

# PLEXUS® Structural Bonding Solutions for Specialty Vehicles



## ***The Problem: Mechanical Fasteners***

- Create potential leak paths
- May result in stress cracking leading to shortened vehicle life
- Require longer assembly time
- Require thicker gauge metals to ensure enough energy absorption in crash events

## ***The Solution: Plexus® Adhesives***

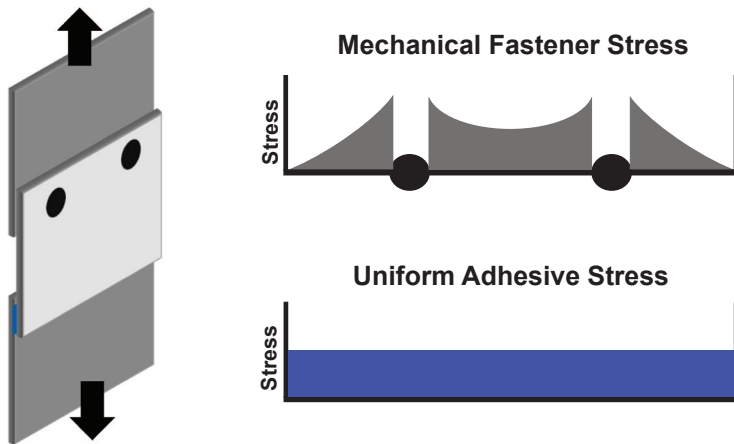
- Eliminate exterior holes by bonding and sealing
- Extend the life of the body structure with high toughness and superior fatigue resistance
- Reduce total cost of assembly with easy to use, fast curing Plexus® adhesives that can cross bond multiple substrates with no/low surface penetration
- Distribute stress with high strength and high elongation adhesives

## Structural Bonding Solutions for Specialty Vehicles

Product	Description	Mixed color	Mix ratio by volume	Working time, mins	Tensile strength, psi (MPa)	Tensile elongation, %													
							Aluminum	Coil Coated	Anodized Aluminum	E-Coat	Cold Rolled Steel	HDG	EZG	Galvanneal	Powder Coated	Stainless Steel	FRP		
MA8110	Next generation primerless multimaterial adhesive	Gray	1:1	8 - 12	3,350 (23.1)	40 - 70	++	++	++	++	++	++	++	++	++	++	++	++	++
MA8120	Next generation primerless multimaterial adhesive	Gray	1:1	18 - 22	2,750 (19.0)	50 - 80	++	++	++	++	++	++	++	++	++	++	++	++	++
MA205HV	Fastest primerless to metal adhesive	Green	10:1	3 - 5	2,250 (15.5)	20 - 50	++	++	++	++	++	-	-	+	++	++	++	++	
MA830	Primerless to metal adhesive	Gray	10:1	4 - 6	3,500 (24.1)	30 - 60	++	++	++	++	++	-	-	+	++	+	++	++	
MA832	Primerless to metal adhesive - medium open time primerless	Gray	10:1	12 - 16	2,850 (19.7)	30 - 60	++	++	++	++	++	-	-	+	++	+	++	++	
MA420	All purpose toughened adhesive	Blue	10:1	4 - 6	2,850 (19.7)	30 - 50	+	++	+	++	++	-	-	-	++	++	++	++	
MA320	Excellent low temp impact, white UV stable	White	10:1	8 - 12	1,950 (13.0)	60 - 100	+	++	+	++	+	-	-	-	++	+	++	++	

++ Excellent adhesion with no to little surface preparation. + Good adhesion with some surface preparation. - Not recommended. \* Use PC120 Cleaner Conditioner for optimum long term environmental durability

### Improved durability with uniform stress distribution



### Improved structure strengths with tougher materials

