



Magna-Tac M648-T

Product Information Sheet

Room Temperature Curing Epoxy Adhesive

Viscosity	Color	Base	Wgt/Gal	Solids	Diluant	Shelf Life
Medium Syrup	Clear, pale amber	Modified epoxy	9.5 lbs	100 %	Do not dilute	1 year

MagnaTac M648T is a high-strength, room-temperature-curing, 100%-Reactive, two-component, formulated epoxy adhesive designed for bonding all metals and other rigid materials (such as glass, ceramics, plastics, plastic foams and structural laminates) to themselves and to each other.

Fully cured bonds exhibit minimal shrinkage, are electrical insulators and provide excellent resistance to weather, galvanic action and most chemical, acids and alkalis.

Surface Preparation

All bonding surfaces must be thoroughly cleaned, degreased and dried. For plastic surfaces, remove mold release if any.

Preparation of adhesive

Always stir each part thoroughly, weigh accurately and mix slowly to avoid entrapping air.

Note: Pot life can be lengthened substantially if shallow mixing vessels are used or smaller batches are mixed. Cover mixed material to prevent water absorption.

Mixed adhesive may be applied with trowel, spatula, knife, paint roller, brush, etc. Apply enough mixed adhesive to leave about 4-6 mils in the final glue line. This may be accomplished by coating 4-6 mils on one surface only or by coating 2-3 mils on each surface.

If one surface is porous, more adhesive must be applied to fill the voids and yet produce a final glue line thickness of 4-6 mils.

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Cure Time

Room Temperature

If cured at room temperature, assemblies can be handled in approximately 4-6 hours and develop 85 % of maximum strength in 14-24 hours.

Fast Cure

If a faster cure is required, the following cycles may be used:

Elevated Temperatures

Temperature	Cure Time
150°F	60 minutes
200° F	20 minutes
250° F	15 minutes

Choice of Catalysts

Catalyst Number	Mixing Ratio (by weight)	Properties	Pot Life @ 77° F	Average Lap Shear Strength
M648-T CH-8	5 PARTS 1 PARTS	For best balance of properties.	20-45 minutes (1 qt)	2500 psi
M648-T CH-16	2 PARTS 1 PART	For best impact and peel strength.	20-45 minutes (1 qt)	2500 psi

Container Sizes

1 quart cans
 1 gallon cans
 5 gallon pails
 55 gallon drums