



## Short Description

**H-611** adhesive is a room temperature curing adhesive made of new glycidyl epoxy resin, bisphenol A epoxy resin, low molecular polysulfide rubber and modified amine curing agent. It has good adhesive properties, two-component, solvent-free, can be cured at room temperature and with normal pressure. Its creep is small and has high insulation properties.

## Application Scope

**H-611** adhesive is suitable for most of our strain gages, and especially for compensation resistors, terminals and stress analysis at normal temperature and normal pressure. It provides convenience for bonding on large and complex specimens which are difficult to heat and cure.

## Technical Specifications H-611



Creep		small	
Viscosity		high	
Bottle Content (per component)	g	Component A: 8	Component B: 2
Clamping Pressure	MPa	0.1 to 0.3 (15 ~ 45 psi)	
Mix Ratio	A : B	4 : 1	
Curing Time		24 hours @ 20°C or 2 hours @ 80°C	
Operating Temperature	°C	-30 to +60	
Storage Life Single Component	Months / °C	10 / +20 ~ +25	
Storage Life after Mixing	Minutes / °C	10 (in summer), 30 (in winter)	

## How To Use

**Note:** Make sure to read the instructions in the Caution chapter carefully on the next page before use.

1. Compare the mass ratio of components **A : B = 4 : 1** mix and shake well.  
Treat the surface of the test piece to be laminated and clean it with a cleaning solvent.
2. Use the positioning tool to position the test points. Prepare PTFE film, special glue pen, special tweezers and resistance strain gauge to be affixed.
3. Heat the test piece to 40°C ~ 60°C, and apply a thin layer of **H-611** as primer on the part of the test piece to be bonded while it is hot (if the primer cannot be heated, the waiting time for pasting needs to be extended).
4. Use special tweezers to bond the strain gauge on the test point, cover with PTFE film, and squeeze out air bubbles and excess glue with your fingers along the axis of the strain gauge.
5. Testing can be done after curing at room temperature for 24 hours, or after curing at 80°C for 2 hours.

## Notes on Storage and Mix Temperatures

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**H-611** adhesive is available in two components, A and B.

Generally speaking, the mixed adhesive solution should be used up within 30 minutes in winter, and the mixed adhesive solution should be used up within 10 minutes in summer.

The storage period of **H-611** adhesive A and B single component at room temperature is 10 months.

## Caution

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1. Remove the bottle from the refrigerator at least 2 hours before use, and open the cap only after the temperature of the glue itself is balanced with the outside temperature.
2. When preparing the glue, component B should be completely poured into component A (if it is not poured completely, it will cause imbalance in the ratio and affect the adhesive force), and by using toothpick stirring to make component A and B fully mixed to ensure the uniformity of the glue.
3. Due to the short application period of amine curing agents, the mixed glue must be used within 1 hour, otherwise it will produce gel phenomenon; if the amount of one time use is small, according to the amount of use of A:B = 4:1 ratio of mixing.
4. During use, the glue bottle should be kept away from heat sources to avoid shortening the pot life of the glue under the action of higher temperatures.
5. Gluing tools should be cleaned after use, to avoid bringing in external impurities (such as cured glue particles, etc.) into the bottle and causing glue contamination.
6. **H-611** adhesive is suitable for use in an environment where the relative humidity is less than 60%.