

Revised  
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## TECHNICAL DATA SHEETS

### MG 4000

#### Description:

**MG4000** is a medical grade instant adhesive. These products have USP Class VI certification and are used in assembling medical devices.

#### Physical Properties:

COLOR: Clear  
VISCOSITY: 4000 cps  
BASE: Ethyl  
STRENGTH: 2700/4300  
TEMPERATURE RANGE: - 65 - 200°F  
CURE SPEED: 23 seconds  
(FIXTURE)  
FULL CURE: 8 hours  
MIL A 46050 Type II  
Class I  
SPECIFIC GRAVITY 1.05  
SOLUBLE IN: Remove Debonder

#### Storage

The MG series is ideally stored in a cold, dry location in unopened containers. Optimal storage temperature is under 50°F. To prevent contamination of unused product, do not return any material to its original container.

#### Handling Characteristics:

Shear Strength, ASTM D1002, DIN 53283	Value	Range
Grit Blasted Steel, N/mm <sup>2</sup> (psi)	23 (3250)	20 to 28 (2910 to 3970)
Etched Aluminum, N/mm <sup>2</sup> (psi)	17 (2450)	13 to 22 (1950 to 3125)
ABS, N/mm <sup>2</sup> * (psi)	>7 (>885)	
PVC, N/mm <sup>2</sup> * (psi)	>7 (>890)	
Polycarbonate, N/mm <sup>2</sup> * (psi)	>6 (>825)	
Phenolic, N/mm <sup>2</sup> * (psi)	12 (160)	6 to 18 (775 to 2450)
Neoprene rubber, N/mm <sup>2</sup> * (psi)	>12 (>1600)	
Nitrile rubber, N/mm <sup>2</sup> * (psi)	>12 (>1600)	
Tensile Strength, ASTM D2095, DIN 53283		
Grit Blasted Steel, N/mm <sup>2</sup> (psi)	20 (3000)	14 to 28 (1900 to 4000)

\* Substrate Failure

### Engineering Excellence

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

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