

Revised  
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**TECHNICAL DATA SHEETS**  
**MP 5404-FS**

**Description:**

**MP 5404-FS** is a one component, heat curable thixotropic paste epoxy adhesive. It is a non-sag adhesive, which forms strong bonds to metals and ceramics. **MP 5404-FS** has exceptional thermal stability and resistance to water, humidity and solvents. This product offers high heat resistance and cures in less than 20 seconds via induction or infrared heating.

**Typical Applications:**

- Permanent Magnet Motors and Loudspeaker Assembly
- Air Conditioning Joint Tubes and Compressors
- High Temperature Structural Bonding
- Filter End Cap and Side Seam Assembly

**Physical Properties:**

Standard Color	Gray
Specific Gravity	1.41 @ 25 °C
Viscosity	500,000-700,000 cps @ 25 °C
Press Flow	60-80 seconds
Sag Resistance	0.315" - 0.400"
Tensile Strength	6,300 psi Typical
Lap Shear Strength	3,000 psi Typical
Hardness	85 Shore D @ 25 °C
Elongation	>1.5%
Impact Strength	0.36 ft lbs/in
CTE	5.72 x 10 <sup>-5</sup> in/in °C
Tg	148 C
Operating Temperature Range	-40 to 400 °F
Thermal Conductivity (BTU/HR/FT <sup>2</sup> / F/FT)	235
Unleaded Gasoline Resistance (1,500 Hrs.)	3,200 psi Typical Prior to test 3,200 psi Typical After 1500 hours of submersion

**Storage:**

<32 °F	75 °F	100 °F
12 months	6 months	2 weeks

**Cure Schedule:**

250 °F	300 °F	350 °F	Induction @ 400 °F
7 min.	1 min.	30 sec.	<20 seconds

**Engineering Excellence**

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

**[www.instantca.com](http://www.instantca.com)**