



The *MP 5400 SERIES* represents the most comprehensive family of products to meet your application requirements. They are conveniently packaged in 50 mil, and 400 mil dual syringe cartridges. This takes all the guess work out of using two component materials. This offers significant benefits for production personnel:

- No mixing, measuring, or weighing . . .  
**ITS ALREADY DONE . . .**
- No contact with material.
- No mess.
- No waste.
- Easy to use, right from the cartridge.
- Saves valuable production time.
- No clean up.

# Adhesive Systems, Inc.

	RATIO	VISCOSITY	COLOR	WORK LIFE (MINUTES)	SHEAR STRENGTH PSI	DIELECTRIC STRENGTH	HARDNESS SHORE D
<b>MP 5400 SERIES, Maximum Performance Epoxies</b>							
<b>Two Part Adhesives:</b>							
MP 5405 General purpose fast setting, 5 minute worklife epoxy. Forms a rigid bond, machinable, clear, flowable, low odor material.	1 to 1	12,500	Clear	3-5 Min.	2,000-4,000 psi	400 Volts/Mils	80
MP 5405BK General purpose fast setting, 5 minute work life epoxy. Forms a rigid bond, machinable, black, flowable, low odor material.	1 to 1	13,000	Black	3-5 Min.	2,000-4,000 psi	400 Volts/Mils	80
MP 5405NS General purpose, non sag material, ideal for applications that require maximum gap filling or high viscosity epoxy. Fast setting, 5 minute worklife, clear.	1 to 1	90,000	Clear	3-5 Min.	2,000-4,000 psi	400 Volts/Mils	80
MP 5405Flex Toughened, 5 minute epoxy. Excellent impact resistance, good peel strength, and flexibility.	1 to 1	9,500	Clear	3-5 Min.	2,000-4,000 psi	400 Volts/Mils	65
MP 5430 General purpose, 20 minute worklife. Amber color, forms a tough, rigid bond.	1 to 1	13,000	Amber	20-30 Min.	2,000-4,000 psi	400 Volts/Mils	80
MP 54110 Fast curing, flexible, excellent weather resistance, bonds well to glass, metal, and plastic. Resist fuel and solvent environments, with good impact resistance.	1 to 1	45,000	Amber	9-12 Min.	2,000-4,000 psi	400 Volts/Mils	70
MP 54110GR Fast curing, good impact resistance and peel strength. Excellent for metal bonding or metal to dissimilar surfaces. Gray in color.	1 to 1	45,000	Gray	9-12 Min.	2,000-4,000 psi	400 Volts/Mils	70
MP 54125 Good peel strength, higher temperature resistance, medium open time for part adjustment and alignment.	1 to 1	48,000	Translucent	25 Min.	2,000-4,000 psi	400 Volts/Mils	70
MP 54125GR Gray color makes it ideal for aluminum and metal bonding. Flexible, toughened epoxy, with good impact resistance.	1 to 1	47,000	Gray	25 Min.	2,000-4,000 psi	400 Volts/Mils	70
MP 54190 Long work life, with good peel strength. Maximum adjustment and positioning time.	1 to 1	15,000	Translucent	70-100 Min.	3,300-4,000 psi	400 Volts/Mils	70
MP 54190GR Toughened epoxy, with good peel strength, impact resistance, and open time. Bonds metals, plastics, and many dissimilar materials. Gray in color.	1 to 1	60,000	Gray	70-100 Min.	3,300-4,000 psi	400 Volts/Mils	60
MP 54270 Potting compound for electronic applications. Non corrosive material, with good work life.	1 to 1	20,000	Clear	60 Min.	1,800-3,000 psi	550 Volts/Mils	85



	RATIO	VISCOSITY	COLOR	WORK LIFE (MINUTES)	SHEAR STRENGTH PSI	DIELECTRIC STRENGTH	HARDNESS SHORE D
<b>MP 5400 SERIES, Maximum Performance Epoxies (continued)</b>							
MP 54270BK Long worklife potting compound ideal for tamper proofing electronic assemblies. Non corrosive with good flow properties, black color.	1 to 1	20,000	Black	60 Min.	1,800-3,000	550 Volts/Mils	85
MP 54420 High performance epoxy, excellent shear and peel strength. High viscosity for maximum gap filling.	2 to 1	43,000	Off-White	20-30 Min.	4,000-5,000	500 Volts/Mils	75
MP 54460 High performance epoxy, high peel and shear strength. Longer work life.	2 to 1	40,000	Off-White	50 Min.	4,000-5,000	500 Volts/Mils	80
MP 54216CL Long work life, flexible epoxy. Bonds dissimilar materials, 18 hour fixture times.	1 to 1	10,000	Translucent	120 Min.	2,500-3,000	400 Volts/Mils	70
MP 5471 Fast setting, high temperature resistance, ideal for speaker applications.	10 to 1	3,500	Brown/Amber	1-3 Min.	3,300	400 Volts/Mils	80
MP 54750 Versatile epoxy used for bonding and potting applications. Excellent resistance to water, acids, bases, and most organic solvents.	1 to 1	15,000	Clear	60-90 Min.	3,400	400 Volts/Mils	80
MP 5434 Urethane based material excellent for bonding metal and dissimilar materials. Also available in high viscosity version.	2 to 1	13,000	Translucent	5 Min.	3,500	400 Volts/Mils	35

Packaging: MP 5400 Series Two Part Epoxies are available in 50 kits, 400 mil kits, and 10 gallon kits. Special packaging is available upon request.

MP 5400	1 Part	1.41	Paste	Gray	@250° F - 15 Min. @300° F - 10 Min. @350° F - 2 Min.	6,400	3,100	85 Shore D	-40 to 400° F
MP 5401 One part, heat cure, forms a tough, durable bond. Excellent high performance at elevated temperatures and superior sag control.	1 Part	1.41	Paste	Gray	@250° F - 10 Min. @300° F - 2 Min. @350° F - 1 Min.	6,770	3,200	85 Shore D	-40 to 400° F
MP 5402NMF One part, heat cure, for electrical applications, where insulating properties are required.	1 Part	1.41	Paste	Cream	@250° F - 30 Min. @300° F - 10 Min. @350° F - 5 Min.	7,000	3,500	85 Shore D	-40 to 400° F
MP 5403FLEX One part, heat cure formulated to provide excellent impact and shock resistance. Ideal for bonding dissimilar surfaces.	1 Part	1.35	Paste	Gray	@250° F - 30 Min. @300° F - 15 min. @350° F - 5 Min.	6,400	3,100	45 Shore D	-40 to 400° F
MP 5404FS One part heat cure that cures rapidly. Cures in seconds by induction or infra-red heating.	1 Part	1.41	Paste	Gray	@250° F - 10 Min. @300° F - 2 Min. @350° F - 1 Min.	6,770	3,200	85 Shore D	-40 to 400° F

Packaging: MP 5400 Series One Part Epoxies are available in 6 ounce cartridges, 12 ounce cartridges and 5 gallon pails. Special packaging is available upon request.

	RATIO	COLOR	VISCOSITY	WORK TIME	FIXTURE TIME	ALUMINUM	STEEL	FIBERGLASS	ACRYLIC	SMC	ABS
<b>MP 55000 SERIES, Maximum Performance Methacrylates</b>											
<b>Two Part Methacrylate:</b>											
MP 55300 General purpose used for bonding plastics and metal components. Fast cure time for high speed assembly.	1 to 1	Natural	Non-Sag	6-8 Min.	10-15 Min.	2,450	3750	S-F	S-F	S-F	S-F
MP 55305 High impact resistance for metals and plastics. Tough, flexible adhesive with a fast cure time for high speed assembly.	1 to 1	Straw	Non-Sag	2-3 Min.	5-6 Min.	2,450	3500	S-F	S-F	S-F	S-F
MP 55310 Excellent metal bonder with good results on plastics as well. Medium cure speed for part positioning and adjustment.	1 to 1	Natural	Non-Sag	10-12 Min.	15-25 Min.	3,700	4200	S-F	S-F	S-F	S-F
MP 55315 High impact resistance for metals and plastics. Tough, flexible bonds with a fast cure speed.	1 to 1	Straw	Non-Sag	5-6 Min.	15-17 Min.	2,400	3800	S-F	S-F	S-F	S-F
MP 55325 High impact, maximum flexibility and elongation. High tensile shear strength. Fast cure speed.	1 to 1	Straw	Non-Sag	3-4 Min.	10-11 Min.	2,700	4700	S-F	S-F	S-F	S-F
MP 55350 Long open time with good work life. Bonds well to most plastics, composites, and metals.	1 to 1	Natural	Non-Sag	60-90 Min.	30-40 Min.	2,350	3,200	S-F	S-F	S-F	S-F
MP 55360 Faster curing version of MP 55350.	1 to 1	White	Non-Sag	12-15 Min.	20-25 Min.	2,350	3,200	S-F	S-F	S-F	S-F
MP 55370 Bonds well to most plastics, composites, and metals. Fast curing.	1 to 1	Natural	Non-Sag	3-4 Min.	7-10 Min.	2,450	3,750	S-F	S-F	S-F	S-F
MP 55420 Superior composite and fiberglass adhesive. Durable bonds with excellent weathering properties. Fast curing.	1 to 1	Blue/Green	Non-Sag	8-9 Min.	12-15 Min.	2,600	3,500	S-F	S-F	S-F	S-F
MP 55500 Specifically engineered for noryl bonding. Offers maximum moisture and solvent resistance, with rapid cure time.	1 to 1	Black	Non-Sag	1-3 Min.	7-8 Min.	2,500	3,750	S-F	S-F	S-F	S-F
MP 55505 Metal bonder for extremely harsh environments. Excellent moisture and chemical resistance. Withstands elevated temperatures. Low odor.	1 to 1	Straw	Non-Sag	5-6 Min.	15-18 Min.	2,200	2,800	S-F	S-F	S-F	S-F
MP 55600 Engineered for solid surface bonding applications. Clear in color. Excellent for clear plastic bonding. Sandable.	1 to 1	Clear	Self-leveling	16-20 Min.	22-27 Min.	N/A	N/A	N/A	S-F	N/A	S-F
MP 55615 Faster curing version of MP 55600. (Sandable in 15 minutes)	1 to 1	Clear	Self-leveling	12-15 Min.	15-20 Min.	N/A	N/A	N/A	S-F	N/A	S-F
MP 55620 Faster curing version of MP55610.	1 to 1	Clear	Self-leveling	3-4 Min.	8-10 Min.	N/A	N/A	N/A	S-F	N/A	S-F

Products are conveniently packaged in 50 mil and 400 mil mix packs. No weighing or manual mixing is needed. This convenient packaging minimizes production personnel coming in contact with the adhesive. Ten gallon kits are available for automated applications. Special packaging is available upon request.