



MP5405

MP5405 is a two part unfilled epoxy adhesive designed for ceramics, and most plastics. It cures to a tough semi-rigid material, and is a free flowing viscosity. 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. Handling strength is normally achieved at room temperature within 3-5 minutes with full cure in 24 hours. An elevated temperature cure schedule can be used to reach final properties quickly.

Technology / Base	Epoxy
Type of Product	Structural Adhesive
Components	Two Component
Curing	Room Temperature (secondary thermal cure)
Appearance / Color	Clear
Consistency	Liquid

Features and Benefits

- Excellent Adhesion Properties
- Excellent Bonding to Metals, Ceramics and Most Plastics
- Excellent Chemical Resistance
- Suitable for Cartridge and MMD Dispensing Equipment
- Excellent Thermal Performance
- 100% Reactive
- Room Temperature Cure
- 1:1 volume mix product for easy meter or static mix of application

Technical Data

Rheology	Value	Condition/Method
Viscosity - Part A	12,000 cPs	at 25°C
Viscosity - Part B	13,000 cPs	at 25°C
Viscosity - Mixed	12,500 cPs	at 25°C
Uncured Material Characteristics		
Specific Gravity - Part A	1.16	
Specific Gravity - Part B	1.15	
Specific Gravity - Mix	1.16	
Volume Mix Ratio	1 to 1	
Weight Mix Ratio	1 to 1	
Pot Life	3 to 5 min	at 25°C 20 gram
Gel Time		20 gram
Handling Time	3 to 5 min	
Full Cure @ 23°C	24 hours	
Full Cure @ 66°C		
Shelf Life	12 months unopened	
Cured Mechanical Properties		
Hardness	80 Shore D	ASTM D2240
Tensile Strength	48.3 MPa (7000 psi)	ASTM D638
Elongation at Break	3 to 5 %	ASTM D638
Overlap Shear Strength		
Aluminum, Acid Etched at 25°C	15.9 MPa (2300 psi)	ASTM D1002, 25°C 50% RH
Operating Temperature	-40°C to 130°C (-40°F to 265°F)	
Cured Electrical Properties		
Dielectric Constant	4.5 at 25°C, 100Hz	ASTM D150
Dielectric Strength	16.1 kV/mm	ASTM D149
Volume Resistivity	8 E 14 ohm-cm	ASTM D257



General Instructions

Surfaces to be bonded must be clean, dry and free of other contaminants. Bring both components to room temperature prior to mixing. Measure out specified amounts of parts A and B and mix without introducing bubbles until homogenous. Alternately use a static mixing nozzle. Apply to device allowing air to escape between and under components. Allow to cure undisturbed until product is fully gelled or tack-free to the touch.

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Specifications and Approvals

Handling and Clean-Up

See SDS for handling and clean-up information.

Storage

Product should be stored in a cool dry place out of direct sunlight. The shelf life is from date of manufacture. Shelf life is based on the products being stored properly at temperatures between 12°C and 25°C. Exposure to temperatures above 25°C will reduce the shelf life. This product should not be frozen.

Use Note

Safety and Disposal

See SDS for