



**System Three Resins, Inc.**  
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**TECHNICAL DATA SHEET**

**GelMagic™**  
**STRUCTURAL EPOXY**  
**ADHESIVE**

**DESCRIPTION:**

System Three GelMagic is a toughened, structural gelled adhesive, designed for superior bonding to most materials including properly prepared plastics. The mixed adhesive will not run or sag even when used on overhead or vertical surfaces. It is ideal for bridging gaps in poorly mated joints with no loss of strength. GelMagic is 100% waterproof, unaffected by oil, kerosene and many other chemicals and cures to an opaque white. GelMagic is particularly well suited for use in boat construction and repair. It is also an ideal adhesive for general woodworking applications when an easy to use, high strength, gap filling, waterproof adhesive is called for. GelMagic cures at room temperature and displays good elevated temperature properties following a mild post cure at 140°F for 2 hours.

**RESIN PROPERTIES:**

Viscosity @ 25°C(77°F) ..... 90,000 cps  
 Density ..... 9.80 lb/gal  
 Color ..... Blue

**HARDENER PROPERTIES:**

Viscosity @ 25°C(77° F) .....60,000 cps  
 Density ..... 8.40 lb/gal  
 Color ..... Amber

**MIXED SYSTEM PROPERTIES:**

Viscosity @ 25°C (77°F) ..... 80,000 cps  
 Mix ratio by weight (resin/hardener) .....100/46  
 Mix ratio by volume (resin/hardener) .....100/50  
 Working time @ 25° C (100 gram mass) .....30 minutes  
 Tack-free time @ 25° C ..... 3 hours  
 Clamp time @ 25° C ..... 8 hours minimum  
 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:	Polyester Laminate ..... 2800*	Aluminum ..... 2365
(ASTM D1002)	Concrete ..... 1100*	Brass ..... 2624
	Wood(Maple) ..... 1800*	Copper ..... 2587
*substrate failure	Mild Steel .....3678	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.

**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 SDS sheets for SilverTip Gel Magic. SDS sheets are available on our website at [www.systemthree.com](http://www.systemthree.com), or by calling or writing System Three Technical Support.

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