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TECHNICAL DATA SHEETS
MP 54420

Description:

MP 54420 is a two part acrylic / epoxy hybrid adhesive designed for bonding metals and plastics. It cures quickly at room temperature to a tough, semi-rigid material. It has good wetting to most surfaces and has controlled flow characteristics to give good wetting without excessive running or dripping. This product gives very good vibration and impact resistance. It gives good resistance to water, salt spray, inorganic acids and bases and most organic solvents.

It was especially formulated to a 2A:1B volume mix ratio for use in side-by-side dispensing cartridges and meter/mix and dispense equipment. **MP 54420** will reach handle cure at room temperature within 6 – 12 hours. Cure time can be accelerated by the application of heat. Times and temperatures from 2 hours at 65°C to 30 minutes at 100°C are typical for most applications. Time to heat substrate must be taken into account. Cooler temperatures will also extend work time and increase cure times.

INSTRUCTIONS:

1) Bring to room temperature before use.

2) Weigh and mix parts A and B accurately and thoroughly, scraping sides of container often. Pre-bleed side-by-side cartridges, discarding the first 3 inches of dispensed material. Maintain adequate velocity during dispensing to ensure complete mixing.

3) Allow to cure undisturbed.

Handling and Physical Properties:

All properties given are at 25°C unless otherwise noted.

Color		Off- White
Viscosity	Part A	40,000 cps
	Part B	30,000 cps
	Mixed	35,000 cps *
Specific Gravity	Part A	1.15
	Part B	1.04
	Mixed	1.12
Pot Life		20 minutes
Mass		50 grams
Hardness Shore - D		75 - 80
Temperature Range		-60 to 150°C
Tensile Elongation		2.75%
Tensile Strength		9000 psi *
Tensile Lap Shear (2024 T3 Aluminum Abraded / MEK Wipe)		4500 psi
T-peel Strength (Al to Al)		25 pli *
Dielectric Constant (25C, 100Hz)		4.5 *
Dielectric Strength		440 v/mil *
Volume Resistivity		8 x 10^{14} ohm-cm *

MIX RATIO:

Mix Ratio (Part A to B):	
by weight	225 to 100
by volume	2 to 1
CURE SCHEDULE:	24 hours at 25°C or 2 hours @ 65°C
SHELF LIFE:	12 Months