

Revised
June 2003



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TECHNICAL DATA SHEETS
MP 5257

Description:

MP 5257 is a tough acrylic adhesive designed primarily for bonding metal to metal, ferrite, ceramics and some thermoplastics. This adhesive may be used in a variety of structural bonding applications due to its versatile performance capabilities. **MP 5257** has demonstrated the ability to provide high tensile strength while maintaining excellent product flexibility. This results in tough, durable bonds with outstanding impact and peel resistance. This tough acrylic is a single component, room temperature curing adhesive that is used in conjunction with activator **MP 5203**.

Physical Properties of Uncured adhesive:

Base resin	Modified acrylic
Solids	100%- no solvents
Appearance	Amber paste
Specific Gravity	1.0
Flash Point, TCC	87°C
Viscosity, 77°F/25°C	
Spindle 7 @ 20rpm	10,000cps
Shelf Life	1 year

Fixture time with the activator

No induced gap:	180sec
0.010" gap:	15sec
0.020" gap:	30 min

Bondline Temperature Duration

250F/121C	20 min
300F/149C	10 min
350F/17C	5 min

Chemical/Solvent Resistance

	%strength retention
Air Reference	100
50/50 Water/Glycol	110
Phosphate Ester	110
Unleaded Gasoline	22
Motor Oil	97
ATF	96
Brake Fluid	5

Specimens immersed for 30 days at 188F and tested at room temperature.

Physical Properties of Cured adhesive:

Ratio of use Adhesive/Activator	100:10/20
Handling time	1-3 minutes
Thickness of joint	min 0.05, max 0.50
Functional strength	24 hours
Shear strength(DIN 53283)	12-25 N/mm ²
Tensile strength(DIN 53288)	15-25 N/mm ²
Peeling strength(ISO 4578)	3.5-5 Nmm
Impact strength(ASTM D-950)	15025 Nmm/mm ²
Coefficient of thermal expansion	80x10 ⁻⁶ 1/K
Thermal conductivity (ASTM C177)	0.1 W/mK
Dielectric constant(ASTM D150)	4.6 Mhz
Volume resistivity(ASTM D257)	2 x 10 ¹³ Ohm *cm
Dielectric strength(ASTM D149)	30-50 KV/mm

Test Temperature

	%strength retention
200F/93C	110
250F/121C	118
300F/149C	132
350F/177C	127
400F/204C	87

Specimens subjected to continuous exposure for 1000 hours.

Engineering Excellence

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

www.instantca.com