



## MP5405FLEXMV

MP5405FLEXMV is a two part unfilled rubber modified medium viscosity epoxy adhesive designed for high speed bonding of metals, ceramics, and most plastics. It cures to a tough semi-rigid material, and is free flowing in viscosity. It gives good resistance to water, salt spray, inorganic acids and bases, and most organic solvents. It was especially formulated to a 1:1 mix ratio for use in either MMD equipment or side-by-side dual cartridges for easy dispensing. A handling cure is normally achieved at room temperature within 20 - 30 minutes with full cure in 24 hours. An elevated temperature cure schedule can be used to reach final properties quickly.

<b>Technology / Base</b>	Epoxy
<b>Type of Product</b>	Structural Adhesive
<b>Components</b>	Two Component
<b>Curing</b>	Room Temperature (secondary thermal cure)
<b>Appearance / Color</b>	Clear
<b>Consistency</b>	Liquid

### Features and Benefits

- Excellent Bonding to Metals, Ceramics and Most Plastics
- Toughened Epoxy Providing Excellent Impact and Thermal Expansion Performance
- Excellent Chemical Resistance
- Suitable for Cartridge and Two Component Dispensing Equipment
- Excellent Thermal Performance
- 100% Reactive
- Room Temperature Cure
- 1:1 volume mix product for easy meter or static mix of application

### Technical Data

Rheology	Value	Condition/Method
Viscosity - Part A	Paste	at 25°C
Viscosity - Part B	15,000 cPs	at 25°C
Viscosity - Mixed	Paste	at 25°C
<b>Uncured Material Characteristics</b>		
Specific Gravity - Part A	1.11	
Specific Gravity - Part B	1.15	
Specific Gravity - Mix	1.13	
Volume Mix Ratio	1 to 1	
Weight Mix Ratio		
Pot Life	3 to 5 min	at 25°C      20 gram
Gel Time		20 gram
Handling Time	20 to 30 min	
Full Cure @ 23°C	24 hours	
Full Cure @ 66°C		
Shelf Life	12 months unopened	
<b>Cured Mechanical Properties</b>		
Hardness	79 Shore D	ASTM D2240
Tensile Strength	45.5 MPa (6600 psi)	ASTM D638
Elongation at Break	5 to 10%	ASTM D638
Overlap Shear Strength Aluminum, Acid Etched at 25°C		
Operating Temperature	-40°C to 130°C (-40°F to 265°F)	
<b>Cured Electrical Properties</b>		
Dielectric Constant	4.5 at 25°C, 100Hz	ASTM D150
Dielectric Strength	16.1 kV/mm	ASTM D149
Volume Resistivity		



## General Instructions

Surfaces to be bonded must be clean, dry and free of other contaminants. Bring both components to room temperature prior to mixing. Measure out specified amounts of parts A and B and stir (without introducing bubbles) until homogenous or use a static mixing nozzle. Apply the uniform mixture to both surfaces. Allow to cure while being held in place with light clamping.

## Specifications and Approvals

### Handling and Clean-Up

See SDS for handling and clean-up information.

### Storage

Product should be stored in a cool dry place out of direct sunlight. The shelf life is from date of manufacture. Shelf life is based on the products being stored properly at temperatures between 12°C and 25°C. Exposure to temperatures above 25°C will reduce the shelf life. This product should not be frozen.

### Use Note

### Safety and Disposal

See SDS for

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