

Strain Gage Adhesive

OTHER ACCESSORIES USED IN AN M-BOND AE-15 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 +125°F (+50°C). Recommended for more critical applications, including transducers. It has a longer pot life than M-Bond AE-10 which allows more time for multiple gage installations.

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: -452° to +200°F (-269° to +95°C). Transducers: to +175°F (+80°C).
ELONGATION CAPABILITIES	2% at -320° (-195°C), 10% to 15% 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	1-1/2 hours at +75°F (+24°C).
CLAMPING PRESSURE	5 to 20 psi (35 to 140 kN/m ²).
CURE REQUIREMENTS*	<p>Recommended Postcure: 2 hours at 25°F (15°C) above maximum operating temperature.</p> <p>Optimum Performance Transducer Postcure: 1 hour at +200°F (+95°C).</p>

PACKAGING	
KIT	BULK
6 mixing jars (10 g ea) Resin 1 bottle (15 ml) Curing Agent 15 6 calibrated pipettes 6 stirring rods	200 g Resin 25 g Curing Agent 10 3 calibrated pipettes

* **References:** 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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