

Revised
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TECHNICAL DATA SHEETS

MP 5400

Description:

MP5400 is a one component, heat curable thixotropic paste epoxy adhesive. It is a non-sag adhesive which forms strong bonds to metals and ceramics. **MP5400** has exceptional thermal stability and resistance to water, humidity and solvents. This product offers high heat resistance and cures rapidly in either a convection oven or infra-red oven. **MP5400** readily exceeds all requirements of military specifications MMMA-132 for type II heat resistant structural adhesives.

Typical Uses:

- * 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	700,000-900,000 cps @ 25 °C
Press Flow	60-80 seconds
Sag Resistance	0.375" - 0.420"
Tensile Strength	>6,400 psi
Lap Shear Strength	>3,100 psi
Hardness	85 Shore D @ 25 °C 75 Shore D @ 120 °C
Elongation	>1.5%
Impact Strength	0.36 ft lbs/in
CTE	5.6×10^{-5} in/in degree °C
Tg	148 °C
Operating Temperature Range	-40 to 400 °F

<u>CURE SCHEDULE:</u>	250 °F	300 °F	350 °F
	15 min.	10 min.	2 min.

<u>STORAGE/SHELF LIFE:</u>	<32 °F	75 °F	100 °F
	12 months	6 months	2 weeks

Store in a cool, dry area. Review MSDS prior to use.

PACKAGING: 6, 12 & 20 ounce cartridges, 1 gallon and 5 gallon containers

Engineering Excellence

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

www.instantca.com