

Revised  
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**TECHNICAL DATA SHEETS**  
**MP 5403FLEX**

**Description:**

**MP 5403FLEX** is an one component epoxy system designed as a high flexibility adhesive and sealant. It was designed for glass to glass, metal, and ceramic bonding where flexibility at -50°F temperature are critical. The material can be cured by convection oven or infrared heating equipment. Dispensing is easily automated through the use of commercially available equipment.

**TYPICAL USES:**

- \* **High Impact Applications**
- \* **Glass Headlamps**
- \* **Metal Bonding**
- \* **Ceramic Bonding**

**PHYSICAL PROPERTIES:**

<b>Color:</b>	<b>Gray</b>
<b>Consistency:</b>	<b>Paste</b>
<b>Pounds per Gallon:</b>	<b>9.3-9.7 lbs.</b>
<b>Hardness Shore D:</b>	<b>&lt;45 D</b>
<b>Press Flow-Initial:</b>	<b>60-90 Seconds</b>
<b>Sag Resistance-Initial:</b>	<b>&lt;.450"</b>
<b>Stroke Cure @ 160°C:</b>	<b>&lt;130 Seconds</b>
<b>Volatiles @ 300°F:</b>	<b>&lt; 2%</b>

<b><u>CURE SCHEDULE:</u></b>	<b>250°F</b>	<b>320°F</b>	<b>350°F</b>
<b>(Once Part Reaches Temp)</b>	<b>40 Min.</b>	<b>20 Min.</b>	<b>8 Min.</b>

<b><u>STORAGE/ SHELF LIFE:</u></b>	<b>32°F</b>	<b>75°F</b>	<b>100°F</b>
	<b>6 Months</b>	<b>2 Months</b>	<b>2 Weeks</b>

Store in cool and dry area

***Engineering Excellence***

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

***www.instantca.com***