

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 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

Operating Temperature Range:

Short Term: -452° to $+700^{\circ}\text{F}$ [-269° to $+370^{\circ}\text{C}$].

Long Term: -452° to $+500^{\circ}\text{F}$ [-269° to $+260^{\circ}\text{C}$].

Elongation Capabilities:

1% at -452°F [-269°C];

3% at $+75^{\circ}\text{F}$ [$+24^{\circ}\text{C}$];

3% at $+500^{\circ}\text{F}$ [$+260^{\circ}\text{C}$].

Shelf Life:

3 months at $+75^{\circ}\text{F}$ [$+24^{\circ}\text{C}$]; 9 months at $+40^{\circ}\text{F}$ [$+5^{\circ}\text{C}$].

Pot Life:

2 weeks at $+75^{\circ}\text{F}$ [$+24^{\circ}\text{C}$]; 4 weeks at $+40^{\circ}\text{F}$ [$+5^{\circ}\text{C}$].

Clamping Pressure:

10 to 70 psi [70 to 480 kN/m²].

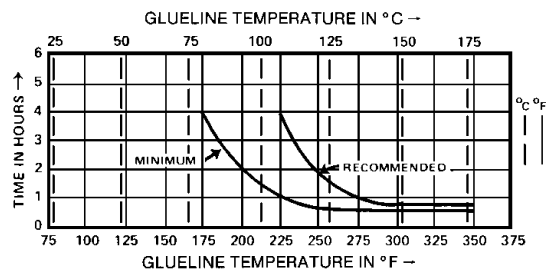
30 to 40 psi optimum [200 to 275 kN/m²].

Cure Requirements:

Moderately Elevated-Temperature Cure Required.

Recommended Postcure:

1 to 2 hours at 50°F [30°C] above maximum operating temperature.



PACKAGING

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

Single Mix Kit:

- 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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