

**PLEXUS** SprayCore®

## Structural Adhesives & Sprayable Syntactics for Recreational Marine





**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

# SprayCore

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

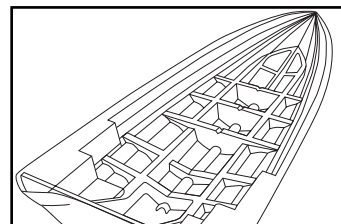
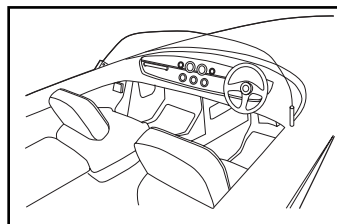
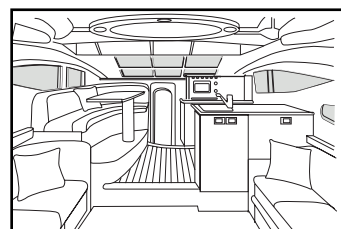
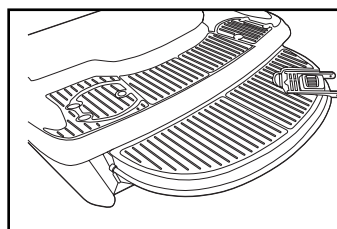
- Sprayable coring materials and barrier coats
- Sprayable filler/primers for use on many substrates
- Polyester adhesive putties for filling and bonding
- Sprayable mold and plug building materials
- Brushable and sprayable radius materials

**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



## 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 (%)	Shear Strength Product (psi)
MA320	All purpose, high elongation, non-sag, short open-time	Black, Cream, White	0.03 in. – 0.375 in.	10:1	A: 135,000-175,000 B: 30,000-70,000	8 - 12	25 - 30	1,700 - 2,200	60 - 100	1,500 - 2,000
MA530	All purpose, high strength, high toughness, medium open time	Gray	0.03 in. – 0.7 in.	1:1	A: 130,000-180,000 B: 160,000-215,000	30 - 40	90 - 160	2,500 - 3,500	90 - 160	1,700 - 2,500
MA560-1	All purpose, high strength/high toughness, long open time	Gray	0.03 in. – 1.0 in.	1:1	A: 145,000-185,000 B: 170,000-205,000	55 - 70	220 - 240	2,500 - 3,100	>130	1,700 - 2,500
MA590	All purpose, high strength/high toughness, long open time	Gray	0.03 in. – 1.5 in.	1:1	A: 140,000-230,000 B: 165,000-230,000	90 - 105	250 - 380	2,000 - 2,500	>130	1,500 - 2,500
MA2015 White	Non sag, short work time, non yellowing - highest UV resistance	White	0.03 in. – 1.5 in.	10:1	A: 180,000-220,000 B: 35,000-70,000	12 - 18	40 - 50	2,700 - 3,200	>30	1,600 - 2,100
MA2045 White	Non sag, medium work time, non yellowing - highest UV resistance	White	0.03 in. – 1.5 in.	10:1	A: 180,000-220,000 B: 35,000-70,000	40 - 50	90 - 120	2,200 - 2,900	>30	1,600 - 2,200
MA2030	Non sag, medium work time	Blue, Black	0.03 in. – 1.5 in.	10:1	A: 180,000-220,000 B: 35,000-70,000	25 - 35	70 - 90	3,000 - 3,400	90 - 125	1,600 - 2,100
MA2045	Non sag, long work time	Blue, Black	0.03 in. – 1.5 in.	10:1	A: 180,000 - 220,000 B: 35,000 - 70,000	40 - 50	100 - 130	2,200 - 2,900	90 - 125	1,600 - 2,200
MA2090	Non sag, long work time	Blue, Black	0.03 in. – 1.5 in.	10:1	A: 180,000 - 220,000 B: 35,000 - 70,000	80 - 100	190 - 230	2,200 - 2,900	90 - 120	1,600 - 2,200
MA2230	Lower exotherms non-sag	Blue	0.03 in. – 1.5 in.	10:1	A: 180,000-220,000 B: 35,000-70,000	25 - 30	70 - 90	2,000 - 2,800	>60	1,700 - 2,300
MA2245	Lower exotherms non-sag	Blue	0.03 in. – 1.5 in.	10:1	A: 180,000-220,000 B: 35,000-70,000	40 - 45	100 - 130	2,000 - 2,800	>60	1,700 - 2,300
MA2290	Lower exotherms non-sag	Blue	0.03 in. – 1.5 in.	10:1	A: 180,000-280,000 B: 35,000-80,000	80 - 110	170 - 215	2,200 - 3,100	40 - 100	1,700 - 2,300

Above 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 [www.itwpp.com](http://www.itwpp.com). NOTE: The above list represents a portion of the Plexus® adhesives product line. Others are available that may suit your needs. Please consult a Sales Representative or Technical Service for further assistance at 1-855-489-7262.

## 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)
<b>BARRIER COAT</b>									
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)	360-400°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)	360-400°F
<b>CORING/BULK PRINT BLOCKER</b>									
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	4-8 0.5-1.5	5-8 4-8	10.00-10.50 (~8.70-9.14)	3,000-5,000 (RvF #4 @ 20rpm)	250-325°F 325-375°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)	285-345°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)	200-250°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)	300-350°F
<b>RADIUS COMPOUND</b>									
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)	250-300°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)	250-300°F
1060	Can be brushed and chopped while wet	1.5% MEKP	MEKP 925 MEKP 925-H MEKP 900 DHD-9	30	20-30	10-17	10.80-11.30	25,000-35,000 (RvF #6 @ 20rpm)	250-300°F
<b>ADHESIVE PUTTIES</b>									
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)	200-250°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)	180-250°F 180-225°F 150-225°F
AlphaFill Lightweight	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
<b>PLUG BUILDING</b>									
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)	290-325°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)	280-320°F
<b>MOLD BUILDING</b>									
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)	280-330°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)	300-350°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)	275-305°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)	325-375°F
<b>SPRAYABLE FILLER</b>									
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
<b>SPECIALTY PRODUCTS</b>									
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: The above list represents a portion of the Plexus® adhesives product line. Others are available that may suit your needs. Please consult a Sales Representative or Technical Service for further assistance at 1-855-489-7262. Above 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 [www.itwpp.com](http://www.itwpp.com)

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