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## TECHNICAL DATA SHEETS

### MP 54750

#### Description:

**MP 54750** is a two part unfilled epoxy structural adhesive designed for bonding application requiring conformance to the Code of Federal Regulations Title 21 175.105 (Adhesives) and 175.300 (Resinous and polymeric coatings)<sup>1</sup>. It cures completely at room temperature to a tough, semi-rigid polymer. It has good wetting and adhesion to most surfaces and has a free flowing viscosity. It has very good resistance to water, acids and bases and most organic solvents.

It was especially formulated to a 1A:1B volume mix ratio for use in side-by-side dispensing cartridges and meter/mix and dispense equipment. **MP 54750** will reach full cure at room temperature within 24 –48 hours. Cure time can be accelerated by the application of heat. Times and temperatures from 2 hours at 150F to 10 minutes at 225F are typical for most applications. Time to heat substrate must be taken into account. Cooler temperatures will also extend work time and increase cure times.

#### INSTRUCTIONS:

- 1) Bring to room temperature before use.
- 2) Weight and mix parts A and B accurately and thoroughly, scraping sides of container often.
- 3) Allow to cure undisturbed.

#### TYPICAL PROPERTIES:

All properties given are at 25C unless otherwise noted.

Color		Clear
Viscosity	Part A	12,000 cps
	Part B	18,000 cps
	Mixed	15,000 cps
Specific Gravity	Part A	1.16
	Part B	0.98
	Mixed	1.10
Pot Life	60 - 90 minutes	
Mass	50 grams	
Hardness Shore - D	80	
Tensile Elongation	8 - 10% *	
Tensile Strength	7000 psi	
Tensile Strength	2500 psi	
Lap Shear (Al to Al)		
Dielectric Constant 25C, 100Hz)	3.5 *	
Dielectric Strength	410 v/mil	
Volume Resistivity	8.3 x 10 <sup>14</sup> ohm-cm	

#### MIX RATIO:

Mix Ratio (Part A to B):	
by weight	100 to 85
by volume	1 to 1

#### CURE SCHEDULE:

24 – 72 hours at 77°F  
or 2 hours @ 150°F

#### SHELF LIFE:

12 Months

### Engineering Excellence

For technical information  
and support call **1-800-552-0299** or visit our website at

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