inspired bonding solutions



Exceptional Strength



High Impact Resistance



Excellent Fatigue Properties

Would you like to improve your productivity and create better value products? The answer could be in your structural adhesive. Our team understands how demanding today's production environment can be, that's why we pride ourselves on providing you with options and innovative solutions, no matter what industry you're in.

We'll use our experience and support services to make the right choices for you and your business.



Laboratory testing for technical solutions and support

Our European Technical Centre is an excellent facility. It is designed to offer support and service for all our customers' technical requirements. Our fully equipped laboratory is part of the centre and it's in this lab that we carry out tensile, impact, fatigue*, thermal, climatic and environmental testing on our customers own substrates. So there's nothing general about our adhesive selection processes, it's all about your unique requirements. The lab also has the facility to test primary and secondary adhesive characteristics, so quality is ensured at all times.

*Carried out in our technical lab in Danvers (USA).

How to use the chart selector

The chart contains information on most of our adhesive products. Everything is on there, from a short description and the colour of the product to the fixture time and strength. This chart is designed to assist you in choosing the correct adhesive for your substrate. Look along the horizontal line and all the substrates with ticks in their boxes can be bonded together using that adhesive. i.e. MA300 will bond aluminium to itself and to sheet metal or stainless steel etc.

Due to the many potential variations in substrates and surface chemistries, ITW Plexus strongly recommends all substrates be tested with the selected adhesive in the anticipated service conditions to determine suitability.

Please contact our technical department at technical@itwplexus.co.uk if you have any questions or you'd like more information about our comprehensive range of adhesive products.









	metals <u></u>	pla	stics	Cor	npos	ites	9			ALIMMI	M RAS CASTR	ON PER FERRITE PRINTE	O COATED META	ALS METAL CO	të delë stët. Politikë kë këntë politiko e të politikë për të për kë për kë për kë për prendit animë të politike për kë për prendit animë të politike për prendit politike për prendit					
Adhesive	Description	Colour	Mix ratio (by volume)	Viscosity (cps)	Working time (mins)	Fixture time (mins)	Shear strength (MPa)	Tensile elongation (%)	Gap fill (mm)			METALS				PLASTICS			COMPOSIT	TES OTHER
MA300	All purpose high strength	Cream	1:1	A: 40,000 - 60,000 B: 40,000 - 60,000	4 - 6	12 - 15	20.6 - 24.1	15 - 25	4	1		1	✓ .	/ /	11	1	11	1 1	/ / /	11
MA310	Ideal for 'difficult to bond plastics'	Cream / Black	1:1	A: 40,000 - 60,000 B: 40,000 - 60,000	15 - 18	30 - 35	20.6 - 24.1	5 - 15	4		1	1	/ /	1	11	11	11	1 1	/ / /	
MA320	Excellent low temperature properties	Off White / White	10:1	A: 135,000 - 175,000 B: 40,000 - 60,000	8 - 12	25 - 30	10.3 - 13.7	100 - 140	10			✓			11		11	11	/	
MA420	All purpose toughened adhesive	Blue / Black / Cream	10:1	A: 100,000 - 125,000 B: 25,000 - 35,000	4 - 6	15 - 18	12 - 15.5	100 - 125	8	1		✓ ✓	/ / .	/ /	11	1	11	1 1	/ / /	
MA420FS	Fast setting adhesive	Blue	10:1	A: 80,000 - 100,000 B: 35,000 - 55,000	1 - 2	3 - 4	8.9 - 11	5 - 15	4			✓			11		✓	11	/	
MA422	All purpose, with medium open time	Blue	10:1	A: 100,000 - 125,000 B: 40,000 - 60,000	17 - 24	35 - 40	10.3 - 12.4	75 - 100	10	1		1	,	/	11	✓	11	11	/ /	11
MA425	All purpose, with long open time	Blue	10:1	A: 100,000 - 125,000 B: 40,000 - 60,000	30 - 35	80 - 90	10.3 - 12.4	120 - 140	10	1		✓	,	/	11	✓	11	11	/ /	11
MA530	All purpose, high strength, medium open time	Grey	1:1	A: 135,000 - 165,000 B: 180,000 - 205,000	30 - 35	90 - 160	13.1 - 15.2	130 - 170	18			✓			11	✓	✓	11		11
MA550	Marine adhesive, white UV stable	White	10:1	A: 130,000 - 160,000 B: 40,000 - 60,000	40 - 45	70 - 75	8.9 - 12.4	35 - 45	10			✓			11	✓	✓	1 1	/	11
MA556	Non swim/sag, large gap fill marine adhesive	Blue	10:1	A: 190,000 - 220,000 B: 40,000 - 60,000	40 - 45	110 - 120	8.6 - 10.3	140 - 160	25*			✓			11	✓	✓	1 1	/ /	1
MA560-1	All purpose, high strength, long open time	Grey	1:1	A: 145,000 - 180,000 B: 180,000 - 205,000	55 - 70	160 - 190	11.7 - 15.2	> 130	25			1			11	1	✓	1 1	/	11
MA590	All purpose, long open time, high gap fill	Grey	1:1	A: 180,000 - 215,000 B: 180,000 - 205,000	90 - 105	210 - 270	9.6 - 12.4	130 - 160	37			1			11	1	✓	1 1		11
MA685	Optically clear and colourless adhesive	Clear	10:1	A: 16,000 - 22,000 B: 40,000 - 60,000	8 - 11	20 - 25	6 - 7**	3 - 5	9						11		✓			
MA830	Metal Bonder	Grey	10:1	A: 90,000 - 120,000 B: 25,000 - 35,000	4 - 6	20 - 25	15.8 - 19.3	30 - 60	12	1	1	111	/ / .	/ /	11	✓	✓	11		1
MA832	Metal Bonder with medium open time	Grey	10:1	A: 90,000 - 120,000 B: 25,000 - 35,000	12 - 16	50 - 60	15.8 - 19.3	30 - 60	12	1	1	/ / /	/ /	/ /	11	✓	✓	11	/	1
MA890	Galvanised steel bonder	Grey	10:1	A: 68,000 - 72,000 B: Paste	8 - 10	20 - 25	10 - 13	30 - 35	4	11	1	′	/ / .	/ /	111	✓	11	11		1
MA920	Low odour general purpose	Blue	10:1	A: 100,000 - 125,000 B: 25,000 - 35,000	4 - 6	15 - 18	10.3 - 13.7	80 - 100	10	1		1		/	11	1	1	11	/ /	1
MA1020	Very low shrink all purpose adhesive	Blue	10:1	A: 100,000 - 125,000 B: 25,000 - 35,000	4 - 6	15 - 20	8.6 - 11	90 - 110	10	1		1		/	11	1	1	11	/	1
MA1025	Low shrink/odour high gap fill	Blue	10:1	A: 180,000 - 220,000 B: 40,000 - 60,000	20 - 25	40 - 45	5.8 - 8.2	90 - 110	25*	1		1		/	11	1	1	1 1	/	✓
MA3940	Excellent for craze sensitive plastics	Off White	10:1	A: 135,000 - 175,000 B: 40,000 - 60,000	12 - 15	25 - 30	10.3 - 13.7	125 - 175	10			1			11		11	1 1	/	
MA3940LH	All purpose fast setting adhesive	Blue	10:1	A: 120,000 - 160,000 B: 35,000 - 55,000	4 - 5	8 - 10	9.5 - 11	75 - 100	4			✓			11	1	/ / /	1 1	/ /	

*Recommend minimum bondline thickness of 2mm. ** Tested on ABS

Also available PC120 Primer / Conditioner - enhances adhesion and durability of Plexus adhesives when bonding aluminium and stainless steel (does not prevent corrosion).

The above table provides a sample of the products available please contact the Plexus technical department for details of our extended range of products.



plastics

composite