

METALS, PLASTICS AND COMPOSITES

Adhesive	Description	Colour	Mix ratio (by volume)	Viscosity (cps)	Working time (mins)	Fixture time (mins)	Shear strength (MPa)	Tensile elongation (%)	Gap fill (mm)	Material Compatibility																												
										Metals						Plastics						Composites						Other										
											Aluminium	Cast iron	Electroplated	Painted/coated metals	Plated metals	Sheet metal	Stainless steel	Cold rolled steel	ABS	Acrylics (PMMA)	Polyamides (nylons)	Polyesters (PBT, PET)	Polycarbonate	Vinyls (PVC)	Polyurethanes	PDCPD	Fibreglass	Gelcoats	SMC	Phenolics	Laminates	RTM	Rubber					
MA300	All purpose high strength	Cream/Black	1:1	A: 40,000 - 70,000 B: 40,000 - 70,000	3 - 6	12 - 15	20.5 - 26	5 - 15	3.5		y		y	y	y	y	y	y	y	y	y	y	y	y	y	y	y	y	y	y	y	y	y	y				
MA310	Ideal for 'difficult to bond plastics'	Cream/Black	1:1	A: 40,000 - 70,000 B: 40,000 - 70,000	15 - 18	45 - 55	20.5 - 24	5 - 15	3.5				y	y						y	y	y				y	y	y	y	y	y	y	y	y				
MA320	Excellent low temperature properties	Cream/White/Black	10:1	A: 135,000 - 175,000 B: 35,000 - 70,000	8 - 12	25 - 30	10.5 - 14	60 - 140	9.5											y	y				y	y												
MA420	All purpose toughened adhesive	Blue/Black/Cream	10:1	A: 100,000 - 125,000 B: 35,000 - 80,000	4 - 6	18 - 22	20.7 - 26.2	30 - 50	9.5				y	y	y	y	y	y						y	y	y	y	y	y	y	y	y						
MA422	All purpose, with medium open time	Blue	10:1	A: 100,000 - 125,000 B: 35,000 - 70,000	17 - 24	35 - 40	11 - 15.9	75 - 100	9.5		y									y	y				y	y												
MA425	All purpose, with long open time	Blue	10:1	A: 100,000 - 125,000 B: 35,000 - 70,000	30 - 35	80 - 90	11 - 15.9	120 - 140	9.5																													
MA530	All purpose, high strength, medium open time	Grey	1:1	A: 130,000 - 180,000 B: 180,000 - 215,000	30 - 40	90 - 160	11 - 15.2	90 - 160	18																													
MA550	Marine adhesive, white UV stable	White	10:1	A: 130,000 - 160,000 B: 35,000 - 70,000	40 - 45	70 - 75	8.3 - 12.4	35 - 45	9.5											y	y				y	y												
MA560-1	All purpose, high strength, long open time	Grey	1:1	A: 145,000 - 185,000 B: 170,000 - 205,000	55 - 70	220 - 240	11 - 15	> 130																														
MA590	All purpose, long open time, high gap fill	Grey	1:1	A: 140,000 - 230,000 B: 165,000 - 230,000	90 - 105	250 - 380	10 - 15	130 - 160	38																													
MA830	Metal Bonder	Grey	10:1	A: 80,000 - 120,000 B: 35,000 - 80,000	4 - 6	20 - 25	13.8 - 17.2	30 - 60	15		y																											
MA832	Metal Bonder with medium open time	Grey	10:1	A: 80,000 - 120,000 B: 35,000 - 80,000	12 - 16	50 - 60	13.8 - 19.3	30 - 60	12		y	y																										
MA8110	Galvanised Metal Bonder	Grey	1:1	A: 40,000 - 70,000 B: 40,000 - 70,000	9 - 11	35 - 50	12.4 - 15.8	10 - 20	9.5		y	y	y	y	y	y	y	y																				
MA8120	Galvanised Metal Bonder	Grey	1:1	A: 40,000 - 70,000 B: 40,000 - 70,000	18 - 22	75 - 90	12.4 - 15.8	45 - 65	9.5		y	y	y	y	y	y	y	y																				
MA920	Low odour general purpose	Blue	10:1	A: 80,000 - 120,000 B: 35,000 - 80,000	4 - 6	15 - 18	10 - 15	80 - 100	9.5																													
MA1020	Very low shrink all purpose adhesive	Blue	10:1	A: 80,000 - 120,000 B: 35,000 - 80,000	4 - 6	15 - 20	10 - 15	80 - 100	9.5																													
MA2045	Non sag high gap fill adhesive	Blue	10:1	A: 80,000 - 120,000 B: 35,000 - 80,000	40 - 45	100 - 130	10 - 15	90 - 125	38																													
MA2090	Non sag high gap fill long open time adhesive	Blue	10:1	A: 180,000 - 220,000 B: 35,000 - 80,000	80 - 100	190 - 230	11 - 14	90 - 120	38																													
MA3940	Excellent for craze sensitive plastics	Cream	10:1	A: 135,000 - 175,000 B: 30,000 - 70,000	12 - 15	25 - 30	10 - 14	125 - 175	9.5																													
MA3940LH	All purpose fast setting adhesive	Blue	10:1	A: 135,000 - 175,000 B: 30,000 - 70,000	4 - 5	8 - 10	9.5 - 11	75 - 100	4																													

The above list represents a portion of the Plexus adhesives product line. Others are available that may suit your needs. Please consult ITW Performance Polymers for further assistance.

