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## TECHNICAL DATA SHEETS

### MP 54110GR

#### Description:

**MP 54110GR** is a two part unfilled epoxy adhesive designed for bonding of metals, ceramics and most plastics. This product gives good resistance to water, salt spray, inorganic acids and bases and most organic solvents. This product gives better water and temperature resistance than standard 5 minute epoxy.

It was especially formulated to a 1:1 mix ratio for use in either MMD equipment or side by side dual cartridges for easy dispensing. A handling cure is normally achieved at room temperature within 30 - 60 minutes with full cure in 24 hours. An elevated temperature cure schedule can be used to reach final properties quickly.

#### Instructions:

- 1) Bring both components to room temperature prior to mixing. Mix 1 parts A to 1 part B thoroughly.
- 2) Allow to cure undisturbed until product is fully gelled or tack-free to the touch.
- 3) Clean up uncured resin with suitable organic solvent such as MEK, acetone or a chlorinated solvent.

#### Mix Ratio:

1A:1B by weight or 1A:1B by volume.

Many epoxy resin systems are prone to crystallization as epoxy resin is a super-cooled fluid. This condition may give the product a gritty or grainy appearance (or hazy in clear products). In extreme cases it may appear solid and cured. Fluctuating temperatures (within 0 to 50°C) aggravate this phenomena. Heating to 50 to 60°C with stirring can usually restore products. Storage at 25 +/- 5°C is optimum for most products.

#### Handling and Physical Properties:

All properties given are at 25°C unless otherwise noted.

Color		Gray
Viscosity	Part A	12,000 cps
	Part B	20,000 cps
	Mixed	15,000 cps (est)
Specific Gravity	Part A	1.17
	Part B	1.15
	Mixed	1.16
Pot Life		8 - 12 minutes
Mass		20 grams
Tensile Strength		2300 psi
Lap Shear (Al to Al)		
T-Peel		3 - 5 pli *
Temperature Range		-40 to 130°C
Hardness Method		80 Shore -D
Linear Coefficient of Thermal Expansion (x 10 (6))/ °C		
		62 *

#### Shelf Life:

12 Months

### Engineering Excellence

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

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