

MA821

Preliminary Technical Data Sheet

Benefits

- No Primer Required on Metal
- High Toughness
- Low Odor
- Low Shrinkage
- Non-Sagging
- Spacer bead in cartridge

Characteristics

- Room Temperature Cure
- Working Time²
 - 4 – 6 minutes
- Fixture Time³
 - 28 – 32 minutes
- 51°F Flash Point
- Operating Temperature
 - 67°F to 250°F
- Gap Filling to 0.5 inch
- Mixed Density
 - 8.33 lbs./gal (1.00 g/cc)

Chemical Resistance⁴

- Excellent resistance to
 - Hydrocarbons
 - Acids and Bases (3-10 pH)
 - Salt Solutions
- Susceptible to:
 - Polar Solvents
 - Strong Acids and Bases

Recommended for:

- ABS
- Acrylics
- Aluminum
- FRP
- Gelcoats⁶
- PVC
- Polyesters (including DCPD modified)
- Steel, Carbon⁷
- Steel, Stainless
- Styrenics
- Urethanes (General)
- Vinyl Esters

Plexus[®] MA821 is a two-part methacrylate adhesive designed for structural bonding of metals without primers. In addition, MA821 does a superb job of bonding thermoplastic and composite assemblies with no surface preparation¹. Combined at a 10:1 ratio, MA821 has a working time of 4 to 6 minutes and achieves 75% of ultimate strength in 28 to 32 minutes. This product provides a unique combination of high strength, excellent fatigue endurance, outstanding impact resistance, and superior toughness. Plexus MA821 is available in gray, with or without 30 mil (0.030 in.) solid bead spacers. MA821 is supplied in ready-to-use cartridges, 5 gallon pails or 50 gallon drums. The product can be dispensed as a non-sagging gel using standard meter-mix equipment. ITW Plexus recommends the **MixPac MC08-32 nozzle** for this product.

Physical Properties (Uncured) –Room Temperature

	Adhesive	Activator	
Viscosity, cP	90,000-120,000	50,000-75,000	
Color	Off-White to Mauve	Gray	Gray, beads
Density, lbs./gal (g/cc)	8.25 (0.99)	8.95 (1.07)	10.59 (1.26)
Mix Ratio by Volume	10	1	1
Mix Ratio by Weight	9.2	1	1*

*Mix ratio with gray, spacer activator is 7.8:1 by weight. Mixed density is 8.46 lbs./gal.

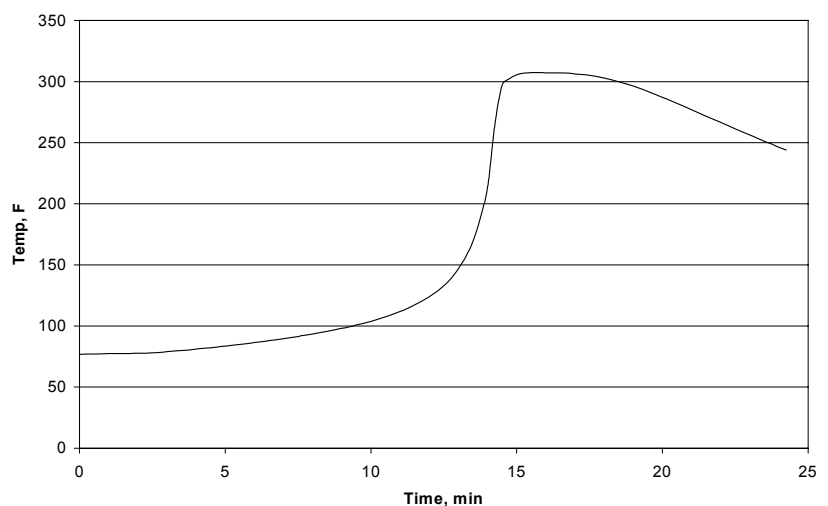
Mechanical Properties (Cured) –Room Temperature

Tensile (ASTM D638)

Strength, psi	2300-2800
Modulus, psi	75,000 – 100,000
Strain to Failure (%)	75-100

Lap Shear (ASTM D1002)

Cohesive Strength, psi	1800 – 2200
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Typical Exotherm Curve for MA821 at 75°F (10 grams)⁵

HANDLING AND APPLICATION

Plexus[®] MA821 adhesive (Part A) is flammable. Contents include Methacrylate Ester. 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. Reference the Material Safety Data Sheet for more complete safety information.

Note: Because of the rapid curing features of this product, large amounts of heat are generated when large masses of material are mixed at one time. The heat generated by the exotherm resulting from the mixing of large masses of adhesive can result in the release of entrapped air, steam, and volatile gases. To prevent this, use only enough material as needed for use within the working time for the product and confine gap thickness to no more than 0.5 inch. Questions relative to handling and applications should be directed to ITW Plexus at 800-851-6692.

DISPENSING ADHESIVE

MA821 may be applied manually or with automated equipment. Automated application may be accomplished with a variety of 10 to 1 meter mix equipment delivering both components to a static mixer. For information concerning meter-mix equipment, contact ITW Plexus Sales Representatives. Pre-measured cartridges are also available, as well as the hand-held guns with which to dispense the adhesive. For more information, contact ITW Plexus at (800) 851-6692. 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. Automated equipment should be constructed of stainless steel or aluminum. 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. Clean up is easiest *before* the adhesive has cured. Citrus terpene or N-methyl pyrrolidone (NMP) containing cleaners and degreasers can be used for best results. If the adhesive is already cured, careful scraping, followed by a solvent wipe may be the most effective method of clean up.

EFFECT OF TEMPERATURE

Application of adhesive at temperatures between 65°F and 80°F will ensure proper cure. Temperatures below 65°F will slow cure speed; above 80°F will increase cure speed. The viscosities of Parts A and B of this adhesive are affected by temperature. To ensure consistent dispensing in meter-mix equipment, adhesive and activator temperatures should be held reasonably constant throughout the year.

STORAGE AND SHELF LIFE

Shelf life of MA821 adhesive (Part A) is 1 year from day of shipment from ITW Plexus. Shelf life of activator (Part B), including cartridges that contain activators, is 9 months from day of shipment. Shelf life is based on continuous storage between 55°F and 75°F. Long term exposure above 75°F will reduce the shelf life of these materials. Prolonged exposure of activators, including cartridges that contain activators, above 100°F quickly diminishes the reactivity of the product and should be avoided. Shelf life can be extended by refrigeration (45°F - 55°F). These products should never be frozen.

Notes

- ¹ ITW Plexus 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 75°F.
- ³ Fixture Time: The interval of time after which surface being joined will support a 2 lb. (1 kg) dead weight on a 1/2 inch (12.7 mm) overlap joint 1 inch (25.4 mm) wide without movement. Times presented were tested at 75°F.
- ⁴ Resistance to chemical exposure varies greatly based on several parameters including; temperature, concentration, bondline 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 Urethane-modified super-weathering gelcoats may require an alternate adhesive. As with all substrates, these gelcoats should be tested with the selected adhesive to determine suitability.
- ⁷ Exterior applications require the use of coatings that will inhibit oxidation of the steel.

All information on this data sheet is based on laboratory testing and is not intended for design purposes. ITW Plexus makes no representations or warranties of any kind concerning this data. Due to variance of storage, handling and application of these materials, ITW Plexus cannot accept liability for results obtained.