



MagnaCryl 640

Product Information Sheet

Room Temperature Curing Epoxy Adhesive

Viscosity (cps)	Color	Base	Wt/Gal	Solids	Flash Point	Diluant	Shelf Life
Thixotropic	Clear Yellow	Modified acrylic	8.1 lbs.	100 %	49°F	Do not dilute	1 year

MagnaCryl 640 is a high performance modified acrylic structural adhesive for bonding a wide variety of metallic and non-metallic materials to themselves or to each other. MagnaCryl 640 develops outstanding shear and peel properties exceeding the inherent strengths of many engineering thermoplastics.

Choice of Catalyst

Accelerator #4: Allows 'no-mix' application where the glue line is less than 10 mils.

Accelerator #5: This two part system provides a faster cure, and a shorter pot life.

Catalyst #	Mixing Ratio (by wt)	Properties	Pot Life @ 77° F	Avg Lap Shear Strength
640 Accelerator #4	No mixing required	For easier application.	None	3000 psi
640 Accelerator #5	100 PARTS 5 PARTS	For faster cure.	5 minutes (1 qt)	3000 psi

Surface Preparation

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

Preparation of adhesive

Depending on the desired method of application, 640 can be cured with Accelerator #4 or Accelerator #5. Always stir each part thoroughly, weigh accurately, and knead slowly to avoid entrapping air.

Mixed adhesive may be applied with trowel, spatula, knife, paint roller, brush, etc. Apply enough mixed adhesive to leave about 4-6 mils in the final glue line. This may be accomplished by coating 4-6 mils on one surface only or by coating 2-3 mils on each surface. If one surface is porous, more adhesive must be applied to fill the voids and yet produce a final glue line thickness of 4-6 mils.



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Cure Time

Cure With Accelerator #4

"NO MIX" SYSTEM: (Not recommended where glue line thickness is greater than 10 mils and/or accelerated cure times are needed.)

Apply a thin, uniform coating of Accelerator #4 to both surfaces by spray, brush, or roller. Accelerator #4 dries in about 30 seconds. After the Accelerator #4 has dried it will appear as a white colored coating. Apply the MagnaCryl 640 to either part at any time within the next 4 hours. The parts should then be joined and allowed to remain in place for about 30 min. The parts can then be moved and handled safely. Full strength is achieved after 24 hrs.

Cure With Accelerator #5

TWO PART MIX SYSTEM:

Add 5 parts by weight of Accelerator #5 to 100 parts of MagnaCryl #640 and mix thoroughly (avoid excessive introduction of air bubbles). Because of the short pot life and cure time, (approx. 15 minutes) parts should be joined as soon as possible after mixing, and clean-up done at this time. Solvents such as toluene or acetone may be used for clean-up.

Bonds will continue to improve in strength at room temperature until optimum is reached, usually within 1-2 days.

Container Sizes

- 1 quart containers
- 1 gallon containers
- 5 gallon pails
- 55 gallon drums