

PLEXUS MA644

Description Plexus™ MA644 is a two-part, methacrylate adhesive designed for solid surface seaming and assembly¹. MA644 is UV stable and non-yellowing. It offers excellent adhesion to a variety of solid surface sheet materials including cast acrylic and cast/densified polyester. It exhibits high resistance to water, impact, wear scuffing, boiling water, high temperature and UV light. Combined with MA644 activator at a 10:1 ratio it has a working time of 8-13 minutes and achieves handling strength in 30 to 40 minutes.

Characteristics	Room Temperature Cure
	<ul style="list-style-type: none"> ▪ Working Time² 8 – 13 minutes ▪ Fixture Time³ 30 – 40 minutes ▪ Operating Temperature -55°C – 121°C ▪ Mixed Density 1.07 g/cc

Environmental Resistance ⁴	Excellent resistance to:
	<ul style="list-style-type: none"> ▪ Water ▪ Impact ▪ Scuffing ▪ High Temperatures ▪ Ultra Violet light (UV)

Physical Properties (uncured) – Room Temperature	Adhesive	Activator
Viscosity, cP	16,000 – 22,000	20,000 – 35,000
Colour	Off white	Off white
Density, g/cc	1.07	1.05
Mix Ratio by Volume	10	1
Mix Ratio by Weight	10.05	1

Mechanical Properties (Cured) Room Temperature	Butt Joint Tensile MPa
	<ul style="list-style-type: none"> ▪ Strength MPa 20 – 24
	4-Point Bend (ASTM D790) <ul style="list-style-type: none"> ▪ Strength MPa 41 – 55

Recommended for:	
	<ul style="list-style-type: none"> ▪ Acrylic Sheet ▪ Polyester Sheet ▪ Thermoplastics ▪ GRP / Composites ▪ Gelcoats⁶

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HANDLING AND APPLICATION

Plexus® MA644 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 9 mm. Questions relative to handling and applications should be directed to ITW Plexus at +44 (0)870 458 7588

DISPENSING ADHESIVE

MA644 may be applied manually or with automated equipment. Static mixer selection is critical to the proper mixing and performance of Plexus adhesives. For additional 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. 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 18°C and 26°C will ensure proper cure. Temperatures below 18°C will slow cure speed; above 26°C 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 MA644 adhesive (Part A) is 1 year. Shelf life of activator (Part B), including cartridges that contain activators, is 9 months. Shelf life is based on continuous storage between 12°C and 23°C. Long term exposure above 23°C will reduce the shelf life of these materials. Prolonged exposure of activators, including cartridges that contain activators, above 37°C quickly diminishes the reactivity of the product and should be avoided. These products should never be frozen. For **expiry date** see label.

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 23°C.
3. Fixture Time: The interval of time after which surface being joined will support a 1 kg dead weight on a 12.7 mm overlap joint 25.4 mm wide without movement. Times presented were tested at 23°C.
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. .

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.