

Description

Plexus® MA830 is a two-part methacrylate adhesive designed for structural bonding of metals without primers. In addition, MA830 does a superb job of bonding thermoplastic and composite assemblies with little or no surface preparation¹. Combined at a 10:1 ratio, MA830 has a working time of 4 to 6 minutes and achieves approximately 75% of ultimate strength in 15 to 25 minutes at 74°F (23°C). This product provides a unique combination of high strength, excellent fatigue endurance, outstanding impact resistance, and superior toughness. Plexus MA830 is supplied in a ready-to-use cartridge, 5-gallon (20-liter) pails, or 50-gallon (200-liter) drums to be dispensed as a non-sagging gel.

Characteristics

Room Temperature Cure

- Working Time² 4 – 6 minutes
- Fixture Time³ 15 – 25 minutes
- Operating Temperature⁶ -40°F – 180°F (-40°C – 82°C)
- Gap Filling 0.012 in. – 0.50 in. (0.3 mm – 13 mm)
- Mixed Density 8.17/8.28 lbs/gal (0.98/0.99 g/cc)
- Flash Point 51°F (11°C)

Chemical Resistance⁴

Excellent resistance to:

- Hydrocarbons
- Acids and Bases (pH 3-10)
- Salt Solutions

Susceptible to:

- Polar Solvents
- Strong Acids and Bases

Typical Physical Properties

(uncured) – Room Temperature

Viscosity, cP

Adhesive

80,000 – 120,000

Activator

35,000 – 80,000

Color

Off-White

Grey or Grey GB

Density, lbs/gal (g/cc)

8.06 (0.97)

9.10 (1.09) or 9.25 (1.11)

Mix Ratio by Volume

10.0

1.0

Mix Ratio by Weight

8.86

1.0 or 1.02

Mixer Recommendation:

Cartridge (490-ml):

Sulzer MFQX 10-24T mix nozzle

Bulk: Refer to ITW PP

Typical Mechanical Properties⁸

(Cured) – Room Temperature

Tensile (ASTM D638)

- Strength, psi (MPa) 3,200 – 3,800 (22.0 – 26.2)
- Modulus, psi (MPa) 70,000 – 100,000 (483 – 689)
- Strain to Failure (%) 30 – 60

Lap Shear (ASTM D1002)

- Shear Cohesive Strength, psi (MPa) 2,000 – 2,800 (13.8 – 19.3) (0.012 in. gap, GB AL)
- T-Peel (ASTM D1876), pli 30-40
- Hardness Shore D (ASTM D2240) 75

Recommended for:

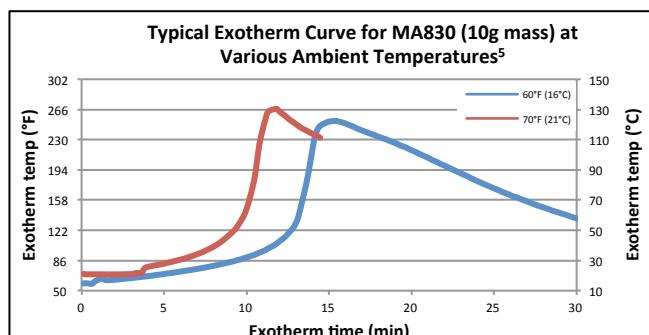
- ABS
- Acrylics
- Aluminium
- FRP
- Gelcoats

- PVC
- Polyesters (including DCPD modified)
- Steel, Carbon

- Steel, Stainless
- Styrenics
- Urethanes (general)
- Vinyl Esters

* **Plexus Primer Suggested⁷**

VOC's	% (g/L)
During Cure (see back page)	<1 (<10)
Shelf Life	Months
Adhesive (A Side)	13
Activator (B Side)	10
Cartridges	10
Other Properties	
Impact, lb-ft/in. 72°F (23°C) ASTM D950	> 20
Impact, lb-ft/in. - 40°F (-40°C) ASTM D950	> 15



TECHNICAL DATA SHEET

MA830

PLEXUS[®]

SAFETY & HANDLING: Plexus[®] adhesive (Part A) is flammable. Contents include methacrylate esters. Keep containers closed after use. Wear gloves and safety glasses to avoid skin and eye contact. Wash with soap and water after skin contact. In case of eye contact, flush with water for 15 minutes and get medical attention. Harmful if swallowed. Keep out of reach of children. Keep away from heat, sparks, and open flames. For more complete health and safety information, contact ITW PP for a Material Safety Data Sheet (MSDS).

Note: Because of the rapid curing features of this product, a large amount of heat may be generated when large masses of material are mixed at one time. Further, the heat generated by the exotherm resulting from the mixing of large masses of this system can result in the release of entrapped air, steam, and volatile gases. To prevent this, dispense only enough material as needed for the application and for use within the working time of the product and confine gap thickness to no more than its maximum gap fill capability. Questions relative to handling and applications should be directed to ITW PP at 855-489-7262.

DISPENSING ADHESIVE AND APPLICATION: Plexus Adhesives may be applied manually or with all stainless steel bulk dispensing equipment. Automated applications may be accomplished with a variety of 10-to-1 meter-mix equipment delivering both components to a static mixer. Avoid contact with copper or copper-containing alloys in all fittings, pumps, etc. Seals and gaskets should be made of Teflon, Teflon-coated PVC foam, ethylene/propylene, or polyethylene. Avoid the use of Viton, BUNA-N, Neoprene, or other elastomers for seals and gaskets. For more information, contact ITW Plexus. To assure maximum bond strength, surfaces must be mated within the specified working time. Use sufficient material to ensure the joint is completely filled when parts are mated and clamped. All adhesive application, part positioning, and fixturing should occur *before* the working time of the mix has expired. After indicated working time, parts must remain undisturbed until the fixture time is reached. Clean up is easiest *before* the adhesive has cured. Citrus terpene or N-methyl pyrrolidone (NMP) containing cleaners, degreasers, and soap and water can be used for best results. If the adhesive is already cured, careful scraping, followed by wiping with a cleaning agent, may be the most effective method of clean up.

EFFECT OF TEMPERATURE: Application of adhesive at temperatures between 65°F (18°C) and 85°F (30°C) will ensure proper cure. Temperatures below 65°F (18°C) or above 85°F (30°C) will slow down or increase cure rate significantly. Temperature affects viscosities of Parts A and B of this adhesive. To ensure consistent dispensing in meter-mix equipment, adhesive and activator temperatures should be held reasonably constant throughout the year. Adhesive in cured state behaves differently at elevated and low temperatures. See ITW PP for specific values.

STORAGE AND SHELF LIFE: Shelf life is based on continuous storage between 54°F (12°C) and 74°F (23°C). Long term exposure above 74°F (23°C) will reduce the shelf life of these materials. Prolonged exposure above 98°F (37°C) quickly diminishes the reactivity of the product and should be avoided. These products should never be frozen.

PRODUCT USE: Many factors beyond ITW PP control and uniquely within user's knowledge and control can affect the use and performance of an ITW PP product in a particular application. Given the variety of factors that can affect the use and performance of an ITW PP product, the end user is solely responsible for evaluating any ITW PP product and determining whether it is fit for a particular purpose and suitable for user's design, production, and final application.

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Notes

1. ITW PP strongly recommends that all substrates be tested with the selected adhesive in the anticipated service conditions to determine suitability.
2. Working Time: The time elapsed between the moment Parts A and B of the adhesive system are combined and thoroughly mixed and the time when the adhesive is no longer useable. Times presented were tested at 74°F (23°C).
3. Fixture Time: Varies with bond gap and ambient temperature. Present values were measured at 74°F (23°C).
4. Resistance to chemical exposure varies greatly based on several parameters including temperature, concentration, bond line thickness, and duration of exposure. The chemical resistance guidelines listed assume long-term exposures at ambient conditions.
5. In a typical bond line, exotherm temperatures will be lower than the temperatures shown.
6. All adhesives soften with temperature and should be evaluated at expected conditions. Consult with ITW PP for values at a specific temperature.
7. Exterior applications require the use of coatings or primers that inhibit oxidation of the steel.
8. Attained test values will vary with test method, approach, speed, etc.

NOTE: The technical information, recommendations, and other statements contained in this document are based upon tests or experience that ITW PP believes are reliable, but the accuracy or completeness of such information is not guaranteed. The information provided is not intended to substitute for the customers own testing.

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PRODUCT CERTIFIED FOR
LOW CHEMICAL EMISSIONS
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