

Strain Gage Adhesive for Stress Analysis and Transducer Applications

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 (+232°C).
ELONGATION CAPABILITIES	1% at -452° (-269°C), 3% at +75°F (+24°C), 3% at +500°F (+260°C).
SHELF LIFE	Minimum shelf life of 9 months when stored unmixed at +75°F (+24°C); or 15 months when stored unmixed 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* FOR STRESS ANALYSIS	<div style="display: flex; align-items: center;"> <div style="flex: 1;"> </div> <div style="flex: 1; padding-left: 20px;"> <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> </div> </div>
CURE REQUIREMENTS* FOR TRANSDUCERS	<p>Recommended Cure: *1 hour at +350°F (+177°C).</p> <p>Transducer Postcure: 2 hours at +400° to +450°F (+205° to +232°C) after wiring.</p> <p>*Altered for aluminum-alloy transducers. See Strain Gage Installation Procedures for Transducers.</p>

* **Reference:** Instruction Bulletin B-130 for complete details.

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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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