



NEW METAL BONDER PLEXUS STRUCTURAL ADHESIVE

ITW Plexus announces **Plexus MA820 Methacrylate Metal Bonding Adhesive**. Like all Plexus Adhesives, MA820 provides a unique combination of high strength, unsurpassed fatigue endurance, outstanding impact resistance, and superior toughness on a variety of substrates, including stainless steel, aluminum, thermoplastics, and composites. Plexus MA820 has been specifically engineered to emphasize these features for use in **rigorous metal bonding applications, such as bus & coach, RV, marine, and heavy truck manufacturing.**

Plexus MA820 is a two-part adhesive that requires no primers and little or no surface preparation on most substrates. The product has a working time of 4-6 minutes and achieves 75% of ultimate strength in 30-35 minutes. It has excellent tolerance to off-ratio mixing, and once mixed, is a non-sagging gel. Plexus MA820 Adhesive requires no primer and cures with no surface tack. The product is supplied in ready to use cartridges, pails, and drums, and can be applied in bulk with Plexus FusionMate™ dispensing equipment.

Product	Description & Potential Substrates	Color	Mix Ratio By Volume	Viscosity cp	Working Time (minutes)	Fixture Time (minutes)	Tensile Strength psi	Tensile Elongation %	Shear Strength psi
MA820	Excellent for structural bonding of surface metals with no surface preparation	Off White Blue	10:1	A: 100,000-125,000 B: 40,000-60,000	4-6	15-20	2900-3300	50-75	2700-3000



ITW Plexus has added new low-odor adhesives to its line of Plexus methacrylate structural adhesives for bonding engineered thermoplastics, composites, FRP, metals and dissimilar materials. Known as the **900 Series**, these new adhesives provide the unmatched convenience, ease-of-use and performance of standard Plexus Adhesives with 90% less odor.

NEW LOW-ODOR METHACRYLATE ADHESIVES

Plexus Adhesives, like all acrylate-based adhesives, have a distinctive odor, which is completely safe, but which some people find unpleasant. Plexus Adhesives have been widely used in the automotive and marine industries for over 15 years, and workers in these industries are accustomed to the smell. However, as the use of the adhesives expands into global markets, odor has become more of a concern.

Environmentally friendly, Plexus Adhesives have very low VOC emissions (less than 1%) and are 100% recyclable. They can be reground without having to cut the adhesive away from the part. **Approved for use by virtually every major vehicle manufacturer**, these durable adhesives have been used to bond more than 5 million plastic automotive bumpers with zero failures.

PRODUCT	MA920	MA922	MA925
Description & Potential Substrates	Low Odor, All Purpose, Short Open Time	Low Odor, All Purpose, Medium Open Time	Low Odor, All Purpose, Long Open Time
Color	Blue	Blue	Blue
Mix Ratio by Volume	10:1	10:1	10:1
Viscosity	A: 100,000-125,000 B: 50,000-70,000	A: 100,000-125,000 B: 10,000-20,000	A: 100,000-125,000 B: 10,000-20,000
Working Time	4-6 minutes	17-24 minutes	30-35 minutes
Fixture Time	15-16 minutes	35-40 minutes	80-90 minutes
Tensile Strength	2700-3000	1800-2200	1750-2200
Tensile Elongation %	80-100	75-100	100-120
Shear Strength psi	1500-2000 psi	1400-1700 psi	1400-1700 psi

Methacrylate Adhesive Technician available at 1-800-323-5158
Email: help@on-hand.com