

Strain Gage Adhesive

OTHER ACCESSORIES USED IN AN M-BOND 600 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



DESCRIPTION

Similar to M-Bond 610 except with more reactive curing agent. Shorter shelf life, pot life, and working time than M-Bond 610, but has lower temperature cures and faster

reaction time. Cure must begin within 30 minutes of application (up to 4 hours for M-Bond 610).

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).															
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 3 months when stored unmixed at +75°F (+24°C); or 9 months when stored unmixed refrigerated upon receipt at +40°F (+5°C). Refrigerated storage recommended. Refer to product label.															
POT LIFE	2 weeks at +75°F (+24°C); 4 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>Moderately Elevated-Temperature Cure Required. Recommended Postcure: 1 to 2 hours at 50°F (30°C) above maximum operating temperature.</p> <table border="1"> <caption>Cure Time vs. Temperature</caption> <thead> <tr> <th>Glueline Temperature (°F)</th> <th>Glueline Temperature (°C)</th> <th>Time (Hours)</th> </tr> </thead> <tbody> <tr> <td>175</td> <td>80</td> <td>2 (Minimum)</td> </tr> <tr> <td>250</td> <td>125</td> <td>1 (Recommended)</td> </tr> <tr> <td>300</td> <td>150</td> <td>0.5</td> </tr> <tr> <td>350</td> <td>175</td> <td>0.5</td> </tr> </tbody> </table>	Glueline Temperature (°F)	Glueline Temperature (°C)	Time (Hours)	175	80	2 (Minimum)	250	125	1 (Recommended)	300	150	0.5	350	175	0.5
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PACKAGING	
KIT	SINGLE MIX KIT
4 bottles (11 g ea) Curing Agent 4 bottles (8 g ea) Resin 4 brush caps for dispensing mixed adhesive 4 disposable mixing funnels	1 bottle (11 g ea) Curing Agent 1 bottle (8 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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