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**TECHNICAL DATA SHEET**

**TDS #: MP55420**

**METHACRYLATE ADHESIVE**

**Revised : March 2014**

Distributed by  
 Freeman Manufacturing & Supply Co.  
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**MAXIMUM PERFORMANCE SERIES  
 MP55420 METHACRYLATE ADHESIVE**

**DESCRIPTION:**

MP55420 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. MP55420 greatly increases the reliability of finished assemblies with exceptional flexibility, it's ability to with stand extreme temperature fluctuation and thermal cycling, and resistance to a wide range of chemicals and environmental conditions.

**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
  - \*PBT BLENDS
  - \*PET BLENDS

**PHYSICAL PROPERTIES (UNCURED):**

VISCOSITY @ 25°C (cps):	RESIN	130,000
	ACTIVATOR	50,000
COLOR:	OFF WHITE	AMBER.SHELL
MIXED DENSITY:	8.00	
MIX RATIO:	VOLUME	10 TO 1
	WEIGHT	10 TO 1
THIX INDEX:	5	
FLASH POINT:	51°F	

**PHYSICAL PROPERTIES (CURED):**

STRENGTH (PSI):	SHEAR	>2800
	TENSILE	>2500
WORK TIME:	4-6 MINUTES	
HANDLING STRENGTH:	9-13 MINUTES	
GAP FILL:	.25 INCHES TEMPERATURE	
RANGE:	-67°F - +250°F	

**BENEFITS:**

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

**PACKAGING:**

The MP 55420 Series is conveniently packaged in 380 mil cartridges, 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.

### **STORAGE AND SHELF LIFE:**

The shelf life of the MP55400 Series for most products is one year from date of shipment (check with ASI). 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 MP55400 Series products are *flammable*. Keep away from heat, spark, and open flames.

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**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.

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### **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.