

## 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 Tape
- TFE-1 PTFE 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:

9 months at +75°F [+24°C]; 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:

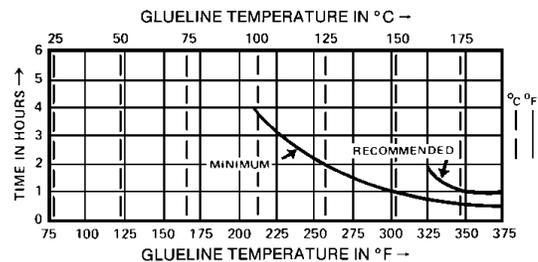
10 to 70psi [70 to 480kN/m<sup>2</sup>].

30 to 40psi optimum [200 to 275kN/m<sup>2</sup>].

#### 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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