



M-Bond 610 is a two component system and must be mixed as follows:

- 1) *Resin and curing agent bottles must be at room temperature* before opening!
- 2) Using the disposable plastic funnel, empty contents of bottle labeled "curing Agent" into bottle labeled "Adhesive". Discard funnel when finished.
- 3) After tightening the brush applicator cap (included separately), thoroughly mix the contents of this "Adhesive" bottle by vigorously shaking it for 10 seconds.
- 4) Mark bottle with date mixed in space provided on the label.
- 5) Allow this freshly mixed adhesive to stand for at least one hour before using.

Operating Temperature Range:

Short Term: -452° to +700°F [-269° to +370°C].

Long Term: -452° to +500°F [-269° to +260°C].

Transducers: to +450°F [+230°C].

Elongation Capabilities:

1% at -452°F [-269°C];

3% at +75°F [+24°C];

3% at +500°F [+260°C].

Shelf Life:

9 months at +75°F [+24°C]; 15 months at +40°F [+5°C].

Pot Life:

6 weeks at +75°F [+24°C]; 12 weeks at +40°F [+5°C].

Clamping Pressure:

10 to 70psi [70 to 480kN/m²]

30 to 40psi optimum [200 to 275kN/m²]

Cure Requirements:

Recommended Postcure: 2 hours at 50° to 75°F [30° to 40°C] above maximum operating temperature or cure temperature, whichever is higher

High Precision Transducer Postcure: 2 hours at +400° to +450°F [+205° to +230°C] after wiring

We realize that sometimes for these non-strain gage applications, information such as thermal coefficient of expansion or electrical resistivity would be useful. But, such information is not needed for the application that M-Bond 610 was originally developed, and such data does not exist so far as we know.