Adhesive Systems, Inc.

TECHNICAL DATA SHEET
TDS #: MP55420
METHACRYLATE ADHESIVE

MAXIMUM PERFORMANCE SERIES
MP55420 METHACRYLATE ADHESIVE

DESCRIPTION:

MP55420 is a high performance two part methacrylate adhesive engineered to bond a wide range of plastics, metals, and composite assemblies. It offers outstanding bond strength, is extremely durable, with excellent impact and weathering properties. *MP55420* greatly increases the reliability of finished assemblies with exceptional flexibility, it's ability to with stand extreme temperature fluctuation and thermal cycling, and resistance to a wide range of chemicals and environmental conditions.

PHYSICAL PROPERTIES (UNCURED):

VISCOSITY @ 25^{0}C (cps):	RESIN	100,000
	ACTIVATOR	50,000
COLOR:	OFF WHITE	AMBER.SHELL
MIXED DENSITY:	8.00	
MIX RATIO:	VOLUME	10 TO 1
	WEIGHT	10 TO 1
THIX INDEX:	5	
FLASH POINT:	51^{0}F	

PHYSICAL PROPERTIES (CURED):

STRENGTH (PSI):	SHEAR	1750-2800
	TENSILE	2500-3500
WORK TIME:	4-6 MINUTES	
HANDLING STRENGTH:	15-20 MINUTES	
GAP FILL:	.25 INCHES	
TEMPERATURE RANGE:	-40^{0}F - +250^{0}F	

WHAT THE MP SERIES BONDS:

METALS
- *ALUMINUM
- *STEEL
- *STAINLESS
- *COATED METALS

THERMO SETS
- *FIBERGLASS
- *PHENOLICS
- *GEL COATS
- *EPOXY
- *RIM URETHANE
- *POLYURETHANE
- *LIQUID MOLDING RESINS

THERMO PLASTICS
- *ACRYLICS
- *ABS
- *POLYCARBONATES
- *NYLONS
- *PPO's
- *VINYL'S
- *PVC's
- *STYRENE'S
- *PBT BLENDS
- *PET BLENDS

BENEFITS:

>NO SURFACE PREP
>EXCELLENT STRENGTH
>IMPACT RESISTANT
>100% REACTIVE
>ROOM TEMPERATURE CURE
>EASILY APPLIED

PACKAGING:

The MP 55420 Series is conveniently packaged in 380 mil cartridges, pail, and drum kits. Special packaging is available upon request.

EFFECTS OF TEMPERATURE:

The product is best used at temperatures between 65^0 F and 80^0 F. Temperatures below 65^0 F will slow the cure speed of the material and viscosities will be higher. Temperatures above 80^0 F will cause the material to cure faster and viscosities will be lower. For consistent dispensing maintain temperature in the above mentioned range.

STORAGE AND SHELF LIFE:

The shelf life of the MP55300 Series is six month from date of shipment. Shelf life is based on the products being stored properly at temperatures between 55^0 F and 75^0 F. Exposure to temperatures above 75^0 F will reduce the shelf life of these materials. These products should NEVER BE FROZEN.

PRECAUTIONS:

ASI's MP55300 Series products are *flammable.* Keep away from heat, spark, and open flames.

KEEP OUT OF REACH OF CHILDREN. THE PRODUCT IS FOR INDUSTRIAL USE ONLY. Keep containers closed when not in use. Avoid contact with skin and eyes. Harmful if swallowed. Refer to Material Safety Data Sheet for complete safety information.

HANDLING AND CLEAN-UP:

For optimum bond strength and to insure maximum performance in the finished assembly mate parts together within the specified work time of the adhesive. Make sure the bond joint has uniform coverage and that a sufficient amount of adhesive is in the bond area. It is important to have the adhesive applied, parts aligned and positioned, within the established work times for the product. To ensure maximum performance in the finished assembly parts should remain undisturbed until the fixture time is reached.

Clean up is best before the adhesive has cured. Cleaners containing NMP (N-methyl pyrolidone) or Citrus terpene provide the best results. On cured adhesive repeat use may be required.