



TECHNICAL DATA SHEET
TDS #: MP55390
METHACRYLATE ADHESIVE

MAXIMUM PERFORMANCE SERIES
MP55390 METHACRYLATE ADHESIVE

DESCRIPTION:

MP55390 is a high performance two part methacrylate adhesive engineered to bond a wide range of plastics, metals, and composite assemblies. It offers outstanding bond strength, is extremely durable, with excellent impact and weathering properties. MP55390 greatly increases the reliability of finished assemblies with exceptional flexibility, it's ability to withstand extreme temperature fluctuation and thermal cycling, and resistance to a wide range of chemicals and environmental conditions. It has maximum open time for use on large structures.

PHYSICAL PROPERTIES (UNCURED):

VISCOSITY @ 25°C (cps):	RESIN	200,000
	ACTIVATOR	200,000
COLOR:	OFF WHITE	GREY
DENSITY:	8.00	8.00
MIXED DENSITY:	8.00	
MIX RATIO:	VOLUME	1 TO 1
	WEIGHT	1 TO 1
THIX INDEX:	5	
FLASH POINT:	51°F	

PHYSICAL PROPERTIES (CURED):

STRENGTH (PSI):	SHEAR	3000-3500
	TENSILE	3000-3500
WORK TIME:	65-75 MINUTES	
HANDLING STRENGTH:	120-200 MINUTES (75% OF OVERALL STRENGTH)	
GAP FILL:	UP TO 1 INCH	
TEMPERATURE RANGE:	-67°F - +250°F	
PEAK EXOTHERM:	220°F @ 75°F	
	160 MINUTES, 10 GRAM MASS	

PACKAGING:

The MP 55390 Series is conveniently packaged in 50 mil, 400 mil, pail, and drum kits. Special packaging is available upon request.

EFFECTS OF TEMPERATURE:

The product is best used at temperatures between 65° F and 80° F. Temperatures below 65° F will slow the cure speed of the material and viscosities will be higher. Temperatures above 80° F will cause the material to cure faster and viscosities will be lower. For consistent dispensing maintain temperature in the above mentioned range.

WHAT THE MP SERIES BONDS:

METALS

- *ALUMINUM
- *STEEL
- *STAINLESS
- *COATED METALS

THERMO SETS

- *FIBERGLASS
- *PHENOLICS
- *GEL COATS
- *EPOXY
- *RIM URETHANE
- *POLYURETHANE
- *LIQUID MOLDING RESINS

THERMO PLASTICS

- *ACRYLICS
- *ABS
- *POLYCARBONATES
- *NYLONS
- *PPO's
- *VINYL'S
- *PVC's
- *STYRENE'S
- *PEEK's
- *PBT BLENDS
- *PET BLENDS

BENEFITS:

- >NO SURFACE PREP
- >EXCELLENT STRENGTH
- >IMPACT RESISTANT
- >100% REACTIVE
- >ROOM TEMPERATURE CURE
- >EASILY APPLIED

STORAGE AND SHELF LIFE:

The shelf life of the MP55300 Series is six month from date of shipment. Shelf life is based on the products being stored properly at temperatures between 55° F and 75° F. Exposure to temperatures above 75° F will reduce the shelf life of these materials. These products should NEVER BE FROZEN.

PRECAUTIONS:

ASI's MP55300 Series products are *flammable*. Keep away from heat, spark, and open flames.

KEEP OUT OF REACH OF CHILDREN. THE PRODUCT IS FOR INDUSTRIAL USE ONLY. Keep containers closed when not in use. Avoid contact with skin and eyes. Harmful if swallowed. Refer to Material Safety Data Sheet for complete safety information.

HANDLING AND CLEAN-UP:

For optimum bond strength and to insure maximum performance in the finished assembly mate parts together within the specified work time of the adhesive. Make sure the bond joint has uniform coverage and that a sufficient amount of adhesive is in the bond area. It is important to have the adhesive applied, parts aligned and positioned, within the established work times for the product. To ensure maximum performance in the finished assembly parts should remain undisturbed until the fixture time is reached.

Clean up is best before the adhesive has cured. Cleaners containing NMP (N-methyl pyrrolidone) or Citrus terpene provide the best results. On cured adhesive repeat use may be required.

NON WARRANTY:

Information contained herein is based on tests we believe to be reliable and accurate. It is offered in good faith for the benefit of the consumer. The Company shall not be liable for any injury, loss, or damage in the use of its chemical products since conditions or use are beyond our control. In every case we urge and recommend the user conduct tests to determine to their own satisfaction that the product is of acceptable quality and suitable for their particular purpose under their own operating conditions. Statements concerning the possible use of our products are not intended as recommendations to use our products in the infringement of any patent. These products are for industrial use only.