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TECHNICAL DATA SHEETS
MP54216CL

Description:

MP54216CL is a two part mineral filled epoxy adhesive designed for bonding metals and plastics. It cures at room temperature to a tough, semi-flexible material. It has good wetting to most surfaces and is free flowing to penetrate cavities and give good self leveling and air release. 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 1A:1B volume mix ratio for use in side-by-side dispensing cartridges and meter/mix and dispense equipment. **MP54216CL** will reach handle cure at room temperature within 16 – 24 hours. Cure time can be accelerated by the application of heat. Times and temperatures from 2 hours at 65°C to 20 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.

PROPERTIES OF UNCURED PRODUCT (typical value)
All properties given are at 25°C unless otherwise noted.

Color		Clear
Viscosity	Part A	80,000 cps
	Part B	80,000 cps
	Mixed	80,000 cps
Specific Gravity	Part A	1.34
	Part B	1.31
	Mixed	1.32
	Pot Life	1 hour
	Mass	100 grams
	Hardness Shore - D	70
	Temperature Range	-60 to 150°C
	Tensile Elongation	60 %
	Tensile Strength	1800 psi
	Tensile Strength Lap Shear (Al to Al)	3000 psi
	T-peel Strength (Al to Al)	25 pli *
	Dielectric Constant (25C, 100Hz)	4.5 *
	Dielectric Strength	410 v/mil *
	Volume Resistivity	8 x 10^{13} ohm-cm *

Tg is 16C, - actual tested
CTE is about 50ppm/C below the Tg and about 150ppm/C above the Tg

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.

MIX RATIO:

Mix Ratio (Part A to B):	
by weight	103 to 100
by volume	1 to 1

CURE SCHEDULE: 24 – 72 hours at 25°C
or 1 hour @ 60°C

SHELF LIFE: 12 Months