

The Creative Adhesives Company

BEACON TECHNICAL DATA SHEET**Magna-Tac® M620**Beacon Adhesives Co. Inc.
125 MacQuesten Parkway South
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PRODUCT SUMMARY

Magna-Tac® M620 is an easy-to-use "no-mix," 100% reactive, solvent free, formulated epoxy adhesive that produces high strength, structural bonds between practically any materials which can withstand a heat cure.

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

While Magna-Tac® M620 spreads smoothly and evenly, it maintains its form once applied and does not flow during the cure cycle. Its is excellent for "poor fit" and similar void-filling applications as well as where dripping or running of adhesive must be controlled.

Product Data**One-Part Heat-Curing Epoxy Adhesive**

Viscosity	Color	Base	Wgt/Gal	Solids	Diluant	Shelf Life
Buttery Thixotropic	Light Tan Opaque	Modified Epoxy	9.3 lbs	100%	Do Not Dilute	1 year

Surface Preparation

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

Preparation of Adhesive

Apply enough Magna-Tac® M620 to fill all cavities and depressions in both surfaces being bonded and 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.

Press parts together firmly enough to establish and maintain intimate contact during cure.

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 **Cure Time**

Temperature	Cure Time
535°F	7-10 min
500°F	12-15 min
450°F	20-25 min
400°F	40-50 min
350°F	1.5-2 hours

Typical lap shear values obtained when Magna-Tac® M620 is used to bond 0.064" etched 2024T3 aluminum alloy to itself in a 1/2 overlap are as follows:

Test Temperature	Av. Lap Shear (psi)
-67°F	1000
77°F	1400
180°F	1400
260°F	1200
300°F	900
400°F	400

Container Sizes

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