

## Strain Gage Adhesive



### OTHER ACCESSORIES USED IN AN M-BOND AE-15 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
- PCT-2M Gage Installation Tape
- HSC Spring Clamp
- GT-14 Pressure Pads and Backup Plates

### DESCRIPTION

Two-component, 100%-solids epoxy system for general-purpose stress analysis. Transparent, medium viscosity. Cure time as low as six hours at +125°F [+50°C]. Recommended for more critical applications, including transducers. It has a longer pot life than M-Bond AE-10 which allows more time for multiple gage installations. Elevated-temperature

postcure is recommended for maximum stability, and/or tests above room temperature. Highly resistant to moisture and most chemicals, particularly when postcured. For maximum elongation, bonding surface must be roughened. Cryogenic applications require very thin glue lines.

### CHARACTERISTICS

#### Operating Temperature Range:

**Long Term:** -452° to +200°F [-269° to +95°C].

**Transducers:** to +175°F [+80°C].

#### Elongation Capabilities:

2% at -320°F [-195°C];

10% to 15% at +75°F [+24°C];

15% at +200°F [+95°C].

#### Shelf Life:

12 months at +75°F [+24°C]; 18 months at +20°F [-7°C]. If crystals form in resin jar, heat to +120°F [+50°C] for 30 minutes. Cool before mixing.

#### Pot Life:

1-1/2 hours at +75°F [+24°C].

#### Clamping Pressure:

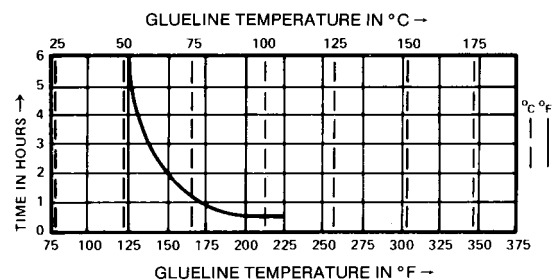
5 to 20 psi [35 to 140 kN/m<sup>2</sup>].

#### Cure Requirements:

**Recommended PostCure:** 2 hours at 25°F [15°C] above maximum operating temperature.

#### Optimum Performance Transducer Postcure:

1 hour at +200°F [+95°C].



### PACKAGING OPTIONS

#### Kit:

- 6 mixing jars [10 g ea] Resin
- 1 bottle [15 ml] Curing Agent 15
- 6 calibrated pipettes
- 6 stirring rods

#### Bulk:

- 200 g Resin
- 25 g Curing Agent 15
- 3 calibrated pipettes

#### References:

Instruction Bulletin B-137, "Strain Gage Applications with M-Bond AE-10, AE-15, and GA-2 Adhesive Systems", included in each kit.