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Magna-Tac M-24

Product Information Sheet

Two Component Structural Adhesive

	Viscosity (cps) 77°F	Color	Base	Wgt/Gal	Solids	Diluant	Shelf Life
Part A	See Below	Red	Synthetic	7.9 lbs	38%	Ketone	6 Months
Part B		Brown	Rubber	8.4 lbs	Mixed		

Joints made with MagnaTac M24 have good peel, impact and shear strengths and retain a large percentage of their strength when stressed at elevated temperatures. MagnaTac M24 is recommended for bonding metals, rigid plastics, ceramics, wood, and porous materials to themselves and to each other.

MagnaTac M24 is also used as a primer under MagnaTac M611 and other MagnaTac void filling, high-strength epoxy based adhesives where superior peel strength and resistance to weathering are required.

Application

- 1) Surface Preparation:** Degrease. Remove corrosion products and mold release, if any. Surfaces must be dry.
- 2) Mixed adhesive:** Stir each part well, separately. Then, accurately weigh out and mix together thoroughly 4 parts of Part I and 1 part of Part II. The mixture has a working life of up to one month at room temperature.
- 3) Coating:** Apply a light brush coat (2-4 dry mils or 6-15 wet mils) on each surface or apply by spray. To spray, thin Magna-Tac M24 with methyl ethyl ketone to a viscosity of 26 seconds on a #4 Ford cup. Use a DeVilbiss P-MBC-510 gun, #36 air cap, FF fluid tip OR equivalent with 25 psi atomization pressure and 5 psi fluid pressure. Hold the gun approximately 8" from the work.
- 4) Drying:** Dry for 1 hour at 150°F
- 5) Assembly & Cure:** Assemble the dried parts and cure under pressure for 30-60 minutes at 325°F \pm 5°F (glue line temperature). In general, the 60-minute cure cycle produces the best results. Use enough pressure to bring the entire bonding area into intimate contact.