



MP5401

MP5401 is a one component, heat cureable thixotropic paste epoxy adhesive. It is a non-sag adhesive, which forms strong bonds to metals and ceramics. MP5401 has exceptional thermal stability and resistance to water, humidity and solvents. This product offers high heat resistance and cures in less than 36 seconds via induction or infrared heating. Typical uses include permanent magnet motors and loudspeaker assembly, air conditioning joint tubes and processors, high temperature structural bonding, filter end cap and side seam assembly.

Technology / Base	Epoxy
Type of Product	Structural Adhesive
Components	One Component
Curing	Thermal Cure
Appearance / Color	Grey
Consistency	Liquid Paste

Features and Benefits

- Excellent Bonding to Metals, Ceramics and Most Plastics
- Non-Sag Paste
- Excellent Chemical Resistance
- One Component for Easy Processing and Dispensing
- Excellent Thermal Performance

Technical Data

Rheology	Value	Condition/Method
Viscosity	700,000 to 900,000 cPs	at 25°C
Thixotropic Index		
Density		
Specific Gravity	1.46	
Uncured Material Characteristics		
Pot Life		
Gel Time		
Cure Temperature and Time	10 min at 120°C (250°F), or 2 min at 150°C (300°F), or 1 min at 175°C (350°F)	
Shelf Life	12 months at 0°C, or 6 months at 23°C	
Cured Mechanical Properties		
Hardness	86 Shore D	ASTM D2240
Tensile Strength	46.7 MPa (6770 psi)	ASTM D638
Elongation at Break	1.5 to 4%	ASTM D638
Overlap Shear Strength		
Aluminum, Acid Etched	22.1 MPa (3200 psi)	ASTM D1002, 25°C 50% RH
Operating Temperature	-40 to 205°C (-40 to 400°F)	
Cured Physical Properties		
Glass Transition Temperature, Tg	148°C	
Coefficient of Thermal Expansion		
Alpha 1	57.2 ppm/°C	
Thermal Conductivity	0.41 W/mK	



General Instructions

Surfaces to be bonded must be clean, dry and free of other contaminants. Bring material to room temperature prior to dispensing. Dispense without introducing bubbles. Press flow time for the material is 60 to 80 seconds. Allow to cure undisturbed until product is fully gelled or tack-free to the touch ensuring parts remain mated throughout the cure process.

Storage

Product should be stored in a cool dry place out of direct sunlight.

Safety and Disposal

See SDS for safety and disposal information.

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Specifications and Approvals

Handling and Clean-Up

See SDS for handling and clean-up information.

Use Note