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.