

Strain Gage Adhesive for Stress Analysis and Transducer Applications

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



RoHS
COMPLIANT

DESCRIPTION

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

CHARACTERISTICS	
PARAMETER	DETAILS
OPERATING TEMPERATURE RANGE	Short Term: -452° to +750°F (-269° to +400°C) Long Term: -452° to +500°F (-269° to +260°C)
ELONGATION CAPABILITIES	>5% at +75°F (+24°C).
SHELF LIFE	6 months at +75°F (+24°C)
POT LIFE	6 weeks at +75°F (+24°C)
CLAMPING PRESSURE	60 to 100 psi (4 to 6 bar)
CURE REQUIREMENTS*	<p>Step 1: Air dry at +75°F (+24°C) 10 to 30 min</p> <p>B-Stage: +225°F (+105°C) for 30 min</p> <p>Cure: +350°F (+175°C) for 1 hour</p> <p>Recommended Postcure for Stress Analysis: 1 hour at 50°F (30°C) above max operating temperature in 50°F (30°C) increments from +350°F (+175°C), dwelling 1 hour at each step.</p> <p>Recommended Postcure for Transducers: 1 hour at 50°F (30°C) above max operating temperature or cure temperature, whichever is higher.</p>

PACKAGING
KIT
4 bottles (12.7 g ea) Curing Agent 4 bottles (11.9 g ea) Resin 4 brush caps for applying adhesive 4 disposable mixing funnels

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

Reference: M-M Strain Gage Accessories databook.

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