MR 100 Blowing Agent however, can be used to bed other materials. ***Can be used with MR-100 Blowing Agent for added stiffness. ****Addition of MR-100 Blowing Agent is optional. ***** For use in summer only.
NOTE: Please consult a Sales Representative or Technical Service for further assistance at 1-855-489-7262. All published values are subject to change. Please see the product TDS for most up to date product information and the SDS for all health and safety information at itwpp.com

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