

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 Tip 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 (0.005 mm). Extremely thin, hard, void-free gluelines minimize creep, hysteresis, and linearity problems. Cure must begin within four hours of application.

CHARACTERISTICS	
PARAMETER	DETAILS
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° (-269°C), 3% at +75°F (+24°C), 3% at +500°F (+260°C).
SHELF LIFE	Minimum 4 months after the date of manufacture on the label when stored at +75°F (+24°C); or minimum 6 months after the date of manufacture on the label when refrigerated upon receipt at +40°F (+5°C). Refrigerated storage recommended. Refer to product label.
POT LIFE	6 weeks at +75°F (+24°C); 12 weeks at +40°F (+5°C).
CLAMPING PRESSURE	10 to 70 psi (70 to 480 kN/m ²) Optimum: 30 to 40 psi (200 to 275 kN/m ²)
CURE REQUIREMENTS	<p>Recommended Postcure: 2 hours at 50° to 75°F (30° to 40°C) above maximum operating temperature or cure temperature, whichever is higher.</p> <p>High Precision Transducer Postcure: 2 hours at +400° to +450°F (+205° to +230°C) after wiring.</p>

PACKAGING	
KIT	SINGLE MIX KIT
4 bottles (11 g ea) Curing Agent 4 bottles (14 g ea) Resin 4 brush caps for dispensing mixed adhesive 4 disposable mixing funnels	1 bottle (11 g ea) Curing Agent 1 bottle (14 g 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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