

Revised
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TECHNICAL DATA SHEETS
MP 5404-FS

Description:

MP 5404-FS is a one component, heat curable thixotropic paste epoxy adhesive. It is a non-sag adhesive, which forms strong bonds to metals and ceramics. **MP 5404-FS** has exceptional thermal stability and resistance to water, humidity and solvents. This product offers high heat resistance and cures in less than 20 seconds via induction or infrared heating.

Typical Applications:

- Permanent Magnet Motors and Loudspeaker Assembly
- Air Conditioning Joint Tubes and Compressors
- High Temperature Structural Bonding
- Filter End Cap and Side Seam Assembly

Physical Properties:

Standard Color	Gray
Specific Gravity	1.41 @ 25 °C
Viscosity	500,000-700,000 cps @ 25 °C
Press Flow	60-80 seconds
Sag Resistance	0.315" - 0.400"
Tensile Strength	6,300 psi Typical
Lap Shear Strength	3,000 psi Typical
Hardness	85 Shore D @ 25 °C
Elongation	>1.5%
Impact Strength	0.36 ft lbs/in
CTE	5.72 x 10 ⁻⁵ in/in °C
Tg	148 C
Operating Temperature Range	-40 to 400 °F
Thermal Conductivity (BTU/HR/FT ² / F/FT)	235
Unleaded Gasoline Resistance (1,500 Hrs.)	3,200 psi Typical Prior to test 3,200 psi Typical After 1500 hours of submersion

Storage:

<32 °F	75 °F	100 °F
12 months	6 months	2 weeks

Cure Schedule:

250 °F	300 °F	350 °F	Induction @ 400 °F
7 min.	1 min.	30 sec.	<20 seconds

Engineering Excellence

For technical information
and support call **1-800-552-0299** or visit our website at

www.instantca.com