

Strain Gage Adhesive

OTHER ACCESSORIES USED IN AN M-BOND AE-10 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
- PCT-2M Gage Installation Tape
- HSC Spring Clamp
- GT-14 Pressure Pads and Backup Plates



DESCRIPTION

Two-component, 100%-solids epoxy system for generalpurpose stress analysis. Transparent, medium viscosity. Cure time as low as six hours at +75°F (+24°C) may be used. Elevated-temperature postcure is recommended for maximum stability, and/or tests above room temperature.

Highly resistant to moisture and most chemicals, particularly when postcured. For maximum elongation, bonding surface must be roughened. Cryogenic applications require very thin gluelines.

CHARACTERISTICS																									
PARAMETER	DETAILS																								
OPERATING TEMPERATURE RANGE	Long Term: -320° to +400°F (-195° to +204°C)																								
ELONGATION CAPABILITIES	1% at -320° (-195°C), 6% to 10% at +75°F (+24°C), 15% at +200°F (+95°C).																								
SHELF LIFE	Minimum 12 months at +75°F (+24°C); or 18 months at +40°F (+5°C). If crystals form in resin jar, heat to +120°F (+50°C) for 30 minutes. Cool before mixing. Refer to product label for most recent information.																								
POT LIFE	15 to 20 minutes at +75°F (+24°C). Can be extended by cooling jar or by spreading adhesive on clean aluminum plate.																								
CLAMPING PRESSURE	5 to 20 psi (35 to 140 kN/m ²).																								
CURE REQUIREMENTS*	<p>Preferred Room-Temperature Cure: 24 to 48 hours at +75°F (+24°C).</p> <p>Recommended Postcure: 2 hours at 25°F (15°C) above maximum operating temperature.</p> <table border="1"> <caption>Cure Time vs. Temperature</caption> <thead> <tr> <th>Glueline Temperature (°C)</th> <th>Glueline Temperature (°F)</th> <th>Cure Time (Hours)</th> </tr> </thead> <tbody> <tr><td>25</td><td>77</td><td>6</td></tr> <tr><td>50</td><td>122</td><td>4</td></tr> <tr><td>75</td><td>167</td><td>3</td></tr> <tr><td>100</td><td>212</td><td>2</td></tr> <tr><td>125</td><td>257</td><td>1.5</td></tr> <tr><td>150</td><td>302</td><td>1</td></tr> <tr><td>175</td><td>347</td><td>0.8</td></tr> </tbody> </table>	Glueline Temperature (°C)	Glueline Temperature (°F)	Cure Time (Hours)	25	77	6	50	122	4	75	167	3	100	212	2	125	257	1.5	150	302	1	175	347	0.8
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PACKAGING	
KIT	BULK
6 mixing jars (10 g ea) Resin 1 bottle (15 ml) Curing Agent 10 6 calibrated pipettes 6 stirring rods	200 g Resin 40 g Curing Agent 10 3 calibrated pipettes

* **Reference:** Instruction Bulletin B-137, "Strain Gage Applications with M-Bond AE-10, AE-15, and GA-2 Adhesive Systems", included in each kit.

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