

Revised
January 2002



9411 Corsair Road
Frankfort, IL 60423
1-800-552-0299 Phone
1-815-464-5650 Fax

EMERGENCY PHONE 1-800-255-3924

TECHNICAL DATA SHEETS

MP 5405NS

Description:

MP5405NS is a two part unfilled epoxy adhesive designed for high speed bonding of metals, ceramics, and most plastics. It cures to a tough semi-rigid material, and is a thixotropic paste consistency to prevent running and sagging. It gives good resistance to water, salt spray, inorganic acids and bases, and most organic solvents. It was especially formulated to a 1:1 mix ratio for use in either MMD equipment or side-by-side dual cartridges for easy dispensing.

A handling cure is normally achieved at room temperature within 20 - 30 minutes with full cure in 24 hours. An elevated temperature cure schedule can be used to reach final properties quickly.

Handling and Storage:

- 1) Bring both components to room temperature prior to mixing. Mix 1 parts A to 1 part B thoroughly.
- 2) Allow to cure undisturbed until product is fully gelled or tack-free to the touch.
- 3) Clean up uncured resin with suitable organic solvent such as MEK, acetone or a chlorinated solvent.

Mix Ratio:

1A:1B by weight or 1A:1B by volume.

Shelf Life:

12 Months

Handling Characteristics:

All properties given are at 25C unless otherwise noted.

| | |
|--|-------------------------------|
| Color | Translucent/White |
| Viscosity Part A | 1,500,000 cps |
| Part B | 1,500,000 cps |
| Mixed | Non-sag Paste |
| Specific Gravity Part A | 1.17 |
| Part B | 1.15 |
| Mixed | 1.16 |
| Pot Life | 3 - 5 minutes |
| Mass | 20 grams |
| Tensile Strength Lap Shear (Al to Al) | 2800 psi |
| Tensile Elongation | 3 - 5% * |
| Tensile Strength Temperature Range | 7000 psi * -40 to 130C |
| Hardness Method | 80 Shore -D |
| Linear Coefficient of Thermal Expansion | (x 10 (6))/C 62 * |
| Dielectric Constant (25C, 100Hz) | 4.5 * |
| Dielectric Strength | 410 v/mil * |
| Volume Resistivity | 8 x 10 ¹⁴ ohm-cm * |

Engineering Excellence

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

www.instantca.com