

## Strain Gage Adhesive

### OTHER ACCESSORIES USED IN AN P ADHESIVE INSTALLATION:

- CSM Degreaser or GC-6 Isopropyl Alcohol
- Silicon-Carbide Paper
- M-Prep Conditioner A
- M-Prep Neutralizer 5A
- CSP-1 Cotton Tip Swabs
- GSP-1 Gauze Sponges
- MJG-2 Mylar® Tape
- TFE-1 Teflon® Film
- HSC Spring Clamp
- GT-14 Pressure Pads and Backup Plates



**RoHS**  
COMPLIANT

### DESCRIPTION

Single-part, solvent-thinned, polyimide adhesive. Results in a strong, thin, near-creep-free, adhesive layer.

CHARACTERISTICS	
PARAMETER	DETAILS
OPERATING TEMPERATURE RANGE	-452° to +700°F (-270° to +370°C). <b>Upper Limit:</b> +800°F (+427°C) for 1 to 2 hours.
ELONGATION CAPABILITIES	2% at +75°F (+24°C).
SHELF LIFE	Minimum 4 months at +75°F (+24°C). Refer to product label for most recent information.
POT LIFE	Minimum 4 months at +75°F (+24°C).
CLAMPING PRESSURE	20 to 40 psi (140 to 280 kN/m <sup>2</sup> ).
CURE REQUIREMENTS*	For two minutes, expose the adhesive on the strain gage and test article to an infrared lamp or other heat source until the materials are dry.  Monitor the temperature of the surface and do not allow materials to exceed +250°F (+120°C).  After clamping, cure 2 hours at +250°F (+120°C), increase temperature to +300°F (+150°C) for 2 hours, increase temperature to +340°F (+170°C) for 2 hours and finish cure with 4 hours at +380°F (+195°C).  <b>Recommended Postcure (Unclamped):</b> 1 hour at +300°F (+150°C), followed by 2 hours at +400°F (+205°C), and then 4 hours at +500°F (+260°C).

PACKAGING
<b>KIT</b>
1 brush-cap bottle [1 oz (30 ml)]

\* **Reference:** Instruction Bulletin B-181 for complete details.

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