

Strain Gage Adhesive



OTHER ACCESSORIES USED IN AN M-BOND 610 INSTALLATION:

- CSM Degreaser or GC-6 Isopropyl Alcohol
- Silicon-Carbide Paper
- M-Prep Conditioner A
- M-Prep Neutralizer 5A
- GSP-1 Gauze Sponges
- CSP-1 Cotton Applicators
- MJG-2 Mylar® Tape
- TFE-1 Teflon® Film
- HSC Spring Clamp
- GT-14 Pressure Pads and Backup Plates



RoHS
COMPLIANT

DESCRIPTION

Two-component, solvent-thinned, epoxy-phenolic adhesive for high-performance applications, including high-precision transducers. Solids content 22%. Widest temperature range general-purpose adhesive available. Low viscosity, capable

of gluelines <0.0002 in [0.005mm]. Extremely thin, hard, void-free gluelines minimize creep, hysteresis, and linearity problems. Cure must begin within four hours of application.

CHARACTERISTICS

Operating Temperature Range:

Short Term: -452° to +700°F [-269° to +370°C].

Long Term: -452° to +500°F [-269° to +260°C].

Transducers: to +450°F [+230°C].

Elongation Capabilities:

1% at -452°F [-269°C];

3% at +75°F [+24°C];

3% at +500°F [+260°C].

Shelf Life:

Minimum 9 months at +75°F [+24°C]; or 15 months at +40°F [+5°C].

Pot Life:

6 weeks at +75°F [+24°C]; 12 weeks at +40°F [+5°C].

Clamping Pressure:

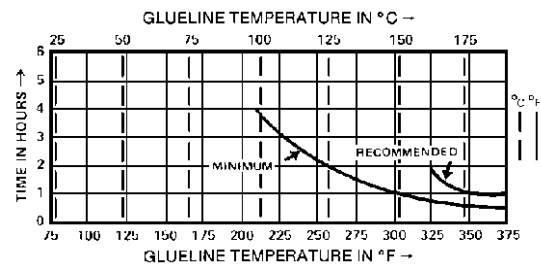
10 to 70psi [70 to 480kN/m²].

30 to 40psi optimum [200 to 275kN/m²].

Cure Requirements:

Recommended Postcure: 2 hours at 50° to 75°F [30° to 40°C] above maximum operating temperature or cure temperature, whichever is higher.

High Precision Transducer Postcure: 2 hours at +400° to +450°F [+205° to +230°C] after wiring.



PACKAGING OPTIONS

Kit:

- 4 bottles [11g ea] Curing Agent
- 4 bottles [14g ea] Resin
- 4 brush caps for dispensing mixed adhesive
- 4 disposable mixing funnels

Single Mix Kit:

- 1 bottle [11g ea] Curing Agent
- 1 bottle [14g ea] Resin
- 1 brush cap for dispensing mixed adhesive
- 1 disposable mixing funnel

References: Instruction Bulletin B-130, "Strain Gage Installations with M-Bond 43-B, 600 and 610 Adhesive Systems," included in each kit.

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