



# BEACON ADHESIVES CO.

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## MagnaTac TR-8899

### ThermoSet Epoxy

lab 161206-01

Viscosity	Color	Base	Wgt/Gal	Solids	Shelf Life
50cps	Amber Translucent	Epoxy	9.1 lbs	36%	3 months

**MagnaTac TR-8899** is a one part formulated thermosetting epoxy designed to adhere metals and alloys in transformer cores, as well as electric motor rotors and stators.

**MagnaTac TR-8899** is a translucent, low viscosity adhesive and is generally applied by roller, dipping or spray.

*Detailed application procedures including photos and video is available by contacting Beacon Adhesives technical staff.*

#### Drying information:

Prior to curing TR-8899 must be dried. Drying is accomplished at 77F for ~2 to 4 hours or heated a maximum of 200F for a period of 30 minutes. Do not exceed 200F or the adhesive will begin to cure.

#### Curing information.

After TR-8899 has been applied, and dried, parts are ready to be cured. Use the table below for guidance. Beacon recommends 320F for 2.5 hours for best results.

Temperature	Minimum Gel Time	Minimum cure time	Maximum Cure Time
266F or 130 C	40 Min.	14 Hours	none
284F or 140C	32 Min	7 Hours	none
302F or 150C	20 min	4 hours	none
320F or 160C	15 min	2 hours	none
338F or 170C	10 min	1.5 hours	none
356F or 180C	8 min	1 hour	none
374F or 190C	6 min	45 min	none
392F or 200C	4 min	30 min	24 hours
428F or 220C	2 min	10 min	60 min.



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**Physical Properties:**

Once cured MagnaTac TR-8899 exhibits lap shear strength of 4500 PSI as per ASTM D1002.

**Contacting Beacon Adhesives Co. Inc.**

Technical assistance. Additional technical assistance is available by telephone and email.

Technical assistance telephone 914-699-3400

Technical email assistance: [david@beaconadhesives.com](mailto:david@beaconadhesives.com)

General information

Telephone 914-699-3400

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**REACH and RoSH compliance:**

We certify that all adhesive manufactured by Beacon Adhesives Co. Inc. are in compliance with both REACH and RoSH.