

Revised  
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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 5403FLEX**

**Description:**

**MP 5403FLEX** is an one component epoxy system designed as a high flexibility adhesive and sealant. It was designed for glass to glass, metal, and ceramic bonding where flexibility at -50°F temperature are critical. The material can be cured by convection oven or infrared heating equipment. Dispensing is easily automated through the use of commercially available equipment.

**TYPICAL USES:**

- \* **High Impact Applications**
- \* **Glass Headlamps**
- \* **Metal Bonding**
- \* **Ceramic Bonding**

**PHYSICAL PROPERTIES:**

|                                |                        |
|--------------------------------|------------------------|
| <b>Color:</b>                  | <b>Gray</b>            |
| <b>Consistency:</b>            | <b>Paste</b>           |
| <b>Pounds per Gallon:</b>      | <b>9.3-9.7 lbs.</b>    |
| <b>Hardness Shore D:</b>       | <b>&lt;45 D</b>        |
| <b>Press Flow-Initial:</b>     | <b>60-90 Seconds</b>   |
| <b>Sag Resistance-Initial:</b> | <b>&lt;.450"</b>       |
| <b>Stroke Cure @ 160°C:</b>    | <b>&lt;130 Seconds</b> |
| <b>Volatiles @ 300°F:</b>      | <b>&lt; 2%</b>         |

|                                 |                |                |               |
|---------------------------------|----------------|----------------|---------------|
| <b><u>CURE SCHEDULE:</u></b>    | <b>250°F</b>   | <b>320°F</b>   | <b>350°F</b>  |
| <b>(Once Part Reaches Temp)</b> | <b>40 Min.</b> | <b>20 Min.</b> | <b>8 Min.</b> |

|                                    |                 |                 |                |
|------------------------------------|-----------------|-----------------|----------------|
| <b><u>STORAGE/ SHELF LIFE:</u></b> | <b>32°F</b>     | <b>75°F</b>     | <b>100°F</b>   |
|                                    | <b>6 Months</b> | <b>2 Months</b> | <b>2 Weeks</b> |

Store in cool and dry area

***Engineering Excellence***

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

***www.instantca.com***