



System Three Resins, Inc.
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 TECHNICAL SUPPORT: 253-333-8118

TECHNICAL DATA SHEET
SilverTip MetlWeld™
 EPOXY ADHESIVE

DESCRIPTION:

MetlWeld™ is a toughened, two-part room-temperature curing epoxy adhesive. It is designed to bond well to mild steel, stainless steel, brass, copper and aluminum. MetlWeld™ develops strength earlier than most comparable 1:1 epoxy adhesives and will cure at temperatures down to 50° F. MetlWeld will bond metals to metal, wood, stone, concrete, ceramic, neoprene rubber or even glass.

RESIN PROPERTIES:

Viscosity 133,000 cps
 Color White
 Density(lb/gal) 10.26

HARDENER PROPERTIES:

Viscosity 108,000 cps
 Color Gray
 Density(lb/gal) 11.18

MIXED SYSTEM PROPERTIES:

Mix ratio by weight resin/hardener 1:1
 Mix ratio by volume resin/hardener 1:1
 Working time @ 25° C 3 hours
 Tack-free time (5-10mil film) @ 25° C 5-8 hours
 Mixed Viscosity (cps) @ 25° C 120,000

TYPICAL CURED PROPERTIES (72 hr. cure @ 25°C):

Lap Shear Strength (psi) (ASTM D1002):
 Aluminum 2524
 Copper 2263
 Stainless Steel 3135
 Brass 3078
 Mild Steel 3513
 Heat Deflection Temperature (°F) 125°F

SURFACE PREPARATION:

Surfaces to be bonded should be freshly abraded with coarse sandpaper or a grinder. Metals can also be etched with appropriate etching solutions. Surfaces must be clean of grease, wax, oil and other contaminants. Wipe surfaces to be bonded with lacquer thinner or equivalent solvent before applying adhesive. Allow 48 hours minimum to cure and develop strength at 77°F(longer at cooler temperatures) before subjecting to stress.

Kit sizes available: ½-pint, 1 quart

For health and safety information concerning this product, refer to the SDS sheets for SilverTip MetlWeld Adhesive. SDS sheets are available on our website at www.systemthree.com, or by calling or writing System Three.

The information contained herein is based on the data available to us and is believed to be correct. However, System Three Resins, Inc. makes no warranty, expressed or implied, regarding the accuracy of these data or the results to be obtained from the use thereof. System Three assumes no responsibility for injury from the use of the product described herein.