

Lower Assembly Time & Cost with Primerless Hybrid Adhesive

	Plexus H4110	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
Repairable	++ Possible w/o damaging panels	+ Difficult w/o damaging panel	- Difficult
Gap Filling	++ Can handle build tolerances	- Cause panel to ripple	- Only 1 sized gap per product
Dissimilar Materials	++ Bonds multiple materials	- Can cause corrosion	+ Might not handle high ΔCTE
Joining and Sealing	++ One step process	- Need secondary seal	+ Limited long term seal

Plexus H4110 is a two-part semi-structural SMP-Epoxy adhesive that bonds a variety of substrates including composites, metal and wood. Plexus H4110 forms flexible, elastic bonds that allow for joint movement.

High Throughput

- Eliminates primer and activator steps

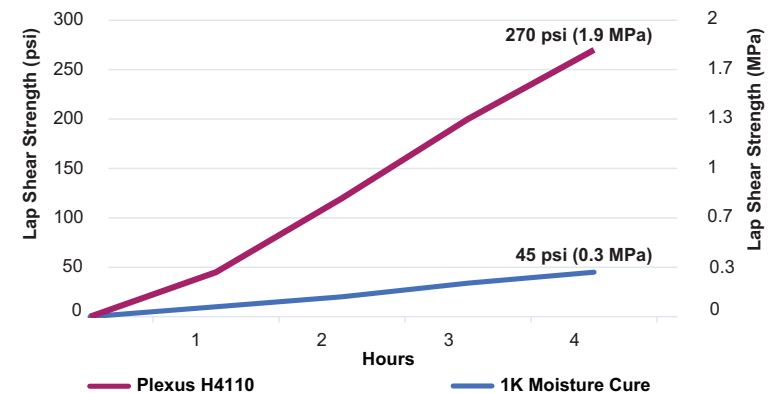
Reliable Production

- Eliminates reliance on moisture and ensures consistent cure speeds

Eliminates Rework

- Low/no shrinkage and exotherm results in no print through

Superior Cure Speed with Plexus H4110





H4110 Hybrid Adhesive

Typical Properties

Mix Ratio	1:1
Working Time ¹ , min	9 - 11
Handling Time ² , min	65 - 75
80% of Cure Time, hrs	24
Tensile Strength, psi (MPa)	950 (6.5)
Tensile Modulus, psi (MPa)	5,800 (40)
Elongation, %	150
Operating Temp, °F (°C)	-40°F - 180°F (-40°C - 82°C)

Lap Shear

G60, psi (MPa)	300 - 500 (2.1 - 3.4)
Aluminum, psi (MPa)	500 - 900 (3.4 - 6.2)
Coated Steel, psi (MPa)	500 - 900 (3.4 - 6.2)
Fiberglass, psi (MPa)	750 (5.2)
DCPD, psi (MPa)	750 (5.2)

Packaging

North America

Item no.	Description
41100	– 400 ml Cartridge
41102	– 48.9 gal Adhesive
41104	– 48.9 gal Activator

EMEA

Item no.	Description
41000	– 400 ml Cartridge
1739	– 185 L Activator
1740	– 185 L Adhesive

Dispensing Equipment

Item no.	Description	Item no.	Description
3333	– Static Mixer	3592	– Static Mixer
30020	– Manual Dispenser	30020	– Manual Dispenser
30010	– Pneumatic Dispenser	30010	– Pneumatic Dispenser

**Refer to our Technical Data Sheets and Safety Data Sheets
for additional technical and safety information.**

1. The maximum allowable time to apply adhesive, mate, and position parts after mixing adhesive and activator at room temperature.
2. Time to 50 psi (0.3 MPa) lap shear strength

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