



System Three Resins, Inc.
 3500 W. Valley Hwy. N. Suite 105
 Auburn, WA 98001
 Technical Support: 253-333-8118

TECHNICAL DATA SHEET
GelMagic™
STRUCTURAL EPOXY
ADHESIVE

DESCRIPTION:

System Three GelMagic is a non-sagging, two-component structural epoxy adhesive designed to bond wood and other substrates. GelMagic is unique in that it starts as two self-leveling liquids, which form a soft, non-sagging paste when mixed. The Part A resin is a blue color which disappears upon proper mixing. Gel-Magic is also toughened, which gives it high peel strength when cured. As the product cures, the toughening agent precipitates to form a two-phase system, which turns the product opaque. GelMagic cures at room-temperature and displays good elevated temperature properties following a mild post cure.

PHYSICAL PROPERTIES:

Viscosity @ 25°C(77° F) cps
 Density (lb. per gallon)
 Color

	Resin	Fast Hardener	Slow Hardener
Viscosity @ 25°C(77° F) cps	6600	2800	2800
Density (lb. per gallon)	9.90	8.20	8.20
Color	Blue	Amber	Amber
MIXED SYSTEM PROPERTIES:			
Viscosity @ 25°C(77° F) cps	N/A	5300	5300
Mix ratio by volume resin/hardener	100	50	50
Mix ratio by weight resin/hardener	100	41	41
Working time @ 25° C (100 gram mass)	N/A	30 min.	120 min.
Tack-free time @ 25° C	N/A	3 hours	16 hours

Recommended minimum application temperature 50°F
 Recommended maximum service temperature 170°F

TYPICAL CURED PROPERTIES(72 hr cure @ 25°C, or 2 hr. @ 60°C):

Lap-Shear Strength, psi: (ASTM D1002)	Polyester Laminate 2800*	Aluminum 2200
	Concrete 1100*	Brass 1560
	Wood(Maple) 1800*	Copper 1700
*substrate failure	Mild Steel 2010	Stainless Steel 2390
Tensile Strength, psi	7600	
Tensile Elongation at break	7.0%	
Flexural Strength, psi	13,000	
Flexural Modulus, psi	410,000	
Compressive Yield Strength, psi	13,000	
Heat Deflection Temperature, ° F	140	

APPLICATION: Ensure surfaces to be bonded are clean and dry, free from dust, dirt and grease. Apply adhesive to both surfaces, allow to sit 5-10 minutes on porous substrates. If all material is absorbed by the substrate, apply more adhesive. Clamp all the pieces together, using only moderate clamping pressure. Remove clamps after 6-8 hours.

NOTE: GelMagic may be used directly on new wood without pre-coating with an epoxy coating or sealer. If substrates are pre-coated, sand any cured material in the bonding area prior to using GelMagic.
 All tests were conducted in accordance with ASTM procedures.
 For health and safety information concerning this product, please refer to the MSDS sheets for Silvertip Gel Magic MSDS sheets are available on our website at www.systemthree.com, or by calling or writing System Three Technical Support.

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