

The Creative Adhesives Company

**BEACON** TECHNICAL DATA SHEET**Magna-Tac® BU120D**Beacon Adhesives Co. Inc.  
125 MacQuesten Parkway South  
Mount Vernon, NY 10550 USA

TEL 914.699.3400

beaconadhesives.com

FAX 914.699.2783

info@beaconadhesives.com

**PRODUCT SUMMARY**

Magna-Tac® BU120D is a high-strength, 100% reactive, room temperature or elevated temperature curing adhesive having good resistance to temperatures up to 400°F. It is used in a wide variety of critical, high-performance applications involving the bonding of all metals and other rigid materials (such as glass, ceramics, structural laminates) to themselves and to each other. Fully-cured bonds yield tensile shear strength in the neighborhood of 1,000-2,000 psi when tested at either room temp or 400°F. Cured adhesive exhibits minimal shrinkage and excellent resistance to most chemicals.

**Product Data****Surface Preparation**

Bonding surfaces must be thoroughly cleaned, degreased and dried. If bonding to metal surfaces, chemical etching or special surface treatment is recommended for maximum bond strength & exposure resistance.

**Preparation of Adhesive**

To 100 parts **by weight** of part 1, add 40 parts **by weight** of part 2 while stirring. Pot life of a one quart batch is approximately 30 minutes at room temperature (77°F). *NOTE: Pot life can be lengthened substantially if shallow metal mixing vessel is used or if small batches are mixed.*

**Application**

Mixed Magna-Tac® BU120D may be applied with spatula, trowel, knife, stiff brush, etc. Apply enough mixed adhesive to leave about 4 - 6 mils on one surface only or by coating 2 - 3 mils on each surface. Press parts together firmly enough to establish and maintain intimate contact during cure (10 psi is sufficient).

** Cure Time**

When cured at room temperature, Magna-Tac® BU120D develops approximately 85% of its maximum strength in 24 hours. Bond continues to advance in strength for approximately one week. If a faster cure is desired in order to develop the ultimate in heat resistance as rapidly as possible, a cure cycle of 30 minutes at 350°F is recommended.

**Caution!**

Magna-Tac® BU120D part 2 contains materials which will react with water and moist air. Keep container closed tightly and protect from moisture.

The Creative Adhesives Company

**BEACON****TECHNICAL DATA SHEET****Magna-Tac® BU120D**Beacon Adhesives Co. Inc.  
125 MacQuesten Parkway South  
Mount Vernon, NY 10550 USA

TEL 914.699.3400

beaconadhesives.com

FAX 914.699.2783

info@beaconadhesives.com

**Specifications**

	Viscosity (cps) at 77°F	Color	Base	Solvent	Weight/gal
<b>Part 1</b>	Semi- thixotropic	Grey	Modified	Uncured: MEK	13.5
<b>Part 2</b>		White	Epoxy		12.3