

Strain Gage Adhesive

OTHER ACCESSORIES USED IN AN M-BOND GA-2 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-3M Gage Installation Tape
- HSC Spring Clamp
- GT-14 Pressure Pads and Backup Plates



DESCRIPTION

Two-component, partially filled, 100%-solids epoxy system for general-purpose stress analysis. Higher viscosity than AE systems. Elevated-temperature cure recommended for best performance and resistance to

chemical attack. Often used to fill irregular surfaces. Uneven gluelines easily detectable by nonuniformity of bond color.

CHARACTERISTICS																									
PARAMETER	DETAILS																								
OPERATING TEMPERATURE RANGE	Long Term: -320° to +200°F (-195° to +95°C)																								
ELONGATION CAPABILITIES	4% at -320°F (-195°C), 10% to 15% at +75°F (+24°C) after 40-hr RT cure or 6-hr RT cure with postcure.																								
SHELF LIFE	Minimum 12 months at +75°F (+24°C); or 18 months at +40°F (+5°C). Refer to product label for most recent information.																								
POT LIFE	15 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/m²). The black filler provides a visual indication of nonuniform bond areas caused by uneven clamping pressure.																								
CURE REQUIREMENTS*	<p>Preferred Room Temperature Cure: 40 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>Graph Data: Time in Hours vs. Glueline Temperature</caption> <thead> <tr> <th>Glueline Temperature (°C)</th> <th>Glueline Temperature (°F)</th> <th>Time in Hours</th> </tr> </thead> <tbody> <tr><td>25</td><td>75</td><td>5.0</td></tr> <tr><td>50</td><td>125</td><td>3.5</td></tr> <tr><td>75</td><td>175</td><td>2.5</td></tr> <tr><td>100</td><td>225</td><td>1.8</td></tr> <tr><td>125</td><td>275</td><td>1.2</td></tr> <tr><td>150</td><td>325</td><td>0.8</td></tr> <tr><td>175</td><td>375</td><td>0.5</td></tr> </tbody> </table>	Glueline Temperature (°C)	Glueline Temperature (°F)	Time in Hours	25	75	5.0	50	125	3.5	75	175	2.5	100	225	1.8	125	275	1.2	150	325	0.8	175	375	0.5
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PACKAGING
KIT
6 mixing jars (15 g ea) Resin, 6 calibrated pipettes, 1 bottle (15 ml) Curing Agent 10-A, 6 stirring rods

* **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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