

## Strain Gage Adhesive

### OTHER ACCESSORIES USED IN AN M-BOND 200 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 Applicators
- PCT-3M Gage Installation Tape



### DESCRIPTION

For routine experimental stress analysis applications under temperate environmental conditions, M-Bond 200 adhesive is ordinarily the best choice. This adhesive is very easy to handle, and cures almost instantly to produce an essentially creep-free, fatigue-resistant bond, with elongation capability of five percent or more.

M-Bond 200 is a cyanoacrylate that has been pretested and certified for use in bonding strain gages. It is an excellent general-purpose adhesive for laboratory and short-term field applications. The procedure for making a strain gage installation with M-Bond 200 is illustrated and described in detail in Instruction Bulletin B-127 included in each kit of adhesive.

The user should note that the performance of the adhesive can be degraded by the effects of time, humidity conditions, elevated temperature, and moisture absorption. Because of the latter effect, strain gage installations should always be covered with a suitable protective coating. When necessitated by more rigorous test requirements and/or environmental conditions, consideration should be given to one of the M-Bond epoxy adhesives, using the “Recommended Adhesives/Strain Gage Series” chart.

CHARACTERISTICS			
PARAMETER	DETAILS		
<b>CURE REQUIREMENTS*</b>	One-minute thumb pressure, followed by a minimum two-minute delay before tape removal. Bond strength increases rapidly during first five minutes. Cure time must be extended under conditions of low temperature [ $<70^{\circ}\text{F}$ ( $<21^{\circ}\text{C}$ )] or low humidity ( $<40\%$ RH).		
<b>OPERATING TEMPERATURE RANGE</b>	<table border="0"> <tr> <td style="text-align: center;"><b>Short Term:</b> -300° to +200°F (-185° to +95°C).</td> <td style="text-align: center;"><b>Long Term:</b> -25° to +150°F (-32° to +65°C).</td> </tr> </table>	<b>Short Term:</b> -300° to +200°F (-185° to +95°C).	<b>Long Term:</b> -25° to +150°F (-32° to +65°C).
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<b>ELONGATION CAPABILITIES</b>	>5% at +75°F (+24°C), 3% at +75°F (+24°C) when used with CEA or EA/Option E strain gages.		
<b>SHELF LIFE</b>	<p>Minimum 12 months when stored unopened at +40°F (+5°C) or minimum 9 months when stored unopened at +75°F (+24°C).</p> <p><i>Note:</i> To ensure a proper seal, wipe bottle spout clean and dry before replacing cap.</p> <p><i>Note:</i> Condensation rapidly degrades adhesive performance and shelf life; if refrigerated, allow adhesive to reach room-temperature before opening. Refrigeration after opening is not recommended.</p>		
<b>POT LIFE</b>	Maximum 3 months at +75°F (+24°C) (not to exceed date of expiration) after opening. Replace the cap immediately after each use.		

PACKAGING OPTIONS	
KIT	BULK
1 bottle (1 oz/28 g) Adhesive 1 brush-cap bottle (30 ml) Catalyst	1 bottle (1 oz/28 g) Adhesive 5 tubes (2 g each) Adhesive 16 bottles (1 oz/28 g each) Adhesive 12 brush-cap bottles (30 ml each) Catalyst

\*Reference: Instruction Bulletin B-127 for complete details.

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