

The Creative Adhesives Company

**BEACON** TECHNICAL DATA SHEET**Magna-Tac® F310**Beacon Adhesives Co. Inc.  
125 MacQuesten Parkway South  
Mount Vernon, NY 10550 USA

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beaconadhesives.com

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**PRODUCT SUMMARY**

Magna-Tac® F310 is a one part, heat cure adhesive designed for high temperature applications including motor laminates, transform cores. Magna-Tac® F310 is formulated with exceptionally low hydrolysable chloride for exceptional chemical resistance to aggressive solvents and concentrated acids.

**Product Data****High Temperature & Chemical Resistant Thermoset Epoxy Adhesive**

Viscosity	Color	Base	Wgt/Gal	Solids	Shelf Life
3000 cps	Amber Translucent	Epoxy	9.1 lbs	100%	3 months

**Cure Time**

After Magna-Tac® F310 been applied, parts are to be cured in accordance with the following schedule.

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

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**Physical Properties**

Once cured Magna-Tac® F310 exhibits lap shear strength of 4500 PSI as per ASTM D1002.