

# Macroplexx®

structural adhesives

## TDS 3295

### General Description

**MACROPLEXX® 3295** is a second generation acrylic adhesive, designed to combine high shear strength, with high temperature resistance, with the additional qualities of a rubber toughened adhesive. The adhesive works when mixed at a 1:1 ration through a mix nozzle, as well as with a bead on bead application system. This adhesive has incredible adhesion on a wide variety of substrates, whilst maintaining very high peel and impact strengths throughout.

### Typical Applications

Sign Fabrication and Installation    Automotive Assembly    GRP Fastening Systems    Magnet Bonding

### Chemical Resistance

Excellent Resistant to:

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

### Packaging

- 25ml Syringe
- 50ml Cartridge
- 250ml Universal
- 400ml Cartridge
- Bulk Dispensing Systems

### Technical Features

Part A Colour	Green
Part B Colour	Pink
Mixed Colour	Purple
Working Time	2 Minutes
Fixture Time	6 Minutes
Viscosity	3500cps
Flash Point	12°C
Specific Gravity	1.02

### Application Instruction

Please consult Macroplexx application manual.

### Technical Notes

Macroplexx 3295 can be also applied at an offset ratio to increase the working time. The upper limit is 3.2 Part A to 1 Part B, which will allow 7 minutes open time, without any change in ultimate cured strength.

Macroplexx 3295 is suitable for paint bake cycles up to 180°C for 20 minutes.

### Typical Properties Cured Material

50% Ultimate Strength	1 Hour
Full Cure	6 Hours
Temperature Range	-35°C to 180°C
Gap Fill	3mm

### ASTM D1002 Lapshears (Tensile Result)

Steel/steel	20-35 N/mm <sup>2</sup>
Glass/Metal	16-22 N/mm <sup>2</sup>
Polycarbonate *	13 N/mm <sup>2</sup>
On ABS/ABS *	8 N/mm <sup>2</sup>

\* Substrate failure

### Suitable Substrates

Ferrites	Ceramics	Steel	Gelcoats
Acrylics	Urethanes	Aluminium	Polyesters
GRP	Vinyl	St.Steel	Wood
FRP			

### Terminology

(1) Working/Open Time: The time interval between application of adhesive to substrate, and the possible assembly/repositioning of the two mating parts @ 20°C

(2) Fixture Time: The length of time after the substrate assembly that will allow a joint to support a 1kg dead weight. (Tested on a 12mm x 25mm overlapped joint @ 20°C)

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Portobello Industrial Estate, Birtley, County Durham, United Kingdom, DH3 2RE **Tel:** +44 (0)191 411 3191 **Fax:** +44 (0)191 411 3192  
**E-mail:** [info@holdtite.com](mailto:info@holdtite.com) **Web:** [www.holdtite.com](http://www.holdtite.com)

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