

MA320 Adhesive

Submittal
Data Sheet



General

MA320 is a two-part, 10:1 opaque white methacrylate adhesive designed for bonding unprepared thermoplastics and thermosetting resins. It requires little surface preparation and no primer. Mixed adhesive is a non-sagging gel.

Typical substrate materials include:

- PVC
- ABS
- Gel-coats
- Acrylics
- Fiber Reinforced Composites (FRP)
- Epoxy-coated surfaces
- Stainless Steel
- Zenoy®

MA320 *does not* bond to concrete.

Applications

MA320 is used for joining, fabricating or repairing PVC, fiberglass, or other materials as listed above.

Physical Properties:

Property	Part A	Part B	Mixed
Viscosity (cps) - (Tb 10 rpm)	138,000	120,000	
Mix Ratio, by weight (lbs/gal)	8.6	1	
Mix Ratio, by volume	10	1	
Density (lbs/gal)	7.7	16	
Mixed Density (lbs/gal)			8.45
Flash Point, °F			51
Fixture Time* (min.) at 72 °F			25

*"Fixture Time" is the interval of time after which surfaces being joined can support a 2 lb. (1 kg) dead weight on a 1/2" (12.7 mm) overlap joint 1" (25.4 mm) wide without movement.

Shelf life is 6 months at 70° F, but may be extended by refrigeration.

Primary Ingredients:

Component A: Inhibited methacrylate ester. Contains methyl methacrylate and methacrylic acid.
Chemical formula is proprietary.

Component B: Organic peroxide solution. Contains benzoyl peroxide and butyl benzyl phthalate.
Chemical formula is proprietary.