Adhesive Systems, Inc.
An ISO 9001:2008 Certified Company

MAXIMUM PERFORMANCE SERIES
MP531201I
UV ADHESIVE

TECHNICAL DATA SHEET
TDS #: MP531201I
UV Adhesive

DESCRIPTION

MP531201I **is a high performance UV curing adhesive engineered to bond plastics. It can be used in a variety of product assemblies and it promotes innovative design solutions. It is a fast cure, strong bonding adhesive. Our MP531201I is a leading performer when used for bonding general industrial applications. MP531201I is often cured with an electroless lamp D, medium pressure metal halide lamp. This UV adhesive also works well with UV light emitted diodes (UV LED) at wavelengths of 365 nm to 395 nm. Design engineers select MP531201I for the optimum in finished product quality, reliability, performance, and cost effectiveness. MP531201I is an essential tool in improving overall product quality, lowering per unit cost, and reducing processing time.**

PHYSICAL PROPERTIES (UNCURED):

Chemical Class	**Acrylate**
Solvent Content	**None**
Appearance	**Gel**
Density, g/ml	**1.05**
Viscosity, 25 °C	**22,000cp-37,000cp**
Flash Point °C	**77**

PHYSICAL PROPERTIES (CURED):

Durometer Hardness	**D35**
Water Absorption, 2 hrs. @ 100 °C	**0.7%**
Water Absorption, 24 hrs. @100 °C	**0.7%**
Glass Transition Temperature, °C	**30**
Dielectric Constant	**<4**
Dielectric Strength, volts/mil	**>400**
Working Temperature °F	**-60 to 300**
Flexibility@RT	**No**
Blue Flourescing	**No**
Water Resistant	**100% waterproof**

Benefits

- **Superior Bond Strength**
- **Solvent Free**
- **Low Odor**
- **Improves Finished Product Quality**
- **Durable**
- **Good Impact and Vibration Resistance**
- **Easily Automated**
- **No Clean Up**

Substrate Applications

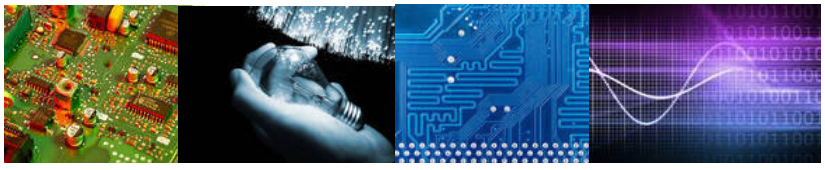
Polycarbonates
PET
PVC
Polyethylene,Polypropylene requires surface treatment such as corona, etc.

CURE SCHEDULE

Medium Pressure Metal Halide Flood Lamp Station @ 50 mW/cm2	40 seconds for 50% UV plastic substrates
Fusion F 300S Lamp D Conveyor @ 5 FPM	Cure Depth: 0.30 inch
Fixed time between 2 Glass Slides @ low intensity black light	1 second
Cure Depth @ 50 mW/cm 2 for 2 minute	0.30 inch
UV LED 365 nm to 395 nm	Time depends on the intensity and wavelength

Storage and Shelf Life

This UV Cure material should be stored in a dark place, above 0°C and below 30 °C. The shelf life is one year from the date of manufacture.



Engineering Excellence
For technical information
and support call **1-800-552-0299** or visit our website at
www.instantca.com

Directions for Use

1. This product cures at exposure to daylight. Minimize to expose during storage and handling.
2. Surface of substrates should be clean and free from grease, mold release, or other contaminants.
3. Cure speed is dependent on UV energy, intensity of UV Light, required depth of cure and percentage of light transmission of substrates.
4. For the best performance, Fusion Lamp D or medium pressure metal halide should be used. Also, UVLED at 365 nm to 395 nm can be used.
5. Allow cured parts to cool before testing to any service loads.
6. Air inhibits a surface cure. To minimize this effect an inert gas such as nitrogen can be used or a higher intensity can be used.