

## Strain Gage Adhesives for Transducer Applications

M-Bond 610



### 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