



**MP55320**

MP55320 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. MP55320 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.

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
- Excellent Impact Resistance
- Suitable for Easy Manual and Pneumatic Dispensing
- Excellent Thermal Performance
- 100% Reactive
- Room Temperature Cure
- 10:1 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	130,000 cPs @ 25°C	Brookfield RV7 20 rpm
Viscosity - Activator	50,000 cPs @ 25°C	Brookfield RV7 20 rpm
Viscosity - Mixed		
Thixotropic Index	5	Brookfield RV7 20/2 rpm
<b>Density</b>		
Mixed Density	0.95 g/cc	
<b>Mix Ratio</b>		
Volume Mix Ratio	10:1	
Weight Mix Ratio	10:1	
<b>Uncured Material Characteristics</b>		
Flash Point	51°F	
Open Time	8 - 14 minutes	
Fixture Time	20 - 30 minutes	
Cure Temperature and Time	Room Temperature, 24 hr	
<b>Cured Mechanical Properties</b>		
Gap Fill Dimension	0.25 inch	
Hardness	45 Shore D	ASTM D2240
Tensile Strength	2175 to 4350 psi (15 to 30 MPa)	ASTM D638
Over Lap Shear Strength		
Carbon Steel	2800 to 3500 psi (19 to 24 MPa)	ASTM D1002, 25°C 50% RH
Aluminum	3700 psi	ASTM D1002, 25°C 50% RH
<b>Cured Thermal Properties</b>		
Thermal Service Range	-67°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 MP55320 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

The MP 55320 Series is conveniently packaged in 50 ml, 380 ml, 490 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

Date Modified: 26 June 2018

Connecting what matters.™

[www.hbfuller.com](http://www.hbfuller.com)

[www.hbfullerengineering.com](http://www.hbfullerengineering.com)

IMPORTANT: Information, specifications, procedures and recommendations provided ("information") are based on our experience, and we believe this information to be accurate. No representation, guarantee or warranty is made as to the accuracy or completeness of the information or that use of the product will avoid losses or damages or give desired results. It is purchaser's sole responsibility to test and determine the suitability of any product for the intended use. Tests should be repeated if materials or conditions change in any way. No employee, distributor or agent has any right to change these facts and offer a guarantee of performance.

® and ™ are trademarks of H.B. Fuller Company or one of its affiliated entities.



**NOTE TO USER:** by ordering/receiving product, you accept the H.B. Fuller General Terms and Conditions of Sale applicable in the region. Please request a copy if you have not received this documentation. These Terms and Conditions contain disclaimers of implied warranties (including but not limited to disclaiming warranties of fitness for a particular purpose) and limits of liability. All other terms are rejected. In any event, (1) the total aggregate liability of H.B. Fuller for any claim or series of related claims, however arising, in contract, tort (including negligence), breach of statutory duty, misrepresentation, strict liability, or otherwise, is limited to replacement of affected products or refund of the purchase price for affected products. (2) H.B. Fuller shall not be liable for loss of profit, loss of margin, loss of contract, loss of business, loss of goodwill, or any indirect or consequential losses arising out of or in connection with product supply. (3) Nothing in any term shall operate to exclude or limit H.B. Fuller's liability for fraud, gross negligence, death, or personal injury caused by negligence, or for breach of any mandatory implied terms unless permitted by law.

H.B. Fuller  
[www.hbfuller.com](http://www.hbfuller.com)

©H.B. Fuller Company, 2018