



## H-619

### Main application

H-619 is a multi-purpose two-component epoxy based adhesive, designed for high precision gages and compensating resistors. It is highly recommended for high precision load cells (C4 class or higher) or when the accuracy of measurements is especially important.

### Polymerization

Thermal treatment.

### Content

Two-component, epoxy-based.

### Key features

wide temperature range, low viscosity, low hysteresis, low creep, good repeatability of the test data, simplicity of use, short application cycle.

### Operation temperature range

-269°C...+210°C.

### Shelf life

**Before mixing:** 6 months at 24°C; 12 months at 4...8°C.

**After mixing:** 7...10 days at 20...25°C; 25 days at 4...8°C.

### Mixing proportion

Component A :  
component B = 1:1.

### Bonding technology

- Press or clamp with 0.1...0.3MPa force.
- Heat up to 135°C with the speed not more than 2°C per minute, treat for 2 hours.
- Cool down to room temperature and release the clamp.
- Heat up to 165°C with the speed not more than 2°C per minute, treat for 2 hours.
- Cool down to room temperature and release the clamp.

### Packing

**1 kit** (1 bottle of component A, 7.5 g; 1 bottle of component B, 7.5 g) or 3 kits (three bottles of each component). Volume of the bottles is enough for mixing both components in any of them.