

Strain Gage Adhesive for Stress Analysis and Transducer Applications

OTHER ACCESSORIES USED IN AN M-BOND 43-B 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 Tip Applicators
- MJG-2 Mylar® Tape
- TFE-1 Teflon® Film
- HSC Spring Clamp
- GT-14 Pressure Pads and Backup Plates



RoHS
COMPLIANT

DESCRIPTION

Single-component, solvent-thinned, epoxy adhesive normally used in transducer applications; solids content 25%. May be used both as an adhesive and as a

protective coating. Capable of forming very thin, hard, void-free gluelines similar to M-Bond 610. Highly resistant to moisture and chemical attack.

CHARACTERISTICS	
PARAMETER	DETAILS
OPERATING TEMPERATURE RANGE	Short Term: -452° to +350°F (-269° to +175°C) Long Term: -452° to +300°F (-269° to +150°C) Transducers: to +250°F (+120°C).
ELONGATION CAPABILITIES	1% at -452°F (-269°C), 4% at +75°F (+24°C), 2% at +300°F (+150°C).
SHELF LIFE	13 months from the date of manufacture on the label (minimum published 9 months) when stored unmixed at +75°F (+24°C); or 22 months from the date of manufacture on the label (minimum published 18 months) when stored unmixed refrigerated upon receipt at +40°F (+5°C). Refer to product label.
POT LIFE	Minimum 9 months at +75°F (+24°C); or 18 months at +40°F (+5°C).
CLAMPING PRESSURE	For Stress Analysis: 15 to 100 psi (100 to 700 kN/m ²). Optimum: 40 to 50 psi (275 to 350 kN/m ²). For Transducers: 45 to 60 psi (315 to 415 kN/m ²). Optimum: 50 psi (350 kN/m ²).
CURE REQUIREMENTS*	2 hours at +375°F (+190°C), or as an alternate cure for aluminum alloy transducers, 2-1/2 hours at +300°F (+150°C). Recommended Postcure: 2 hours at +400°F (+205°C), or as an alternate postcure for aluminum alloy transducer applications, 2-1/2 hours at +350°F (+175°C).

PACKAGING	
KIT	SINGLE BOTTLE
4 brush-cap bottles (30 ml ea) premixed adhesive	1 brush-cap bottle (30 ml ea) premixed adhesive

* **Reference:** 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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