

Strain Gage Adhesives for 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 Applicators
- MJG-2 Mylar® Tape
- TFE-1 Teflon® Film
- HSC Spring Clamp
- GT-14 Pressure Pads and Backup Plates

DESCRIPTION

Two-component, solvent-thinned, epoxy-phenolic adhesive for high-precision transducers; solids content 22%. Low viscosity, capable of gluelines <0.0002 in (0.005mm).

Extremely thin, hard, void-free gluelines minimize creep, hysteresis, and linearity problems. Life limited by oxidation and sublimation effects at elevated temperatures.

CHARACTERISTICS

Operating Temperature Range:

– 452° to + 450°F
(– 269° to + 230°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:

45 to 60 psi (3 to 4 bar)
50 psi (3.4 bar) optimum

Cure Requirements:

Recommended Cure:*1 hours at + 350°F (+ 175°C)

Recommended Postcure:*2 hours at + 400° to + 450°F
(+ 205° to + 230°C)

*Altered for aluminum-alloy transducers. See Strain Gage Installation Procedures for Transducers.

PACKAGING

Kit:

- 4 bottles (11 g ea) Curing Agent
- 4 bottles (14 g ea) Resin
- 4 brush caps for applying adhesive
- 4 disposable mixing funnels