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):

<table>
<thead>
<tr>
<th>Material</th>
<th>Lap-Shear Strength, psi</th>
<th>Tensile Strength, psi</th>
<th>Tensile Elongation at break</th>
<th>Flexural Strength, psi</th>
<th>Flexural Modulus, psi</th>
<th>Compressive Yield Strength, psi</th>
<th>Heat Deflection Temperature, ° F</th>
</tr>
</thead>
<tbody>
<tr>
<td>Polyester Laminate</td>
<td>2800*</td>
<td></td>
<td></td>
<td>13,000</td>
<td>410,000</td>
<td>13,000</td>
<td>140</td>
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<tr>
<td>Concrete</td>
<td>1100*</td>
<td></td>
<td></td>
<td>7.0%</td>
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<tr>
<td>Wood(Maple)</td>
<td>1800*</td>
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</tbody>
</table>

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 Silvetip Gel Magic. SDS sheets are available on our website at www.systemthree.com, or by calling or writing System Three Technical Support.

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.