



Magna-Tac A-39

MMM-A-134 Type 1

Product Information Sheet

Metal to Metal Structural Epoxy

Viscosity	Color	Base	Wt/Gal	Solids	Diluant	Shelf Life
Paste	Dark Gray	Modified epoxy	9.5 lbs.	100 %	Do not dilute	1 year

Magna-Tac A-39 is a 100% -solids, two-component, solvent-free, formulated epoxy adhesive in paste form specifically designed for metal-to-metal applications and for bonding other rigid materials such as glass, plastics, wood and structural laminates based on glass or fiber reinforced melamine, silicone, polyester, phenolic, epoxy, etc., resins.

This adhesive may be cured at room temperature or at elevated temperatures, depending on manufacturing conditions, properties desired and on service requirements for the finished assembly.

Magna-Tac A-39 meets military specification MMM-A-134 Type 1.

Surface Preparation

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

Preparation of Adhesive

Weigh each part accurately and mix slowly to avoid entrapment of 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

Depending upon the end use service requirements of the completed bond, Magna-Tac A-39 may be used with hardeners which set at room temperatures, at moderate temperatures and at elevated temperatures.



BEACON ADHESIVES CO.

125 MacQuesten Parkway S. • Mount Vernon, NY 10550 USA

Phone 914.699.3400 • Fax 914.699.2783

david@beaconadhesives.com

www.beaconadhesives.com

Magna-Tac A-39 MMM-A-134 Type 1

Product Information Sheet



Cure Time

	Mixing Ratio (by weight)	Properties	Pot Life @ 77F	Aver. Tensile Strength
Part A	7 PARTS	For best balance of properties.	30 min (175 gms)	2500 psi
Part B	2 PARTS			

Heat Curing

75% of cure is attained in 24 hours. To accelerate the cure, any of the following cycles may be used:

Temperature	Cure Time
150F	60 minutes
200F	25 minutes
250F	15 minutes

Where military specification qualification is necessary, A39 must be cured for 1 hour at 164°F.

Application

Mixed Magna-Tac A-39 may be applied with trowel, spatula, knife, etc. Apply enough mixed adhesive to fill all cavities and depressions in both surfaces being bonded and to leave about 4 additional mils of adhesive on each side. After proper mating of the components (with slight squeeze out of adhesive), optimum bond line thickness should range from .003 to .006 inch. (Very heavy glue lines may be tolerated up to 0.010 inch - and the adhesive may be cured in heavy sections with very little shrinkage and with good resultant bond strength). Assemble the parts immediately after spreading the adhesive since there are no volatile solvents present to be evaporated.

Clean-up solvent: Do not add thinner to this adhesive. Methyl Ethyl Ketone may be used for cleaning equipment or wiping up spilled adhesive before curing.

Container Sizes

1 quart cans

1 gallon cans

5 gallon pails

55 gallon drums