**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°F to +700°F [-269°C to +370°C].
*Long Term:* -452°F to +500°F [-269°C 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.