



# GPI

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## Product Specification Sheet

### Magnobond 6398, Parts A & B

#### DESCRIPTION

Magnobond 6398, Parts A & B is a two component thixotropic paste epoxy system designed for bonding metals and composite structures. Magnobond 6398 has good properties at high and low temperatures using a room temperature cure.

#### SPECIAL FEATURES

1. 6398 is the same as 6392 but without spacer beads for bondline control.
2. QPL listed under Rockwell Specification RBO-120-023.
3. QPL listed under Textron/Bell Specification 299-947-100, Type II, Class 2.

#### PROPERTIES

Mix Ratio: 100:27 parts by weight, A & B

Pot Life: 3 oz. at 77°F: 80 minutes

Cure Schedule: 7 days at 77°F or 1 hour at 150°-250°F.

Note: At room temperature, most of the curing process is completed during the first 12 to 24 hours.

Shelf Life: Parts A and B: 6 months at 75°F or below  
or 12 months @ 40°F or below

Specific Gravity: A: Compound 1.3  
B: Curing Agent 1.0  
Mix: 1.25

Viscosity:  
6398: A: Compound - Paste  
B: Curing Agent - Paste  
Mix: Paste

## CURED PROPERTIES

Lap Shear Strength, ASTM D1002, Al to Al

Test Conditions	Test Value
10 minutes at -67°F	4,200 psi
75°F	4,700 psi
10 minutes at 250°F	3,000 psi
10 minutes at 300°F	2,100 psi
10 minutes at 350°F	900 psi
10 minutes at 400°F	400 psi
75°F after 30 days at 120°F and 95% relative humidity	3,800 psi
75°F after 7 days in hydraulic oil	4,200 psi
75°F after 7 days in JP-4	3,600 psi
Creep rupture, 75°F, 1600 psi	<0.005 inch
Creep rupture, 75°F, 800 psi	<0.005 inch

The above values were obtained using a cure schedule of 7 days at room temperature.

## Lap Shear Strength

Testing to FMS-4500A, Form I - Metallic Filler

Test Conditions	Test Values, psi		Require-	
	5 day/R.T. Cure	2 hours/250°F Cure	ment	
10 minutes at -67°F	4,800	4,800	2,700	
75°F	4,600	5,000	4,000	
10 minutes at 200°F	2,400	3,400	2,000	
10 minutes at 300°F	1,700	2,000	1,600	
7 days water immersion				
75°F	4,200	5,000	3,000	
200°F	3,100	3,000	1,800	

Test Conditions	Test Values, psi		Require-	
	5 day/R.T. Cure	2 hours/250°F Cure	ment	
7 days, Condensing humidity				
75°F	4,200	4,200	3,000	
200°F	2,800	2,800	1,800	
7 days MIL-L-7808 (Engine Oil)				
75°F	4,500	4,500	2,700	
200°F	3,100	3,300	2,000	
7 days MIL-H-83282 (Hydraulic Oil)				
75°F	4,800	4,600	2,700	
200°F	3,300	3,300	2,000	
7 days MIL-H-5606 (Hydraulic Oil)				
75°F	4,800	3,900	2,900	
200°F	3,100	3,500	2,000	
7 days MIL-T-5624 (JP-4)				

75°F	4,400	4,600	2,700
200°F	2,800	3,700	2,000
7 days MIL-A-8243 (Anti-Icing)			
Type I			
75°F	4,700	5,000	2,700
200°F	2,300	3,300	2,000
Type II			
75°F	4,200	4,200	2,700
200°F	2,800	2,800	2,000

Tensile Properties (ASTM D-638)

Tensile Strength @ R.T.           6,000 psi  
   @ 225°F           3,000 psi

Tensile Elongation @ R.T.        3.10%  
   @ 225°F        3.70%

Compressive Properties (ASTM D-695)

Ultimate Compressive Strength @ R.T.   10,000 psi  
   @ 225°F    3,700 psi

Compressive Modulus @ R.T.        300,000 psi  
   @ 225°F    200,000 psi

DANGER

FIRST-AID

May cause severe irritation.	Eyes - Immediately flush
Do not get in eyes, on skin or clothing.	eyes with plenty of water for at least 15 minutes.
Do not inhale vapors.	Get medical attention.
Wear rubber gloves & aprons.	Skin - Wash immediately
Use with adequate ventilation.	with soap and water.
Wash thoroughly after handling.	Clothing - Remove clothing
For industrial use only.	and wash before reuse.
Keep container closed.	
Do not reuse this container.	