



## MP55300

MP55300 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. MP55300 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 offers exceptional bonding to a wide range of substrates.

Technology / Base	Modified Acrylic
Type of Product	Structural Adhesive
Components	Two component
Curing	Room Temperature Cure
Appearance / Color	Off White or Amber
Consistency	Viscous Liquid

### Features and Benefits

- No Surface Preparation Required
- Excellent Adhesion Properties
- Excellent Strength to Metals, E-Coat, Thermoplastics, Thermosets, and Engineering Plastics
- High Impact Resistance
- Suitable for Easy Manual and Pneumatic Dispensing
- Excellent Thermal Performance
- 100% Reactive
- Room Temperature Cure
- 1:1 meter-mix product for ease of application
- Use on as received metal surfaces including aluminum, stainless and plated steels and forms tough, high strength bonds without surface preparation

### Technical Data

		Condition/Method
<b>Rheology</b>		
Viscosity - Resin	60,000 cPs @ 25°C	Brookfield RV7 20 rpm
Viscosity - Activator	60,000 cPs @ 25°C	Brookfield RV7 20 rpm
Viscosity - Mixed		
Thixotropic Index	5	Brookfield RV7 20/2 rpm
<b>Density</b>		
Mixed Density	0.98 g/cc	
<b>Mix Ratio</b>		
Volume Mix Ratio	1:1	
Weight Mix Ratio	1:1	
<b>Uncured Material Characteristics</b>		
Flash Point	51°F	
Open Time	4 - 6 minutes	
Fixture Time	10 - 15 minutes	
Cure Temperature and Time	Room Temperature, 24 hr	
<b>Cured Mechanical Properties</b>		
Gap Fill Dimension	0.125 inch	
Hardness	75 Shore D	ASTM D2240
Tensile Strength	3625 to 5075 psi (25 to 35 MPa)	ASTM D638
Over Lap Shear Strength		
Carbon Steel	3100 to 3900 psi (21 to 27 MPa)	ASTM D1002, 25°C 50% RH
Aluminum	2450 psi	ASTM D1002, 25°C 50% RH
<b>Cured Thermal Properties</b>		
Thermal Service Range	-65°F to 250°F	



## Recommended For

### METALS

- Aluminum
- Steel
- Stainless
- E-Coated Metal

### THERMOSETS

- Fiberglass
- Phenolic
- Gel Coat
- Epoxy
- RIM Urethane
- Polyurethane
- Liquid Molding Resin

### THERMOPLASTICS

- Acrylic
- ABS
- Polycarbonate
- Nylon/PA
- PPO
- Vinyl
- PVC
- Styrene
- Peek
- PBT Blends
- PET Blends

## Handling and Clean-Up

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.

## Storage and Shelf Life

Product should be stored in a cool dry place out of direct sunlight. The shelf life of MP55300 is one year from date of manufacture. 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. This product should NEVER BE FROZEN.

## General Instructions

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.

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.

## Typical Packaging

MP55300 is conveniently packaged in 50 ml, 400 ml, pail, and drum kits. Special packaging is available upon request.

## Safety and Disposal

**For safe handling information on this product, consult the Safety Data Sheet (SDS)**

H.B. Fuller Company  
9411 Corsair Road  
Frankfort, IL 60423  
Tel: +1.800.552.0306

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