



We are an ISO 9001:2000 Quality System...The Standard for World Class Quality

**FREE CATALOG ON CD:** Our complete product catalog now available on a Glu Guru™ Catalog CD....Available free to you. Call 1-800-323-5158 or Email [gluguru@on-hand.com](mailto:gluguru@on-hand.com) for your Compact Disk and we will immediately mail it to you free of charge.

**FREE Users Guide to Adhesives brochure**

Part 1 Assessment of Bonding

Part 2 Essential stages of the Pretreatment Process

Call 1-800-323-5158 or Email [gluguru@on-hand.com](mailto:gluguru@on-hand.com) for your copy.

You can depend on your **Glu Guru™** as your reliable one-stop source for Adhesives and Adhesive Dispensers.

#### Your Glu Guru™ Resources

Ad - Tech	Frekote
BF Goodrich	Henkel
Bostick-Findley	ITW Dynatec
Camie Campbell	ITW Plexus
Ciba	Kahnetics
Comprotec	Loctite
Croda	Sovereign
Cyberbond	National Starch
Cox	Ratio Pak
Dymax	Sika
Eclectic	SIA
Glue Dots	Vantico
Loctite-Hysol	

- |                        |                         |
|------------------------|-------------------------|
| ◆ Acrylics             | ◆ PUR Hot Melts         |
| ◆ Aerosols-Non CFC's   | ◆ Release Agents        |
| ◆ Cyanoacrylates       | ◆ Sealants              |
| ◆ Encapsulants         | ◆ Solvent Adhesives     |
| ◆ Epoxies              | ◆ Structural Adhesives  |
| ◆ Hot Melt & Cool Melt | ◆ Urethanes             |
| ◆ Hot Melt Spray       | ◆ UV Adhesives          |
| ◆ Instant Adhesives    | ◆ Water Based Adhesives |
| ◆ Methacrylates        | ◆ Adhesive Dispensers   |

## ADHESIVE FOCUS

On-Hand Adhesives, Inc.  
Adhesive Tech Center  
1850 So. Elmhurst Road  
Mount Prospect, IL 60056

Summer 2006 Issue



Inside This Issue

# Bonding Metals

First Class Mail  
U.S. Postage  
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Mount Prospect IL  
Permit No. 43

# ADHESIVE FOCUS

Volume XII Issue 2

Summer 2006

Aluminum Anodized  
Stainless Steel  
**BOND METALS!**  
Without Primers!  
Steel Galvanized Steel

**P**lexus Metal Bonder™ Adhesives bond metals to other metals, composites, plastics, wood, and dissimilar substrates.

Eliminate rivets and mechanical fasteners.  
Reduce assembly times, factory noise levels  
And repetitive stress injuries to workers.

Speed and simplify production.  
Eliminate pre-drilling operations,  
reduce assembly labor and costs.

Replace welding.  
No scorching or dimpling of thin panels.

Produce stronger, lighter assemblies.  
Distribute stress over large areas.  
Eliminate drill holes and leaks.  
Reduce assembly weight.

Superior flexibility and vibration absorption.  
Superior resistance to impact, fatigue, temperature extremes, and thermal cycling.

Create smooth, seamless surfaces for better graphics.



**Plexus Metal Bonder™ Adhesives for faster assembly and stronger and rivet free sidewalls in truck manufacturing.**



While the above enclosures were initially manufactured by welding, PLEXUS® MA920 adhesive was selected in its place due to customer demand for improved structural performance, exterior appearance and design freedom.

ITW Plexus® introduces a New Generation of Metal Bonding Adhesives

**MA830 and MA832**  
More information on next page

## ITW Plexus Introduces a New Generation of Metal Bonding Adhesives

In a continuous effort to offer the highest performance products, ITW PLEXUS® has announced its enhanced version of metal bonding structural adhesives, MA830 and MA832. This series represents Plexus' most advanced metal bonding technology to date, based upon its patented methacrylate chemistry.

This new series exhibits high performance on a variety of materials including metal, composites and thermoplastics with little or no surface preparation. The end result is the one of the most versatile Plexus structural adhesive series for bonding

Carbon Steel  
Stainless Steel  
Aluminum

to themselves and to dissimilar substrates and coatings.

This new generation of products offers high bond strength, durability, cycle fatigue resistance, and impact strength at a wide temperature range.

The MA830 series is available in two speeds and a variety of packaging including

400 ml cartridges  
5-gallon pails  
55 gallon drum kits  
All without or with glass beads.

**MA830 Description and Potential Substrates:** All purpose Adhesive, High Strength/High Toughness, No Primer Metal Bonding

**Color:** Gray

**Mix Ratio By Vol:** 10:1

**Viscosity cP:** A: 90,000-120,000  
B: 50,000-80,000

**Working Time (min):** 4-6

**Fixture Time (min):** 20-25

**Tensile Strength (psi):** 3200-3800

**Tensile Elongation (%):** 30-60

**Shear Strength (psi):** 2300-2800

**MA832 Description and Potential Substrates:** All purpose Adhesive, High Strength/High Toughness, No Primer Metal Bonding

**Color:** Gray

**Mix Ratio By Vol:** 10:1

**Viscosity cP:** A: 90,000-120,000  
B: 50,000-80,000

**Working Time (min):** 12-16

**Fixture Time (min):** 50-60

**Tensile Strength (psi):** 3500-4000

**Tensile Elongation (%):** 30-60

**Shear Strength (psi):** 2300-2800

## SOLUTION TO HIGHER FUEL COSTS

With increased fuel costs, many trucks, bus and coach builders are looking to reduce vehicle weight and improve MILEAGE without sacrificing strength.



Truck



School Bus

## Plexus Structural Adhesives



Wrecker



Animal Trailers

- STREAMLINE PRODUCTION
- REDUCE ASSEMBLY COSTS
- PRODUCE STRONGER ASSEMBLIES BY DISTRIBUTING STRESS OVER LARGE AREAS INSTEAD OF AT RIVET SITES
- ELIMINATE DIMPLING AND SCORCHING DUE TO WELDING
- REDUCE COSTLY PRE-DRILLING OPERATIONS, FACTORY NOISES AND REPETITIVE INJURIES FROM RIVETING
- REDUCE WEIGHT WITHOUT SACRIFICING STRENGTH OR DURABILITY

For more information and/or to place an order, please contact:  
Email [gluguru@on-hand.com](mailto:gluguru@on-hand.com) or phone 1-800-323-5158

*ITW Plexus, manufacturer of Plexus Adhesives has over 30 years experience in the development of methacrylate adhesives for bonding engineered plastics, advanced components, metals, and other dissimilar substrates. Plexus Adhesives are widely used in the marine, automotive, truck, bus, architectural, and general manufacturing industries.*

*On-Hand Adhesives and the Glu Guru's Tech Center has also been serving the users of adhesives for over 30 years and has a reputation for belief in our customers' needs.*

*We are committed to be the first choice adhesive supplier of quality solutions, quality products and quality service in the markets we serve-working to insure that customers want to buy from, suppliers want to sell to us, and people want to work for us. And to continued improvement.*

*The Glu Guru*