



BEACON ADHESIVES CO.

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Magna-Tac 2220

Product Information Sheet

Metal to Metal, Structural Epoxy

Viscosity	Color	Base	Specific Gravity	Solids	Diluent	Shelf Life
Paste	Dark Grey	Modified epoxy	9.3 lbs	100 %	Do not dilute	1 year

Magna-Tac 2220 is a vinyl modified epoxy adhesive with a paste consistency that offers a light degree of initial tack which helps keep the adhesive in place during cure. Once fully cured with the recommended activators, Magna-Tac 2220 forms rigid, impact-resistant bonds. Magna-Tac 2220 conforms to mil spec MMM-A-134 type II when cured with Activator E.

Magna-Tac 2220 adhesive has a continuous service rating of 65°F to 250°F. When the application requires minimal stress or force, temperatures as low as 110°F and as high as 325°F may be tolerated.

Typical Applications:

Magna-Tac 2220 adhesive is particularly useful for bonding copper and its alloys; also excellent for bonding aluminum, stainless steel, nickel and dissimilar metals. With its wide temperature range, Magna-Tac 2220 can be used as a sealant, especially on uneven surfaces and between wide gaps where low viscosity adhesives cannot be used. This adhesive will not support fungus growth.

Curing Systems:

Activator "A" has a low combining weight which results in a minimum reduction in the viscosity of the adhesive and short time room temperature cures.

Activator "E" is a low reactivity activator designed for use only when a prolonged working life is required and elevated cure temperatures can be tolerated. It is not recommended for room temperature cures.

Activator H-20 allows for room temperature cures that have improved physical properties, a longer working life and a higher combining weight which results in a more manageable adhesive system. Materials will cure to a good handling strength in 16 hours at room temperature. H-20 mixtures can be rapidly cured at elevated temperatures when necessary; 30 minutes at 165°F will offer physical properties equal to 16 hours at room temperature.



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Typical Physical Properties of Magna-Tac 2220 / Activator Systems

Activator	"A"	"E"	H-20
Mix Ratio 2220/Activator by weight	100/8	100/6	100/17
Mix Viscosity	Paste	Paste	Paste
Working Life (4 oz.)	20 Min.	2-3 Hrs.	45 Min.
Tensile Shear Al/Al @ 77°F	3000 psi	3500 psi	3850 psi