

Macroplexx[®] structural adhesives 3000 / 4000 / 5000 / 6000 series

3000 Series - Toughened Acrylics

Ref. No.	Mix Ratio	Application / Description	Colour	25ml Syringe	50ml	250ml Bottle	280ml UniC	310ml	380ml	400ml	Bulk	Working Time In Nozzle (minutes)	Functional Strength (hours)	Fixture Time (minutes)	Viscosity Range (cps)	Gap Fill (mm)	Bond Strength (N/mm ² Steel)
3294	1:1	Metals / Ceramics / Plastics / Wood / GP Bonder	Green / Black	✓	✓						✓	2-3 mins	< 30 mins	5 mins	< 5000 cps	Up to 1mm	<20N/mm ²
3295	1:1	Metals / Ceramics / Plastics / Wood / GP Bonder	Pink / Green	✓	✓					✓	✓	2-3 mins	< 30 mins	5 mins	< 4500 cps	Up to 1mm	<25N/mm ²
3299	1:1	Low Odour GP Bonder, Non-flammable	Blue / Cream	✓	✓						✓	2-4 mins	Up to 1 hour	6 mins	< 6000 cps	Up to 0.5mm	22-25N/mm ²
3326	1 Part	Metals / Ferrites / Mix in bondline (1 min), Use 7500 Activator	Amber / Trans	✓	✓	✓		✓			✓	No Mix / Act	< 30 mins	1 min	10 - 15000 cps	< 0.5mm	20-24N/mm ²
3327	1:1	Metals / Ferrites / Mix in nozzle (2 mins)	Semi Trans.		✓	✓				✓	✓	Up to 3 mins	< 30 mins	3 - 4 mins	10 - 20000 cps	< 0.35mm	<25N/mm ²
3329	1 Part	Metals / Plastics / Glass, mix in bondline fast, Use 7600 Activator	Amber / Trans		✓			✓			✓	No Mix / Act	40-75 mins	< 2 mins	30 - 40000 cps	< 0.25mm	<30N/mm ²
3330	1 Part	Metals / Plastics / Glass, mix in bondline fast, Use 7600 Activator	Amber / Trans		✓			✓			✓	No Mix / Act	40-75 mins	< 2 mins	30 - 40000 cps	< 0.25mm	<30N/mm ²

4000 Series - Low Odour Methacrylates

Ref. No.	Mix Ratio	Application / Description	Colour	25ml Syringe	50ml	250ml UniC	280ml UniC	310ml	380ml	400ml	Bulk	Working Time In Nozzle (minutes)	Functional Strength (hours)	Fixture Time (minutes)	Viscosity Range (cps)	Gap Fill (mm)	Bond Strength (N/mm ² Steel)
4020	1:1	Metals / Plastics / Ceramics / Ferrites, fast cure rate	Semi Trans.	✓	✓	✓				✓	✓	1-2 mins	30-60 mins	2-4 mins	8 - 10,000 cps	0.25mm	20 - 25N/mm ²
4040	1:1	Metals / Plastics / Ceramics / Ferrites, moderate cure	Semi Trans.	✓	✓	✓				✓	✓	2-4 mins	30-60 mins	4-6 mins	8 - 10,000 cps	0.25mm	20 - 25N/mm ²
4060	1:1	Metals / Plastics / Ceramics / Ferrites, controlled cure	Semi Trans.	✓	✓	✓				✓	✓	8-10 mins	1-2 hours	12-18 mins	10,000 Thixotropic	0.25mm	20 - 22N/mm ²
4121	1:1	Metals / Ceramics / Plastics / Wood / Glass / GP Bonder	Purple / Green	✓	✓	✓				✓	✓	2-3 mins	< 30 mins	5 mins	Mobile gel	Up to 1mm	<25N/mm ²

5000 Series - Methacrylates

Ref. No.	Mix Ratio	Application / Description	Colour*	25ml Syringe	50ml	250ml UniC	280ml UniC	310ml	380ml	400ml	Bulk	Working Time In Nozzle (minutes)	Functional Strength (hours)	Fixture Time (minutes)	Viscosity Range (cps)	Gap Fill (mm)	Bond Strength (N/mm ² Steel)
5005	1:1	Metal / Composite Bonder, very fast set time	Natural	✓	✓					✓	✓	3-4 mins	1-2 hours	6-8 mins	100-150,000 cps	Up to 3mm	20N/mm ²
5020	1:1	Metal / Composite Bonder, fast set time	Natural	✓	✓	✓				✓	✓	5-7 mins	2-4 hours	10-12 mins	150-200,000 cps	Up to 5mm	20N/mm ²
5028	1:1	Metal / Composite Bonder, fast set time	Natural								✓	6-7 mins	2-4 hours	12-15 mins	200-400,000 cps	Up to 6mm	20N/mm ²
5030	1:1	Metal / Composite Bonder, moderate set time	Natural	✓	✓	✓				✓	✓	10-12 mins	4-6 hours	18-20 mins	150-200,000 cps	Up to 5mm	20N/mm ²
5038	1:1	Metal / Composite Bonder, moderate set time	Natural								✓	Up to 25 mins	4-6 hours	25-35 mins	200-400,000 cps	Up to 10mm	20N/mm ²
5060	1:1	Metal / Composite Bonder, long wet time	Natural		✓	✓				✓	✓	40-50 mins	6-10 hours	55-65 mins	150-350,000 cps	Up to 8mm	Up to 18N/mm ²
5510	10:1	Plastic / Composite Bonder, controlled cure	Blue						✓	✓	✓	15-20 mins	2-4 hours	25-35 mins	200-350,000 cps	Up to 20mm	Up to 18N/mm ²
5520	10:1	Plastic / Composite Bonder, fast set time	Blue						✓	✓	✓	6-8 mins	1-2 hours	10-15 mins	60-200,000 cps	Up to 8mm	18N/mm ²
5528	10:1	Plastic / Composite Bonder, fast set time (high viscosity)	Blue							✓	✓	8-10 mins	2-4 hours	12-18 mins	100-300,000 cps	Up to 10mm	Up to 18N/mm ²
5530	10:1	High Flexibility / Low Exotherm / Plastic / Composite Bonder	Blue						✓	✓	✓	2-4 mins	1-2 hours	8-10 mins	60-200,000 cps	Up to 10mm	18N/mm ²
5538	10:1	High Flexibility / Low Exotherm / Plastic / Composite Bonder	Blue / White						✓	✓	✓	20-30 mins	2-4 hours	25-35 mins	150-300,000 cps	Up to 20mm	Up to 16N/mm ²
5545	10:1	High Flexibility / Low Exotherm / Plastic / Composite Bonder	Blue						✓	✓	✓	25-35 mins	4-6 hours	30-40 mins	150-300,000 cps	Up to 20mm	18N/mm ²
5560	10:1	High Flexibility / Low Exotherm / Plastic / Composite Bonder	White						✓	✓	✓	45-55 mins	4-6 hours	60-80 mins	150-300,000 cps	Up to 30mm	10N/mm ²

6000 Series - Epoxies

Ref. No.	Mix Ratio	Application / Description	Colour	25ml Syringe	50ml	250ml UniC	280ml UniC	310ml	380ml	400ml	Bulk	Working Time In Nozzle (minutes)	Functional Strength (hours)	Fixture Time (minutes)	Viscosity Range (cps)	Gap Fill (mm)	Bond Strength (N/mm ² Steel) (*72 hours @ 25°C)
6001	1:1	Multi-Purpose / Plastics / Metals / very fast cure rate	Clear	✓	✓					✓	✓	< 60 secs	< 1 hour	90 secs	10-20,000 cps	0.25mm	< 18N/mm ²
6005	1:1	Multi-Purpose / Plastics / Metals / cures in under 5 mins	Clear	✓	✓	✓				✓	✓	< 3 mins	1-2 hours	5 mins	20-60,000 cps	0.5mm	< 22N/mm ²
6012	1:1	Industrial Strength / Plastics / Metals / Composites	Pale Straw	✓	✓					✓	✓	< 8 mins	2-4 hours	12 mins	30-50,000 cps	< 2mm	16 - 18N/mm ²
6030	1:1	Multi-Purpose / Industrial Applications / Controlled Cure	Pale Straw		✓	✓				✓	✓	< 20 mins	4-6 hours	30 mins	30-50,000 cps	< 2mm	16 - 18N/mm ²
6060	1:1	Multi-Purpose / Industrial Applications / Controlled Cure	Pale Straw		✓	✓				✓	✓	< 45 mins	10-12 hours	60 mins	40-60,000 cps	< 2.5mm	16 - 18N/mm ²
6090	1:1	Multi-Purpose / Industrial Applications / Controlled Cure	Pale Straw		✓					✓	✓	< 75 mins	12-24 hours	90 mins	30-50,000 cps	< 2.5mm	16 - 18N/mm ²
6100	1:1	Fast cure metal repair - Non conductive	Metal	✓	✓					✓	✓	< 10 mins	1-2 hours	30 mins	Thixotropic Paste	Large	< 20N/mm ²
6110	1:1	Fast cure metal repair - Contains steel particles	Metal	✓	✓					✓	✓	< 10 mins	1-2 hours	30 mins	Thixotropic Paste	Large	< 25N/mm ²



* Also available in white, grey, black and specific colours

All the data provided is for guidance purposes only and is not intended for specification. It is the users responsibility to determine the suitability of the products and methods of use or preparation as Holdite and its agents cannot assume liability or responsibility for results obtained in the use of its products by persons who's methods are outside or beyond our control. Product samples available on request.

Test methods - ASTM D1002