



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

MAXIMUM PERFORMANCE SERIES

MP531104I

UV ADHESIVE

TECHNICAL DATA SHEET
TDS #: MP531104I
UV Adhesive
Passed ISO 10993 Cytotoxicity

DESCRIPTION

MP531104I is a high performance UV curing adhesive engineered to bond plastic, metal, and glass. 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 MP531104I has passed ISO 10993 Cytotoxicity testing and is a leading performer when used for bonding general industrial applications. MP531104I is often cured with an electroless lamp D, medium pressure halide lamp. This UV adhesive also works well with UV light emitted diodes (UV LED) at wavelengths of 365 nm to 410 nm. Design engineers select MP531104I for the optimum in finished product quality, reliability, performance, and cost effectiveness. MP531104I 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	Liquid
Density, g/ml	1.02
Viscosity, 25 °C, 20 RPM	440cp-550cp
Flash Point °C	77

PHYSICAL PROPERTIES (CURED):

Durometer Hardness	D65
Water Absorption, 2 hrs. @100 °C	3%
Water Absorption, 24 hrs. @ 25 °C	2.7%
Glass Transition Temperature, °C	63
Tensile Strength PSI	3450
Dielectric Constant	<4
Dielectric Strength, volts/mil	>400
Working Temperature °F	-60 to 300
Flexibility@RT	No

CURE SCHEDULE

Medium Pressure Metal Halide Flood Lamp Station @ 50mW/cm2
Fusion F 300 S Lamp D Conveyor @
Fixed time between 2 Glass Slides @ low intensity black light
Cure Depth @ 50 mW/cm2 for 2 minutes
UV LED 365 nm to 410 nm

5 seconds for 20% UV block PVC
Belt Speed @ FPM
0.5 second
1.1 inch
Time depends on the intensity and wavelength

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

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

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

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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 410 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.**

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