# metals plastics composites wood

| 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 | | | | | | COMPOSITES | | | | | | WOOD | | | OTHERS | | | | | |
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| | | | | | | | | | | ALUMINIUM | BRASS | CAST IRON | COPPER | FERRITE | PAINTED / COATED METALS | PLATED METALS | SHEET METAL | STAINLESS STEEL | COLD ROLLED STEEL | GALVANIZED | ABS | ACRYLICS (PMMA) | POLYAMIDES (NYLONS) | POLYESTERS (PBT, PET) | POLYCARBONATE | VINYLS (PVC) | POLYURETHANES | FIBREGLASS | GELCOATS | SMC | PHENOLICS | LAMINATES | RTM | WOOD (HARD & SOFT) | PLYWOOD | PARTICLE BOARD | BRICK | CONCRETE | RUBBER | HONEYCOMB | CERAMICS | GLASS |
| MA300 | All purpose high strength | Cream | 1:1 | A: 40,000 - 60,000<br>B: 40,000 - 60,000 | 4 - 6 | 12 - 15 | 20.6 - 24.1 | 15 - 25 | 4 | ✓ | | | | ✓ | | ✓ | ✓ | ✓ | | ✓ | ✓ | | ✓ | | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | | | | | | | | | | |
| MA310 | Ideal for 'difficult to bond plastics' | Cream / Grey | 1:1 | A: 40,000 - 60,000<br>B: 40,000 - 60,000 | 15 - 18 | 30 - 35 | 20.6 - 24.1 | 5 - 15 | 4 | | | ✓ | | ✓ | ✓ | ✓ | | ✓ | | ✓ | ✓ | ✓ | ✓ | | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | | | | | | ✓ | | | |
| MA320 | Excellent low temperature properties | Off White / White / Black | 10:1 | A: 135,000 - 175,000<br>B: 40,000 - 60,000 | 8 - 12 | 25 - 30 | 10.3 - 13.7 | 100 - 140 | 10 | | | | | ✓ | | | | | | ✓ | ✓ | | | | ✓ | ✓ | ✓ | ✓ | | | | | | | | | | | | | |
| MA420 | All purpose toughened adhesive | Blue / Black | 10:1 | A: 100,000 - 125,000<br>B: 25,000 - 35,000 | 4 - 6 | 15 - 18 | 12 - 15.5 | 100 - 125 | 8 | ✓ | | | | ✓ | ✓ | ✓ | ✓ | ✓ | | ✓ | ✓ | | ✓ | | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | | | | | | | | | |
| MA420FS | Fast setting adhesive | Blue | 10:1 | A: 80,000 - 100,000<br>B: 35,000 - 55,000 | 1 - 2 | 3 - 4 | 8.9 - 11 | 5 - 15 | 4 | | | | | ✓ | | | | | | ✓ | ✓ | | | | ✓ | | ✓ | ✓ | | | | | | | | | | | | | |
| MA422 | All purpose, with medium open time | Blue | 10:1 | A: 100,000 - 125,000<br>B: 40,000 - 60,000 | 17 - 24 | 35 - 40 | 10.3 - 12.4 | 75 - 100 | 10 | ✓ | | | | ✓ | | | ✓ | | | ✓ | ✓ | | ✓ | | ✓ | ✓ | ✓ | ✓ | ✓ | | ✓ | ✓ | | | | | | | | | |
| MA425 | All purpose, with long open time | Blue | 10:1 | A: 100,000 - 125,000<br>B: 40,000 - 60,000 | 30 - 35 | 80 - 90 | 10.3 - 12.4 | 120 - 140 | 10 | ✓ | | | | ✓ | | | ✓ | | | ✓ | ✓ | | ✓ | | ✓ | ✓ | ✓ | ✓ | ✓ | | ✓ | ✓ | | | | | | | | | |
| MA530 | All purpose, high strength, medium open time | Grey | 1:1 | A: 160,000 - 180,000<br>B: 175,000 - 210,000 | 30 - 35 | 90 - 160 | 13.1 - 15.2 | 130 - 170 | 18 | | | | | ✓ | | | | | | ✓ | ✓ | | ✓ | | ✓ | | ✓ | ✓ | | | ✓ | ✓ | | | | | | | | | |
| MA550 | Marine adhesive, white UV stable | White | 10:1 | A: 130,000 - 160,000<br>B: 40,000 - 60,000 | 40 - 45 | 70 - 75 | 8.9 - 12.4 | 35 - 45 | 10 | | | | | ✓ | | | | | | ✓ | ✓ | | ✓ | | ✓ | | ✓ | ✓ | | | ✓ | ✓ | | | | | | | | | |
| MA556 | Non swim/sag, large gap fill marine adhesive | Blue | 10:1 | A: 190,000 - 220,000<br>B: 40,000 - 60,000 | 40 - 45 | 110 - 120 | 8.6 - 10.3 | 140 - 160 | 25* | | | | | ✓ | | | | | | ✓ | ✓ | | ✓ | | ✓ | | ✓ | ✓ | ✓ | | | ✓ | | | | | | | | | |
| MA560-1 | All purpose, high strength, long open time | Grey | 1:1 | A: 145,000 - 185,000<br>B: 175,000 - 210,000 | 55 - 70 | 160 - 190 | 11.7 - 15.2 | > 130 | 25 | | | | | ✓ | | | | | | ✓ | ✓ | | ✓ | | ✓ | | ✓ | ✓ | | | ✓ | ✓ | | | | | | | | | |
| MA590 | All purpose, long open time, high gap fill | Grey | 1:1 | A: 175,000 - 220,000<br>B: 175,000 - 210,000 | 90 - 105 | 210 - 270 | 9.6 - 12.4 | 130 - 160 | 37 | | | | | ✓ | | | | | | ✓ | ✓ | | ✓ | | ✓ | | ✓ | ✓ | | | ✓ | ✓ | | | | | | | | | |
| MA830 | Metal bonder | Grey | 10:1 | A: 90,000 - 120,000<br>B: 25,000 - 35,000 | 4 - 6 | 20 - 25 | 15.8 - 19.3 | 30 - 60 | 12 | ✓ | | ✓ | | ✓ | ✓ | ✓ | ✓ | ✓ | | ✓ | ✓ | | ✓ | | ✓ | | ✓ | ✓ | | | | ✓ | | | | | | | | | |
| MA832 | Metal Bonder with medium open time | Grey | 10:1 | A: 90,000 - 120,000<br>B:25,000 - 35,000 | 12 - 16 | 50 - 60 | 15.8 - 19.3 | 30 - 60 | 12 | ✓ | | ✓ | | ✓ | ✓ | ✓ | ✓ | ✓ | | ✓ | ✓ | | ✓ | | ✓ | | ✓ | ✓ | | | | ✓ | | | | | | | | | |
| MA890 | Galvanised steel bonder | Grey | 10:1 | A: 68,000 - 72,000<br>B: Paste | 8 - 10 | 20 - 25 | 10 - 13 | 30 - 35 | 4 | ✓ | ✓ | | ✓ | | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | | ✓ | | ✓ | ✓ | ✓ | ✓ | | | ✓ | | | | | | | | |
| MA920 | Low odour general purpose | Blue | 10:1 | A: 100,000 - 125,000<br>B: 25,000 - 35,000 | 4 - 6 | 15 - 18 | 10.3 - 13.7 | 80 - 100 | 10 | ✓ | | | | ✓ | | | ✓ | | | ✓ | ✓ | | ✓ | | ✓ | | ✓ | ✓ | ✓ | | | ✓ | | | | | | | | | |
| MA1020 | Very low shrink all purpose adhesive | Blue | 10:1 | A: 100,000 - 125,000<br>B: 25,000 - 35,000 | 4 - 6 | 15 - 20 | 8.6 - 11 | 90 - 110 | 10 | ✓ | | | | ✓ | | | ✓ | | | ✓ | ✓ | | ✓ | | ✓ | | ✓ | ✓ | | | | ✓ | | | | | | | | | |
| MA1025 | Low shrink/odour high gap fill | Blue | 10:1 | A: 180,000 - 220,000<br>B: 40,000 - 60,000 | 20 - 25 | 40 - 45 | 5.8 - 8.2 | 90 - 110 | 25* | ✓ | | | | ✓ | | | ✓ | | | ✓ | ✓ | | ✓ | | ✓ | | ✓ | ✓ | | | | ✓ | | | | | | | | | |
| MA3940 | Excellent for craze sensitive plastics | Off White | 10:1 | A: 135,000 - 175,000<br>B: 40,000 - 60,000 | 12 - 15 | 25 - 30 | 10.3 - 13.7 | 125 - 175 | 10 | | | | | ✓ | | | | | | ✓ | ✓ | | | ✓ | ✓ | | ✓ | ✓ | | | | | | | | | | | | | |
| MA3940LH | All purpose fast setting adhesive | Blue | 10:1 | A: 120,000 - 160,000<br>B: 35,000 - 55,000 | 4 - 5 | 8 - 10 | 9.5 - 11 | 75 - 100 | 4 | | | | | ✓ | | | | | | ✓ | ✓ | | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | | | | | | | | | | | | |
| EP202 | Extremely strong, water resistant epoxy adhesive | Clear | 1:1 | Mixed: 8,000 | 8 - 12 | 30 - 35 | 15.5 | - | 2 | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | | | ✓ | ✓ | | | | | | | ✓ | | ✓ | | | | | ✓ | ✓ | ✓ | ✓ | ✓ | | ✓ | ✓ | ✓ |
| EP205 | Thixptropic non-migrating, gap filling epoxy | Light Amber | 1:1 | Mixed: 150,000+ | 3 - 6 | 10 - 15 | 17.2 | - | 6 | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | | | ✓ | ✓ | | | | | | | ✓ | | ✓ | | | | | ✓ | ✓ | ✓ | ✓ | ✓ | | ✓ | ✓ | ✓ |
| EP225 | Rubber toughened structural epoxy | Grey | 1:1 | Mixed: 50,000 | 25 | 3.5hrs | 18.9 | 20 | 2 | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | | ✓ | ✓ | ✓ |

*Recommend minimum bondline thickness of 2mm.
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.

ITW PLEXUS Structural Adhesives

metals plastics composites wood