



**MAXIMUM PERFORMANCE SERIES**

**SIGN INDUSTRY**

**METHACRYLATE ADHESIVE**

***MP 55000 Series.....Our All Star Structural Adhesive  
Used For The Sign Industry!***

**Instructions for Applying Our MP 55000 Series Methacrylate Adhesives**

**Methacrylate Adhesives**

MMA's are a unique balance of high tensile, shear and peel strengths with the maximum resistance to shock, stress and impact across a wide temperature range. Methacrylates(MMA) can generally be used without surface preparation when joining plastics, metals and composites. They are two component reactive materials based on methyl methacrylate monomer that, when mixed together, have a controlled cure speed based on the appropriate application process. Methacrylates are tolerant to off ratio mixing and remain strong and durable under severe environmental conditions. They resist water and solvents to form an impenetrable bond.

**Surface Preparation**

Some adhesives generally need some surface preparation before bonding which may take the form of abrasion, priming, solvent, or chemical cleaning. Light abrasion of the surface gives a better key to the adhesive than does a high polish. Freshly abraded surfaces usually are better for achieving good bond strength. Abrade aluminum to remove oxidation.

***Brushing/Sanding***

Coarse stiff brush is used to rub the surface.

***Blasting***

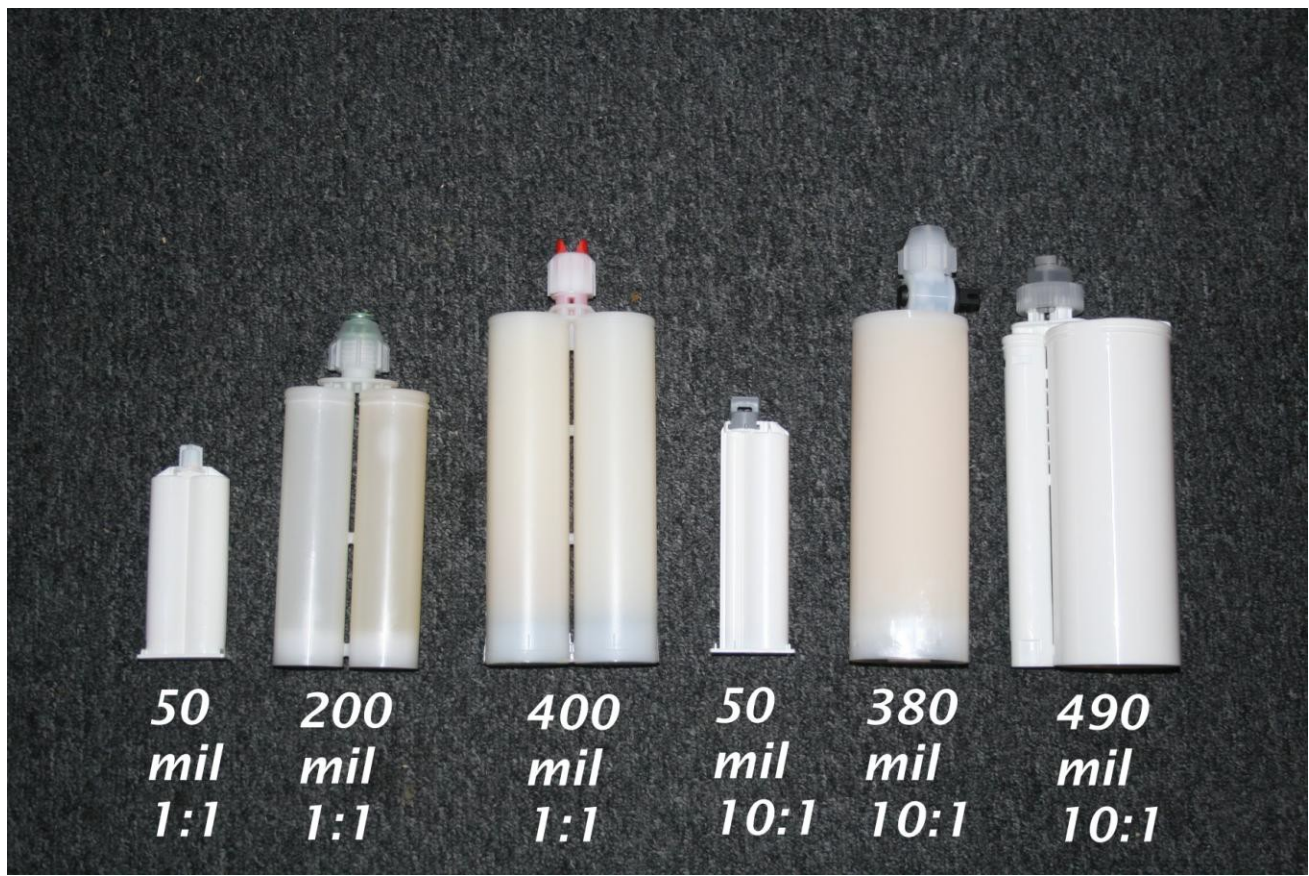
Shot blasting, where small sharp pieces of the blast medium impact the surface

***Isopropyl Alcohol/Solvent wipe***

Using a soaked material to wipe the surface of the part until clean and contaminants removed.

### Cartridge Sizes

Each cartridge has a manual gun appropriate for use with that specific size cartridge.



### How to Apply

Our MP 55000 Series Methacrylates are generally applied using a dispensing gun. We have guns available for a variety of cartridge sizes. The guns can be operated manually or pneumatically.



Needed materials: Cartridge of Adhesive, static mixer, and dispensing gun

1. Unscrew the cap from the cartridge. Pull out the plug that keeps the adhesive from leaking out of the cartridge when the cartridge is not in use.



**2.** Place the cartridge into the dispensing gun.



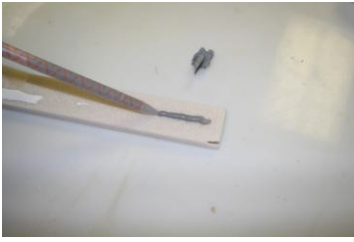
**3.** Purge the cartridge containing the adhesive by activating the dispensing gun. This purging process ensures that the dispensing gun is pushing out both parts of the adhesive before placing the mixer on the cartridge. This should be done in manner that dispenses a small amount of material.



**4.** Attach the static mixer to the nozzle of the cartridge containing the adhesive. The static mixer will allow for the appropriate mixture of the two parts of the methacrylate when applying the product to the substrate being bonded. Be sure to replace the cap over the static mixer to allow for a good connection between the mixer and the cartridge.



**5.** Dispense an appropriate size bead (uniformed coverage) of the methacrylate on to the substrate by pointing the tip of the mixer to the substrate while activating the dispensing gun.



6. Once the application is completed, remove the cap and the static mixer.



7. Replace the plug into to cartridges nozzle. Then take the cap and place that back on to the cartridge containing the used methacrylate.



Technical Data Sheets are available for our MP 55000 Series Methacrylates. The following chart is also available on our website at [www.instantca.com](http://www.instantca.com).

PRODUCT	RATIO	COLOR	VISCOSITY	WORK TIME	FIXTURE TIME	ALUMINUM PSI	STEEL PSI
MP 55300	1 to 1	Natural	Non-Sag	6-8 Min.	10-15 Min.	2,450	> 3000
MP 55305	1 to 1	Straw	Non-Sag	2-3 Min.	5-6 Min.	2,450	> 3000
MP 55310	1 to 1	Natural	Non-Sag	10-12 Min.	15-25 Min.	3,700	> 3000
MP 55350	1 to 1	Natural	Non-Sag	60-90 Min.	30-40 Min.	2,350	> 3000
MP 55420SC	10 to 1	Straw	Non-Sag	8-12 Min.	25-35 Min.	> 2500	> 2500
MP 55420	10 to 1	Straw	Non-Sag	6-9 Min.	15-22 Min.	> 2500	> 2500
MP 55420FS	10 to 1	Straw	Non-Sag	3-6 Min.	5-8 Min.	>2500	>2500

\* NOTE

Strength=Pounds Per Square Inch PSI

Open Time=Work Time

Set Time=Fixture Time

NON-WARRANTY: Information contained herein is based on tests we believe to be reliable and accurate. It is offered in good faith for the benefit of the consumer. Adhesive Systems shall not be liable for any injury, loss, or damage in the use of it's chemical products since the conditions of use are beyond our control. In every case we urge and recommend the user conduct tests to determine to their own satisfaction that the product is of acceptable quality and is suitable for their particular purpose under their own operating conditions. Statements concerning the possible use of our products are not intended as recommendations to use our products in the infringement of any patent. Because of changing reporting requirements and other variables it is impossible to guarantee the accuracy of the information contained in this document. It is the responsibility of the user to determine proper personal protection based on the actual condition of use and to comply with all Federal, State, and Local laws and regulations.

## Dispensing Guns



50 mil gun for 50 mil cartridges 1:1 and 10:1



200 mil gun for 200 mil cartridges 1:1



400 mil gun for 400 mil cartridges 1:1



400 mil pneumatic gun for 400 mil cartridges 1:1



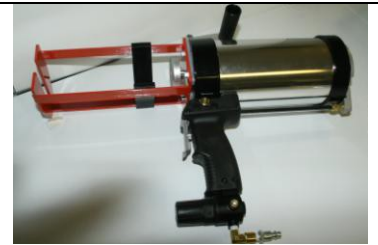
380 mil pneumatic Gun for 380 mil 10:1



380 mil gun for 380 cartridges 10:1



490 mil gun for 490 cartridges 10:1



490 mil pneumatic gun for 490 mil cartridges 10:1