



Strain Gage Installations with P Adhesive

Description

Single-part, solvent-thinned, polyimide adhesive. Results in a strong, thin, near creep-free adhesive layer. Recommended for high temperature stress analysis and transducer applications.

Characteristics

Operating Temperature Range
-452° to +700°F [-270° to +370°C]
+800°F [+425°C] for 1 to 2 hours

Elongation Capabilities
+/-2% at +75°F [+24°C]

Shelf Life
4 months at +75°F [+24°C]

Pot Life
4 months at +75°F [+24°C]

Clamping Pressure
20 to 40 psi [140 to 280 kN/m²]

Cure Requirements
250°F for 2 hours, increase temperature to 300°F for 2 hours, increase temperature to 340°F for 2 hours, increase temperature to 380°F for 4 hours.

Recommended Postcure (Unclamped)
Small gages (<1/8" gage length)
200°F for 1 hour, increase temperature to 300°F for 1 hour, increase temperature to 400°F for 2 hours, increase temperature to 500°F for 4 hours, increase temperature to 600°F for 4 hours, increase temperature to 650°F for 6 hours.

Large gages (>1/8" gage length)
200°F for 1 hour, increase temperature to 300°F for 1 hour, increase temperature to 400°F for 6 hours, increase temperature to 500°F for 12 hours, increase temperature to 600°F for 6 hours, increase temperature to 650°F for 6 hours.

Transducer postcure for 600° to 700°F applications
Cure and additional 18 to 24 hours at 25°F above the max operating temperature either before or after wiring is completed. Lack of complete coverage of silicone varnish at this temperature will decrease life of gages unless gage atmosphere contains only inert gases.

Installation Accessories

For proper results, the procedures and techniques presented in this bulletin should be used with qualified Vishay Micro-Measurements installation accessory products. M-LINE accessories used in this procedure are:

- CSM Degreaser or GC-6 Isopropyl Alcohol
- Silicon Carbide Paper (SCP-1, SCP-2, SCP-3)
- M-Prep Conditioner A
- M-Prep Neutralizer 5A
- GSP-1 Gauze Sponges
- CSP-1 Cotton Applicators
- MJG-2 Mylar Tape
- GT-14 Pressure Pads and Backup Plates
- HSC-1, HSC-2, HSC-3 Spring Clamps

Handling Precautions

While this material is considered relatively safe to handle, contact with skin and inhalation of vapors should be avoided. Immediate washing with ordinary soap and water is effective in cleansing should skin contact occur. For eye contact, rinse thoroughly with a copious amount of water and consult a physician. For additional health and safety information, consult the Material Safety Data Sheet, which is available upon request.

Mixing Adhesive

This adhesive is a single-component epoxy and no mixing is required.

Installation Procedure

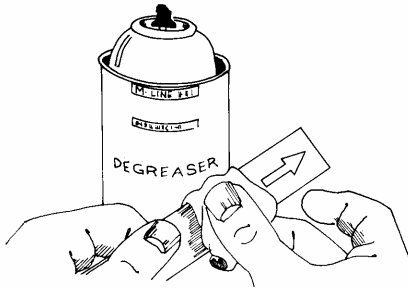
The installation procedure presented here is somewhat abbreviated and is intended only as a guide in achieving proper gage installation with P-Adhesive. Vishay Micro-Measurements Instruction Bulletin B-129, "Surface Preparation for Strain Gage Bonding", presents recommended procedures for surface preparation, and lists specific considerations that are helpful when working with most common structural materials.



Instruction Bulletin B-181

Vishay Micro-Measurements

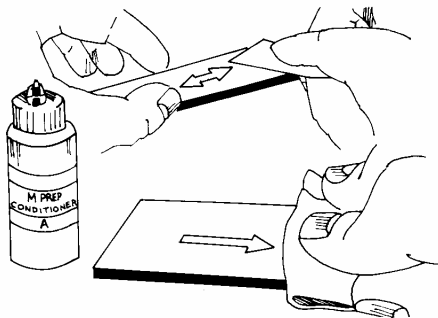
Step 1



The surface preparation technique used is the same basic cleaning procedure described in Vishay Micro-Measurements Instruction Bulletin B-129, "Surface Preparation for Strain Gage Bonding". The initial step is to thoroughly degrease with solvents such as CSM Degreaser or GC-6 Isopropyl Alcohol. CSM Degreaser is preferred whenever possible since this is a very active degreaser. The substitution of GC-6 as a degreasing agent should be considered for materials that may be sensitive to strong solvents.

Any degreasing should be done with clean solvents. Thus the use of a "one-way" container, such as the aerosol can, is highly advisable.

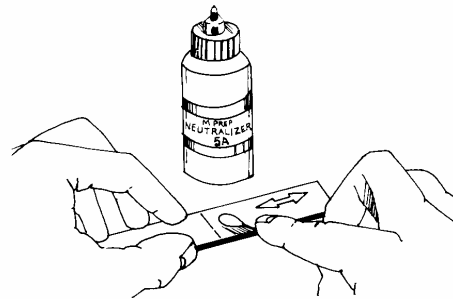
Step 2



Dry-abrade the gaging area with 220- or 320-grit silicon-carbide paper to remove any scale or oxides on the base material. Apply M-Prep Conditioner A and wet-abrade the gage area. Keep the surface wet while abrading. Remove the residue and Conditioner by slowly wiping through the gaging area with a gauze sponge. The wet-abrade and wiping procedure should then be repeated with 220-, 320-, or 400-grit silicon-carbide paper, depending on the surface hardness of the test material (refer to Bulletin B-129, "Surface Preparation for Strain Gage Bonding").

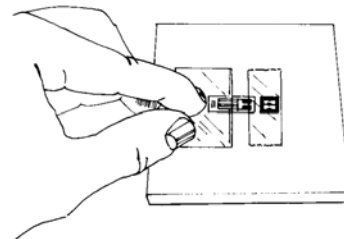
With a 4H (hard) drafting pencil on aluminum or a ball-point pen on steel, burnish whatever alignment marks are needed on the specimen. Rewet the surface with Conditioner A and scrub with cotton-tipped applicators until a clean applicator is no longer discolored by the scrubbing. Remove the residue and Conditioner by slowly wiping through the gaging area with a gauze sponge. Do not wipe back and forth over the gage area since this may allow contaminants to be re-deposited on the cleaned area.

Step 3



Apply a liberal amount of M-Prep Neutralizer 5A to the gage area. Keeping the surface wet, scrub with cotton-tipped applicators. Do not allow evaporation of the cleaning material on the specimen surface since this would leave a thin, unwanted film between the adhesive and the specimen. Remove the Neutralizer by slowly wiping through the gage area, allowing the gauze sponge to absorb the Neutralizer. Do not wipe back and forth over the gage area since this may allow contaminants to be re-deposited on the cleaned area.

Step 4



Remove a gage from its mylar envelope with tweezers, making certain not to touch any exposed foil. Place the gage, bonding side down, onto a chemically clean glass plate or empty

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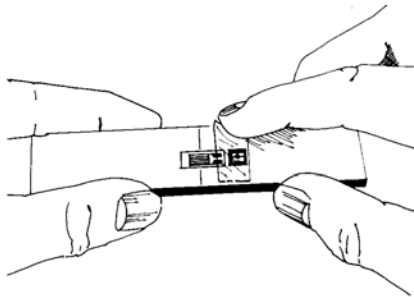


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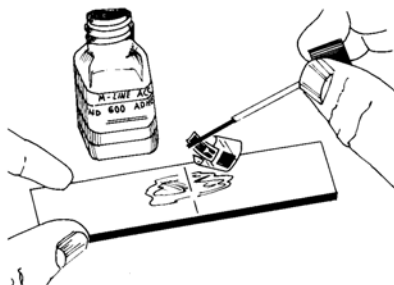
gage box. If a solder terminal is to be incorporated, position it next to the gage. While holding the gage in position with a mylar envelope, place a short length of MJG-2 mylar tape down over about half of the gage tabs and the entire terminals. Do not cover more than one edge of the strain gage with the MJG-2 tape in order to allow solvents a path to migrate from the adhesive layer during the elevated temperature cure cycle.

Step 5



Remove the gage/tape/terminal assembly by peeling the tape at a shallow angle (about 30°) and transferring it onto the specimen. Make sure gage alignment marks coincide with specimen layout lines. If misalignment does occur, lift end of tape at shallow angle until assembly is free. Realign and replace. Use of a pair of tweezers often facilitates this handling.

Step 6

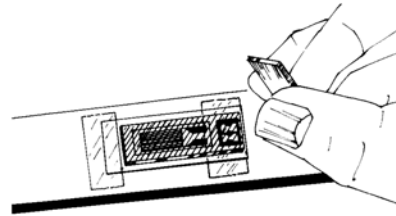


Now, by lifting at a shallow angle, peel back one end of the taped assembly so as to raise both gage and terminal. By curling this mylar tape back upon itself, it will remain in position, ready to be accurately repositioned after application of adhesive.

Apply a single, thin, even coat of P-Adhesive with the brush applicator to the prepared surface, gage backing and terminal. Do not allow the

adhesive applicator to touch the tape mastic. For two minutes, expose the two surfaces under an infrared lamp or other heat source until the materials are dry to the touch. Monitor the temperature of the surface and do not allow materials to exceed 250°F.

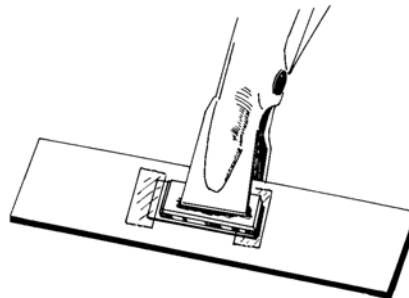
Step 7



Return gage/terminal assembly to its original position over layout marks. Use only enough pressure to allow assembly to be tacked down. Overlay gage/terminal area with a piece of thin TFE-1 teflon film. If necessary, anchor Teflon in position with a piece of mylar tape across one end.

Cut a 3/32-in (2.5- mm) thick GT-14 silicon gum pad and a metal backup plate to a size slightly larger than the gage/terminal areas, and carefully center these as shown below. Larger pads may restrict proper spreading of adhesive, and entrap residual solvents during cure process.

Step 8



Either HSC spring clamps, as shown here, or dead weight can be used to apply pressure during the curing cycle. The clamping pressure should be 20 to 40 psi (140 to 280 kN/m²) is recommended. Place clamped gage/specimen into a cool oven and raise temperature to the initial cure temperature at a rate of 5° to 20° F (3° to 11° C) per minute. Air bubbles trapped in the adhesive, uneven glue lines, and high adhesive film stresses often result from starting with a hot oven. The recommended cure for this adhesive

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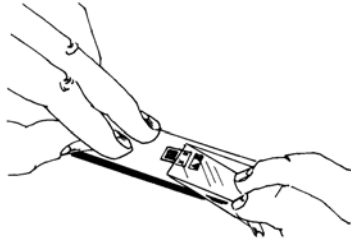
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is 250°F for 2 hours, increase temperature to 300°F for 2 hours, increase temperature to 340°F for 2 hours, and increase temperature to 380°F for 4 hours.

Step 9

Upon completion of the curing cycle, allow oven temperature to drop at least 100° F (55° C) before removing specimen. Remove clamping pieces and mylar tape. It is advisable to wash off the entire gage area with either RSK Rosin Solvent or toluene. This should remove all residual mastic and other contamination. Blot dry with a GSP-1 gauze sponge

Step 10



The gage and terminal strip are now solidly bonded in place. To remove the tape, pull it back directly over itself, peeling it slowly and steadily off the surfaces.

This technique will prevent possible lifting of the foil on open-faced gages or other damage to the installation. It is not necessary to remove the tape immediately after gage installation. The tape will offer mechanical protection for the grid surface and may be left in place until it is removed for gage wiring.

Postcure the strain gage installation as described in the "Characteristics" section of this bulletin.

Final Installation Procedure

Select appropriate solder and attach leadwires. Remove solder flux with RSK Rosin Solvent. Select and apply protective coating. Vishay Micro-Measurements gages have been treated for optimum bonding conditions and require no pre-cleaning before use unless contaminated during handling. If contaminated, the back of any gage may be cleaned with a CSP-1 Cotton Applicator slightly moistened with M-Prep Neutralizer 5A.

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