



HS-400



General information

HS-400 is a high performance one component phenolic-based adhesive. HS-400 is characterized by its low hysteresis, small creep, good repeatability and a wide working temperature range. The operating temperature for this adhesive is: for long term up to 350°C and short term – up to 400°C.

HS-400 is suitable for all strain gauges and compensation resistors.

The HS-400 adhesive has a storage life of 3 months at 20°C, 6 months at 5°C. Please note not to freeze the adhesive.

Main application

For up to 400°C temperature gauge bonding.

Surface and tools preparation requirements

- The surface where the gauge will be attached should be sand-blasted or sanded by sandpaper and cleaned well with acetone or butanone.
- Use ethyl alcohol to clean the tools, Teflon film and the strain gauge which will be bonded.

Strain gauge bonding

- Coat the area where the strain is going to be attached with HS-400 adhesive and apply the gauge immediately. The time between applying the adhesive and gauge bonding shouldn't exceed 2 minutes.
- Press the strain gauge with a pressure of about 0.8–2 bar.
- Dry in air for 1 hour.
- Heat-treat and remove the clamp.
- Curing in the furnace: heat to 65°C (1°C/min, hold 90 min) – heat to 180°C (1°C/min, hold 180 min) – cool, remove press – heat to 240°C (3°C/min, hold 180 min).

Storage conditions

At normal condition in the original packing, shelf life of the glue is 3 months. After opening of the bottle, shelf life is 1 month.

Precautions and recommendations

- Make sure to take the HS-400 adhesive out of the refrigerator 2 hours prior to using it and using it only when the liquid's temperature is the same as the environmental temperature.
- During usage, the adhesive bottle should be as far away from heat and light sources. This is due to the adhesive solvent reacting with higher temperature and light to volatize faster.
- When a bottle of adhesive is used up and the adhesive becomes thicker or little particles arise in the adhesive (caused by dust), the adhesive is not suitable for use of strain gauge bonding anymore. However, it is still fine to use for compensation resistors or terminal tab bonding.

Packing

1 bottle: 30ml/bottle

Shelf life

3 months after production;
1 month after opening.