

Revised
June 2003



9411 Corsair Road
Frankfort, IL 60423
1-800-552-0299 Phone
1-815-464-5650 Fax

EMERGENCY PHONE 1-800-255-3924

TECHNICAL DATA SHEETS

MP 55420

Description:

MP 55420 is a 1:1 meter mix methacrylate-based structural adhesive designed for bonding fiberglass components to themselves or metals and or plastics. **MP 55420** forms tough, durable bonds to many diverse substrates including, plastics, composites and metals. Surface cleaning, preparation or the use of primers, or chemical wipes is not needed on composites. This is a medium fast curing product with an open time of the mixed adhesive in 6 minutes and fixture in 18-20 minutes. The cure time is designed for normal manufacturing processed where a medium open time and normal fixturing is required. **MP 55420** has a non sag viscosity which can support $\frac{3}{4}$ " diameter bead on vertical surfaces. The high thixo ratio allows for easy dispensing out of 50ml and 400ml cartridges through mixer tubes as well as bulk dispensing equipment.

Uncured Properties:

Viscosity	Part A	Part B
	900,000 cps	900,000 cps
Thixotropic ratio	6	6
Density(lbs/gal)	8	8
Color	off white	amber
Flash Point	51°F	51°F
Mix ratio	1:1	

Cured Properties:

Mixed Viscosity	2000,000
Mixed Density	8
Fixture Time	18-20 minutes
Full cure time	4 hours
Operating Temp	-60 - 250°F
Hardness	72-77 Shore D
Color	Light amber

Bond Performance:

Tensile Shear $\frac{1}{2}$ " overlap
Fiberglass – Fiber tear
Steel—3400-4050psi

ABS—Stock failure

PVC—Stock failure

Aluminum—13.0ft lbs/in²

Chemical resistance:

MP 55420 exhibits excellent resistance to commonly encountered service environments and chemicals. Depending on the materials being bonded, **MP 55420** will retain bond strength in hot water, salt water, salt fog, kerosene, gasoline, diesel fuel, antifreeze, hydraulic fluids, and cutting oils. Resistance to specific chemicals and environments must be tested.

Packaging & Shelf Life:

MP 55420 is available is cartridges, pails, and drums. The material can be used with conventional meter/mix/dispense equipment if the fast cure time can be allowed for purging or continuous operation. All material should be stored in a cool place when not used for an extended period of time. Shelf life of the product is 12 months at 23°C when stored in original sealed container. Shelf life may be extended with refrigeration. DO NOT freeze.

Engineering Excellence

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

www.instantca.com