

Strain Gage Adhesive



OTHER ACCESSORIES USED IN AN M-BOND 450 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

High-performance, two-component, solvent-thinned epoxy system specially formulated for high accuracy, elevated-temperature transducer applications.

CHARACTERISTICS

Operating Temperature Range:

Short Term: -452° to $+750^{\circ}\text{F}$ [-269° to $+400^{\circ}\text{C}$].

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

Elongation Capabilities:

$>5\%$ at $+75^{\circ}\text{F}$ [$+24^{\circ}\text{C}$].

Shelf Life:

6 months at $+75^{\circ}\text{F}$ [$+24^{\circ}\text{C}$].

Pot Life:

6 weeks at $+75^{\circ}\text{F}$ [$+24^{\circ}\text{C}$].

Clamping Pressure:

60 to 100 psi [415 to 690 kN/m²].

Cure Requirements:

Step 1: Air dry at $+75^{\circ}\text{F}$ [$+24^{\circ}\text{C}$] 10 to 30 minutes.

B-Stage: $+225^{\circ}\text{F}$ [$+105^{\circ}\text{C}$] for 30 minutes.

Cure: $+350^{\circ}\text{F}$ [$+175^{\circ}\text{C}$] for 1 hour.

Recommended Postcure: 1 hour at 50°F [30°C] above maximum operating temperature in 50°F [30°C] increments from $+350^{\circ}\text{F}$ [$+175^{\circ}\text{C}$], dwelling 1 hour at each step.

PACKAGING

Kit:

- 4 bottles [12.5 g ea] Curing Agent
- 4 bottles [12.5 g ea] Resin
- 4 brush caps for applying adhesive
- 4 disposable mixing funnels

References: Instruction Bulletin B-152, "Instructions for the Application of Micro-Measurements M-Bond 450 Adhesive", included in each kit.

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