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monicas[®] MP-602



テクニカルガイド

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Yokohama Kobunshi Kenkyujo Co.,Ltd.

monicas[®] MP-602 is a one coat adhesive for Fluoroelastomers (apply to co- and ter-polymer bis- phenol cure system and co- and ter-polymer amine cure system).
monicas[®] MP-602 is a special grade developed for the Chinese environment and use conditions.
monicas[®] MP-602 can apply wide usage such as oil seals, bearing seals, many kinds of valves, rolls, etc...

Features

Grade name	monicas[®] MP-602
Appearance	Clear
Specific gravity	0.810~0.830(20℃)
Solid content	4~8%
Viscosity	1 cps
Flash point	12.2(closed・℃)
Solvent	MIBK/MeOH
Dilution	MEK or MIBK/MeOH
Packing & Units	0.9kg square can or 15kg round can



§ Bonding property

□ Test condition

- Metal 40 × 15 × 1t SUS304P
- Gum

Formulation	①	②	③	④	⑤
Dai-el G752 (Daikin)	100.00				
FPM 2602 (Chenguang)		100.00			
FPM 2462 (Chenguang)			100.00		
13W (Meilan)				100.00	
26503 (Fluorine)					100.00
N-990 Carbon Black			2.00	2.00	2.00
Diatmous Earth	15.00	15.00	12.00	15.00	15.00
Calsium Metasilicate	18.00	18.00	18.00	18.00	18.00
Titanium Dioxide	0.10	1.00			
Ferric oxide			4.00	4.00	4.00
Phthalocyanine Green	0.85	0.85			
Calcium hydroxide	3.00	3.00	3.00	3.00	3.00
Magnesium oxide(high activity)	6.00	6.00	6.00	6.00	6.00
Carnauba Wax	0.50	1.50	1.20	1.20	1.50
Bis-Phenol AF		1.70	1.75	1.70	1.70
Benzyl Triphenylphosphonium Chloride		0.45	0.55	0.45	0.45
Total	143.35	147.5	148.5	151.35	151.65

- Treatment of Metal Remove soils such as greases and oils by Trichlene
Grit Blast10 min.(#20)
Clean surface by Trichlene (dry : 15 min. at 96℃)
- Apply adhesive Use brush apply once
- Dry condition 15 min. at room temperature
- Prebake 15 min. at 150℃
- Curing condition Press Cure : 15 min. at 180℃
Oven Cure : 12 hours at 230℃
- 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



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□ Test results

Compound	only Press cure			after Post cure		
		M	- RC - R		M	- RC - R
①	G	0	- 0 - 100	G	0	- 0 - 100
	G	0	- 0 - 100	G	0	- 0 - 100
	G	0	- 0 - 100	G	0	- 0 - 100
②	G	0	- 0 - 100	G	0	- 0 - 100
	G	0	- 0 - 100	G	0	- 0 - 100
	G	0	- 0 - 100	G	0	- 0 - 100
③	G	0	- 0 - 100	G	0	- 0 - 100
	G	0	- 0 - 100	G	0	- 0 - 100
	G	0	- 0 - 100	G	0	- 0 - 100
④	G	0	- 0 - 100	G	0	- 0 - 100
	G	0	- 0 - 100	G	0	- 0 - 100
	G	0	- 0 - 100	G	0	- 0 - 100
⑤	G	0	- 0 - 100	G	0	- 0 - 100
	G	0	- 0 - 100	G	0	- 0 - 100
	G	0	- 0 - 100	G	0	- 0 - 100