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**TECHNICAL DATA SHEETS**

***MP 55350***

**Low Exotherm, Long open time  
1:1 Mix ratio**

**PRODUCT DESCRIPTION**

MP 55350 is a 1:1 meter- mix, modified methacrylate adhesive, that features an extended open time for bonding large components or for prolonged assembly operations. MP 55350 offers outstanding adhesion to a wide variety of materials, including fiberglass, composites, vinyl esters, gelcoats, thermoplastics, and metal. Surface preparations, such as sanding , priming, or chemical wipes are generally not required for good adhesion. MP 55350 exhibits high strength and superior toughness over a wide temperature range including subzero temperatures. The formulation has special materials to curtail odor after application and during the long open time. This product has a unique benefit to end users concerned with read-through, it has a low exotherm in large masses to prevent sensitive parts from seeing distortion.

**UNCURED PROPERTIES**

	Part A	Part C
Viscosity, cps (#7, 2.5 rpm).....	305000	220,000
Viscosity, cps (#7, 20 rpm).....	76,000	50,000
Thixo ratio	5	4
Color.....	natural	amber
Mix Ratio (wt & volume).....	1:1	

**CURING PROPERTIES\***

Open Time.....	<b>60-75 minutes</b>
Gel Time.....	<b>60-75 minutes</b>

**Fixture time** .....85-95 minutes  
**Exotherm temp ( Max)** ..... 90C (50gram mass)\* Curing

properties are highly dependent on the specific application and the materials being bonded. The ranges used here are based on representative examples of typical applications. Above values with 10 gram mass mixed in an open cover in a controlled lab test unless otherwise stated.

### **CURED PROPERTIES**

Hardness ..... Shore D 60-65  
Elongation.....20-30%  
Operating Temp.....-40° - 250°F

### **BOND PERFORMANCE**

Steel/Steel.....>3300 psi	Aluminum/Aluminum.....>1500 psi
E-Coat/E-Coat.....Stock Failure	Fiberglass/Fiberglass.....Stock Failure
GelCoat/GelCoat.....Stock Failure	SMC.....Stock Failure
ABS.....Stock failure	PMMA/PMMA.....Stock Failure
Peel Strength, Steel/Steel(ASTM D1876).....20 pli	
Impact Strength FG/FG, Auto Side Impact.....>3.78 J	

### **CHEMICAL RESISTANCE**

MP 55350 exhibits excellent resistance to commonly encountered service environments and chemicals. Depending on the materials being bonded, MP 55350 will retain bond strength in boiling water, salt water, salt fog, kerosene, gasoline, diesel fuel, antifreeze, hydraulic fluids, and cutting oils. Resistance to specific chemicals and environments must be tested. NOT RECOMMEND FOR EXPOSURE TO: Crude oil, toluene, MEK, Acetone, 100% low molecular weight aromatics, aldehydes, and ketones.

### **PACKAGING & SHELF LIFE**

MP 55350 is available in cartridges, pails, and drums. The material can be used with conventional meter/mix/dispense equipment. All materials should be stored in a cool place when not used for an extended period of time. Shelf life of this product is 8-12 months at 23°C when stored in original sealed container. Shelf life may be extended with refrigeration. Do not freeze.

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## **Engineering Excellence**

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

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