Holdtite®
performance adhesives

Macroplexx® PPX5 Ultimate Plastic Bonder

Low Energy substrates, difficult to bond?

Not with PPX5!

50ml Cartridge

Designers of Plastic components are often faced with the problem of wanting to use low energy surface plastics such as Polypropylene and Polyethylene because of their inherent benefits, such as low cost, durability etc., but they then have to devise mechanical means of joining the parts to other plastics or metal, or use a variety of primers or pre-treatments that are not always particularly successful.

Macroplexx® PPX5 Ultimate Plastic Bonder has been developed to bond these surfaces effectively, with no special pre-treatments. It's a low odour, 2 part, 10:1 mix ratio thixotropic Acrylic based adhesive, which produces tough resilient bonds and is resistant to most chemicals.

Ordering Information:

50ml Adhesive: D-PPX5-50 *(Carton of 6 including 12 nozzles)*
Applicator: CM5-Gun
Additional Nozzles: CCOAX-50-10:1 *(Pack of 12)*

September 2010

Holdtite® Macroplexx® PPX5 Ultimate Plastic Bonder

Why use Macroplexx® PPX5?

- Mechanical fixings can be costly, clumsy, time-consuming to attach. They have to be designed into some mouldings thus restricting flexibility of use.
- Hotmets are not always suitable or practical for structural bonding.
- Plastic Welding tends to be for small surface edge bonding, which has only localised strength.

Typical Applications for Macroplexx® PPX5

- Rotational mouldings, generally made in PE or PP, can have metal inserts included in the process *(but only on the outside surface of the mould)*, slowing down the moulding cycle and increasing the cost. Macroplexx® PPX5 allows fasteners and fixings to be applied afterwards, inside or out, thereby increasing the possible design combinations.
- Filters often have polypropylene end-caps or casings which can be sealed and bonded with Macroplexx® PPX5.
- Metal Grilles and other fittings can be bonded into PE engine covers, equipment casings etc.

TECHNICAL DATA	Part A - Resin	Part B - Hardener
Colour:	Off white	Translucent
S.G:	0.99	0.98
Viscosity sp3 @10 rpm Brookfield:	7,500-8,500cps	5,000-6,000cps
Base Resin:	Methacrylate	Amine
Mix Ratio:	10	1
Handling Time - Light Duty:	<20 minutes	
Handling Time - Heavy Duty:	2 hours	
Working time in Nozzle @ 20°C:	2.5 - 3.5 minutes	
Full cure to achieve structural integrity:	24 hours minimum	
Flash Point:	>85°C	
Peak Exotherm:	<25°C	

TYPICAL BONDED PROPERTIES (ASTM D1002)		
PE	Substrate Failure	>8N/mm²
PP	Substrate Failure	>8 N/mm²
LDPE	Substrate Failure	>6 N/mm²
ABS	Substrate Failure	>7 N/mm²
Polycarbonate	Substrate Failure	>6 N/mm²
PMMA	Substrate Failure	>7 N/mm²
Polystyrene	Substrate Failure	>5 N/mm²
PVC (hard)	Cohesive Failure	>10 N/mm²
FRP	Cohesive Failure	>15 N/mm²
Aluminium / Aluminium	Cohesive Failure	>14 N/mm²
Stainless / PE	Substrate Failure	>8 N/mm²
Mild Steel / PE	Substrate Failure	>8 N/mm²
Aluminium / PE	Substrate Failure	>8 N/mm²
Oiled Steel	Cohesive Failure	>12 N/mm²

Contact our Customer Support Department on: **+44 (0)191 411 3191** or email **enquiries@holdtite.com**

Holdtite Adhesives Ltd, Portobello Industrial Estate, Birtley, Chester-Le-Street, County Durham, DH3 2RE. UK. www.holdtite.com