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monicas[®] MP-204



テクニカルガイド

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Yokohama Kobunshi Kenkyujo Co.,Ltd

monicas[®] MP-204 is a clear one coat adhesive for Fluoroelastomers(apply to all kinds of Fluoroelastomers).

Especially, **monicas[®] MP-204** can apply to peroxide cure system Fluoroelastomers include Propylene consisted Fluoroelastomers, these elastomers are very difficult to bonding.

Also **monicas[®] MP-204** can get tough bonding with good anti-hot water resistance.

Features

Grade name	monicas[®] MP-204
Apperance	Transparent~Light Yellow
Specific gravity	0.810~0.850(20℃)
Solid content	5.5~6.5%
Viscosity	Cps
Flash point	12(Closed・℃)
Solvent	Methanol
Dilution	Methanol
Packing & Units	0.9kg square can or 15kg round can



§ Bonding property

□ Test condition

- Metal 40×15×1t SUS304P
- Gum
 - ◆ ① Viton B Diak#3 Formulation
 - ◆ ② Viton E-430 Standard Formulation
 - ◆ ③ Viton B Bisphenol cure Formulation
 - ◆ ④ Dai-el G-901 Standard Formulation
 - ◆ ⑤ AFLAS 150P Recommended Formulation

Formulation	①	②	③	④	⑤
Gum	100.0	100.0	100.0	100.0	100.0
N-990 Carbon Black	30.0	30.0	30.0	30.0	30.0
Calcium hydroxide		6.0	6.0		
Magnesium oxide (low activity)	15.0				
Magnesium oxide (high activity)		3.0	3.0		
Diak #3	3.0				
Viton Curative #20			3.0		
Viton Curative #30			4.0		
TAIC				4.0	5.0
Perhexa25B/40				1.5	
Peroxide*					1.0
Calcium Stearate					1.0
Total	148.0	139.0	146.0	135.5	137.0

*1,3Bis(t-butylperoxy)-di-isopropyl Benzene(100% active)

- Treatment of Metal Remove soils such as greases and oils by Trichlene
Grit Blast10min.(#20)
Clean surface by Trichlene(dry:15min. at 96℃)
- Apply adhesive Use brush apply once
- Dry condition 15 min. at room temperature
- Prebake 15 min. at 180℃ for formulation 1 to 4
30 to 60 min. at 210℃ or 15 to 30 min. at 250℃ for formulation 5

● Curing condition

Compound	Press cure	Post cure
Viton B Diak #3 Formulation	15 min. at 167℃	12 hours at 200℃
Viton E-430 Standard Formulation	15 min. at 177℃	12 hours at 230℃
Viton B Bisphenol cure Formulation	15 min. at 177℃	12 hours at 230℃
Dai-el G-901 Standard Formulation	10 min. at 160℃	4 hours at 180℃
AFLAS 150P Recommend Formulation	20 min. at 170℃	4 hours at 200℃



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- Exfoliation Use pincers
- Remark G>F>M>P
Depend on the broken area ratio
M : Broken at metal – adhesive layer
RC : Broken at adhesive – rubber layer
R : Broken on rubber

□ Test results

Compound	only Press cure					after Post cure						
		M	-	RC	-	R		M	-	RC	-	R
Viton B Diak #3 Formulation	G	0	-	0	-	100	G	0	-	0	-	100
	G	0	-	0	-	100	G	0	-	0	-	100
	G	0	-	0	-	100	G	0	-	0	-	100
Viton E-430 Standard Formulation	G	0	-	0	-	100	G	0	-	0	-	100
	G	0	-	0	-	100	G	0	-	0	-	100
	G	0	-	0	-	100	G	0	-	0	-	100
Viton B Bisphenol cure Formulation	G	0	-	0	-	100	G	0	-	0	-	100
	G	0	-	0	-	100	G	0	-	0	-	100
	G	0	-	0	-	100	G	0	-	0	-	100
Dai-el G-901 Standard Formulation	G	0	-	0	-	100	G	0	-	0	-	100
	G	0	-	0	-	100	G	0	-	0	-	100
	G	0	-	0	-	100	G	0	-	0	-	100
AFLAS 150P Recommended Formulation	G	0	-	0	-	100	G	0	-	0	-	100
	G	0	-	0	-	100	G	0	-	0	-	100
	G	0	-	0	-	100	G	0	-	0	-	100