

Revised
September 2004



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

MP54216CL

Description:

MP54216CL is a two part mineral filled epoxy adhesive designed for bonding metals and plastics. It cures at room temperature to a tough, semi-flexible material. It has good wetting to most surfaces and is free flowing to penetrate cavities and give good self leveling and air release. This product gives very good vibration and impact resistance. It gives good resistance to water, salt spray, inorganic acids and bases and most organic solvents.

It was especially formulated to a 1A:1B volume mix ratio for use in side-by-side dispensing cartridges and meter/mix and dispense equipment. **MP54216CL** will reach handle cure at room temperature within 16 – 24 hours. Cure time can be accelerated by the application of heat. Times and temperatures from 2 hours at 65°C to 20 minutes at 100°C are typical for most applications. Time to heat substrate must be taken into account. Cooler temperatures will also extend work time and increase cure times.

INSTRUCTIONS:

- 1) Bring to room temperature before use.
- 2) Weigh and mix parts A and B accurately and thoroughly, scraping sides of container often. Pre-bleed side-by-side cartridges, discarding the first 3 inches of dispensed material. Maintain adequate velocity during dispensing to ensure complete mixing.
- 3) Allow to cure undisturbed.

PROPERTIES OF UNCURED PRODUCT (typical value)

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

Color		Clear
Viscosity	Part A	80,000 cps
	Part B	80,000 cps
	Mixed	80,000 cps
Specific Gravity	Part A	1.34
	Part B	1.31
	Mixed	1.32
Pot Life		1 hour
Mass		100 grams
Hardness Shore - D		70
Temperature Range		-60 to 150°C
Tensile Elongation		60 %
Tensile Strength		1800 psi
Tensile Strength		3000 psi
Lap Shear (Al to Al)		
T-peel Strength (Al to Al)		25 pli *
Dielectric Constant (25C, 100Hz)		4.5 *
Dielectric Strength		410 v/mil *
Volume Resistivity		8 x 10 ¹³ ohm-cm *

T_g is 16C, - actual tested

CTE is about 50ppm/C below the T_g and about 150ppm/C above the T_g

MIX RATIO:

Mix Ratio (Part A to B):	
by weight	103 to 100
by volume	1 to 1

CURE SCHEDULE:

24 – 72 hours at 25°C
or 1 hour @ 60°C

SHELF LIFE:

12 Months

Engineering Excellence

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

www.instantca.com