

Structural Adhesives & Sprayable Syntactics for Recreational Marine





Advanced adhesives and sealants for bonding composites, thermoplastics, metals and dissimilar substrates

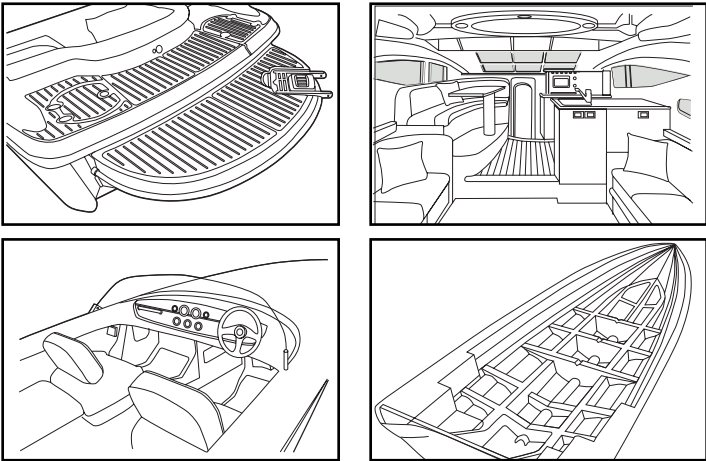
- Over 30 years of innovative technology
- Global manufacturing and distribution network
- Little to no surface preparation
- Room temperature cure
- Demonstrate superior gap fill and sag resistance on vertical or inverted surfaces

SprayCore

A pioneer and leading manufacturer of innovative sprayable syntactic materials and sprayable industrial coatings

- Sprayable coring materials and barrier coats
- Sprayable filler/primers for use on many substrates
- Polyester adhesive putties for filling and bonding
- Sprayable mold and plug building materials
- Brushable and sprayable radius materials

Primary Bonding - Stringer bonding - Deck to hull mating - Hard tops - Liner to hull bonding - Acrylic to gel-coat (windows) - Swim platforms - Radar arches - Spray rails	Seconday Bonding - Shower stalls - Center console finish liners - modular furniture attachment - Hardware - Plastic seats - Plastic to metal hardware - Watercraft subassembly
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Structural Adhesives

Product	Description	Mixed Color	Gap Fill	Mix Ratio by Vol.	Viscosity, cP	Working Time (min)	Fixture Time (min)	Tensile Strength (psi)	Tensile Elongation (%)	Shear Strength Product (psi)
MA320	All purpose, high elongation, non-sag, short open-time	Black, Cream, White	0.03 in. – 0.375 in.	10:1	A: 135,000-175,000 B: 30,000-70,000	8 - 12	25 - 30	1,700 - 2,200	60 - 100	1,500 - 2,000
MA530	All purpose, high strength, high toughness, medium open time	Gray	0.03 in. – 0.7 in.	1:1	A: 130,000-180,000 B: 160,000-215,000	30 - 40	90 - 160	2,500 - 3,500	90 - 160	1,700 - 2,500
MA560-1	All purpose, high strength/high toughness, long open time	Gray	0.03 in. – 1.0 in.	1:1	A: 145,000-185,000 B: 170,000-205,000	55 - 70	220 - 240	2,500 - 3,100	>130	1,700 - 2,500
MA590	All purpose, high strength/high toughness, long open time	Gray	0.03 in. – 1.5 in.	1:1	A: 140,000-230,000 B: 165,000-230,000	90 - 105	250 - 380	2,000 - 2,500	>130	1,500 - 2,500
MA2015 White	Non sag, short work time, non yellowing - highest UV resistance	White	0.03 in. – 1.5 in	10:1	A: 180,000-220,000 B: 35,000-70,000	12 - 18	40 - 50	2,700 - 3,200	>30	1,600 - 2,100
MA2045 White	Non sag, medium work time, non yellowing - highest UV resistance	White	0.03 in. – 1.5 in	10:1	A: 180,000-220,000 B: 35,000-70,000	40 - 50	90 - 120	2,200 - 2,900	>30	1,600 - 2,200
MA2030	Non sag, medium work time	Blue, Black	0.03 in. – 1.5 in	10:1	A: 180,000-220,000 B: 35,000-70,000	25 - 35	70 - 90	3,000 - 3,400	90 - 125	1,600 - 2,100
MA2045	Non sag, long work time	Blue, Black	0.03 in. – 1.5 in.	10:1	A: 180,000 - 220,000 B: 35,000 - 70,000	40 - 50	100 - 130	2,200 - 2,900	90 - 125	1,600 - 2,200
MA2090	Non sag, long work time	Blue, Black	0.03 in. – 1.5 in.	10:1	A: 180,000 - 220,000 B: 35,000 - 70,000	80 - 100	190 - 230	2,200 - 2,900	90 - 120	1,600 - 2,200
MA2230	Lower exotherms non-sag	Blue	0.03 in. – 1.5 in.	10:1	A: 180,000-220,000 B: 35,000-70,000	25 - 30	70 - 90	2,000 - 2,800	>60	1,700 - 2,300
MA2245	Lower exotherms non-sag	Blue	0.03 in. – 1.5 in	10:1	A: 180,000-220,000 B: 35,000-70,000	40 - 45	100 - 130	2,000 - 2,800	>60	1,700 - 2,300
MA2290	Lower exotherms non-sag	Blue	0.03 in. – 1.5 in	10:1	A: 180,000-280,000 B: 35,000-80,000	80 - 110	170 - 215	2,200 - 3,100	40 - 100	1,700 - 2,300

Above values are subject to change. Please see the product TDS for most up to date product information and the SDS for all health and safety information at www.itwpp.com.
 NOTE: The above list represents a portion of the Plexus® adhesives product line. Others are available that may suit your needs. Please consult a Sales Representative or Technical Service for further assistance at 1-855-489-7262.

Sprayable Syntactics

Product	Description	Mix Ratio	Preferred Red-Dye Catalyst	Styrene (%)	Approx. Gel Time (min)	Approx. Gel to Peak Range (min)	Density Range (lbs/gal)	Viscosity (cP)	Peak Exotherm Product (100g mass)
BARRIER COAT									
1500-LS	Fast cure time	1.5% MEKP	DHD-9 MEKP 925	22	1-3	3-5	6.20-6.80	6,000-8,000 (HB #4 @ 20rpm)	360-400°F
1800-LS	Medium cure time	1.5% MEKP	DHD-9 MEKP 925	22	3-5	3-7	6.20-6.80	4,000-7,000 (HB #4 @ 20rpm)	360-400°F
CORING/BULK PRINT BLOCKER									
2045*	Ceramic compounded resin with a very fast gel and cure cycles; Adjustable high and low densities	1.5% MEKP 2.0% MEKP/ 1.5% MR-100	MEKP 925 MEKP 925-H	30	4-8 0.5-1.5	5-8 4-8	10.00-10.50 (~8.70- 9.14)	3,000-5,000 (RvF #4 @ 20rpm)	250-325°F 325-375°F
2000-OS LS**	Effectively blocks bulk print through in minimum thickness of .090" and can be used to imbed plywood or other sheetcore materials	1.75%-2.25% MEKP	MEKP 925 MEKP 925-H MEKP 900 DHD-9	27	2.5-3.5	6-9	5.60-6.00	13,000-15,000 (HB #4 @ 20rpm)	285-345°F
6000	Economical solution for a variety of applications	1.5% MEKP	MEKP 925 MEKP 925-H MEKP 900 DHD-9	31	5-10	15-25	5.80-6.30	13,000-15,000 (RvF #5 @ 20rpm)	200-250°F
7315*	Unique micro balloon ceramic resin with adjustable low and high densities	1.5% MEKP 2.0% MEKP/ 1.5% MR-100	MEKP 925 MEKP 925-H	32	4-8 0.5-1.5	6-10 4-8	5.80-6.30 (~4.29-4.67)	10,000-14,000 (RvF #5 @ 20rpm)	300-350°F
RADIUS COMPOUND									
900	Longer gel time allows good working time with rollers	1.5% MEKP	MEKP 925 MEKP 925-H MEKP 900 DHD-9	25	21-26	21-26	10.80-11.30	20,000-25,000 (RvF #6 @ 20rpm)	250-300°F
1050	Can be sprayed and chopped while wet	1.5% MEKP	MEKP 925 MEKP 925-H MEKP 900 DHD-9	27	25-35	10-17	10.80-11.30	15,000-20,000 (RvF #6 @ 20rpm)	250-300°F
1060	Can be brushed and chopped while wet	1.5% MEKP	MEKP 925 MEKP 925-H MEKP 900 DHD-9	30	20-30	10-17	10.80-11.30	25,000-35,000 (RvF #6 @ 20rpm)	250-300°F
ADHESIVE PUTTIES									
PDR 6000	Formulated for slow gel time	1.5% MEKP	DDM-9 MEKP-9 DDM30*****	25	75-105	15-30	6.10-6.60	600,000-700,000 (RvF T-E @ 5rpm)	200-250°F
PDR 9000	Formulated for 3 different gel times	1.5% MEKP	DDM-9 MEKP-9 DDM30*****	20	10-20 40-50 80-105	5-15 10-25 25-50	8.70-9.50	650,000-750,000 850,000-1,000,000 850,000-1,000,000 (RvF T-E @ 5rpm)	180-250°F 180-225°F 150-225°F
AlphaFill Lightweight	Excellent adhesion and featheredge	2% MEKP	BPO	15-20	3-5	N/A	9.7	102,000-120,000 (SSA W/T-E Bar @ 20rpm)	N/A
PLUG BUILDING									
2000-HS	Developed for easy routing with CNC equipment	1.75%-2.25% MEKP	MEKP 925 MEKP 925-H MEKP 900 DHD-9	33	2.5-3.5	7-9	4.80-5.20	16,000-18,000 (HB #4 @ 20rpm)	290-325°F
SC-4500	High HDT	1.75%-2.25% MEKP	MEKP 925 MEKP 925-H	26	8-13	14-20	5.30-6.00	9,000-15,000 (HB #4 @ 20rpm)	280-320°F
MOLD BUILDING									
SC-4750	High Performance shrink controlled filled Tooling Resin	1.5% MEKP	MEKP-900, MEKP-925, MEKP 925H	29	30 - 45	5-12	12.3-12.8	2,500-4,000 (LVT #3 @ 30 rpm)	280-330°F
4000 HDT	Coring material w/ high heat tolerance when used with MR-100 Blowing Agent****	1.5%-2.2% MEKP	DHD-9 MEKP 925	29	3-4	5-8	5.25-5.75	12,000-14,000 (HB #4 @ 20rpm)	300-350°F
4055***	Can be applied at 20-30 mils directly onto the gelcoat	1.5% MEKP 2.0% MEKP 1.5% MR-100	DHD-9 MEKP 925	26	8-13	5-15	9.7-10.7	8,000-11,000 (RvF #5 @ 20rpm)	275-305°F
VELR 4000	Rapidly wets out and cures uniformly with a low exotherm	1.5% MEKP	DHD-9 MEKP 925	32	15-25	4-10	8.80-9.20	450-650 (RvF #2 @ 20rpm)	325-375°F
SPRAYABLE FILLER									
AlphaCoat 1700	Extremely fast cure time and high built	2% MEKP	MEKP 9H DDM-9	20	3-6	60-90	9.10-9.60	1200-1400 (LVT #3 @ 30rpm)	N/A
SPECIALTY PRODUCTS									
2000-CM	For compression molding. Makes parts stronger, lighter, void free application. Makes a product stiffer without adding fiberglass laminates. Greatly reduces fiberglass transfer.	1.75-2.25% MEKP	DHD-9 DDM-9 MEKP 900	28	20-30	20-30	4.80-5.20	18,000-22,000 (HB #4 @ 20rpm)	>220°F

*Can be used with or without the MR-100 Blowing Agent for density weight reduction. **Does not use MR 100 Blowing Agent however, can be used to bed other materials. ***Can be used with MR-100 Blowing Agent for added stiffness. ****Addition of MR-100 Blowing Agent is optional.
 ***** For use in summer only. NOTE: The above list represents a portion of the Plexus® adhesives product line. Others are available that may suit your needs. Please consult a Sales Representative or Technical Service for further assistance at 1-855-489-7262.
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