

## 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            | <b>Short Term:</b> -452° to +700°F (-269° to +370°C).<br><b>Long Term:</b> -452° to +500°F (-269° to +260°C).<br><b>Transducers:</b> 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                             | 5 months from the date of manufacture on the label (minimum published 4 months) when stored unmixed at +75°F (+24°C); or 7 months from the date of manufacture on the label (minimum published 6 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 <sup>2</sup> )<br><b>Optimum:</b> 30 to 40 psi (200 to 275 kN/m <sup>2</sup> )   |
| CURE REQUIREMENTS* FOR STRESS ANALYSIS | <div style="display: flex; align-items: center;"> <div style="flex: 1;"> <p style="text-align: center;">GLUELINE TEMPERATURE IN °C --</p> <p style="text-align: center;">GLUELINE TEMPERATURE IN °F --</p> </div> <div style="flex: 1; padding-left: 20px;"> <p><b>Recommended Postcure:</b><br/>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><b>Recommended Cure:</b><br/>*1 hour at +350°F (+177°C).</p> <p><b>Transducer Postcure:</b><br/>2 hours at +400° to +450°F (+205° to +232°C) after wiring.</p> <p>*Altered for aluminum-alloy transducers.<br/>See Strain Gage Installation Procedures for Transducers.</p>  |

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

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| <b>PACKAGING</b>   |  |
|--|--|
| <b>KIT</b>   | <b>SINGLE MIX KIT</b>  |
| 4 bottles (11 g ea) Curing Agent<br>4 bottles (14 g ea) Resin<br>4 brush caps for dispensing mixed adhesive<br>4 disposable mixing funnels | 1 bottle (11 g ea) Curing Agent<br>1 bottle (14 g ea) Resin<br>1 brush cap for dispensing mixed adhesive<br>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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