テクニカルガイド

株式会社 横浜高分子研究所
+81-45-594-7171

monicas®
MP-605E

テクニカルガイド

株式会社 横浜高分子研究所
+81-45-594-7171

monicas® MP-605E

Yokohama Kobunshi Kenkyujo Co.,Ltd.

monicas® MP-605E 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-605E can apply wide usage such as oil seals, bearing seals, many kinds of valves, rolls, etc…

Features

Grade name	**monicas® MP-605E**
Appearance	Clear
Specific gravity	0.820～0.840(20℃)
Solid content	7～11%
Viscosity	1 cps
Flash point	12.2(closed・℃)
Solvent	MEK/MeOH
Dilution	MEK/MeOH
Packing & Units	0.9kg square can or 15kg round can

株式会社 横浜高分子研究所
+81-45-594-7171

§ Bonding property

❑ Test condition

- Metal 40×15×1t SUS304P
- Gum
  - ◆ ① Viton B Diak#1 Formulation
  - ◆ ② Viton B Diak#3 Formulation
  - ◆ ③ Viton E-430 Standard Formulation
  - ◆ ④ Viton E-60C Standard Formulation
  - ◆ ⑤ Viton B Bisphenol cure 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	6.0
Magnesium oxide(low activity)	15.0	15.0			
Magnesium oxide(high activity)			3.0	3.0	3.0
Diak #1	1.5				
Diak #3		3.0			
Viton Curative #20					3.0
Viton Curative #30					4.0
Total	146.5	148.0	139.0	139.0	146.0

- Treatment of Metal Remove soils such as greases and oils by Trichlene
  Grit Blast10min. (#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

Compound	Press cure	Post cure
Viton B Diak #1 Formulation	15 min. at 167℃	12 hours at 200℃
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 E-60C Standard Formulation	15 min. at 177℃	12 hours at 230℃
Viton B Bisphenol cure Formulation	15 min. at 177℃	12 hours at 230℃

株式会社 横浜高分子研究所
+81-45-594-7171

- 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 #1 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 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 Srandard 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-60C 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