



Designation: E2004 – 18

Standard Test Method for Facing Cleavage of Sandwich Panels¹

This standard is issued under the fixed designation E2004; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

This standard has been approved for use by agencies of the U.S. Department of Defense.

1. Scope

1.1 This test method covers the determination of the cleavage force to peel stiff facings from sandwich panels.

1.2 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.3 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

1.4 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 *ASTM Standards:*²

- D1781 Test Method for Climbing Drum Peel for Adhesives
- E4 Practices for Force Verification of Testing Machines
- E631 Terminology of Building Constructions
- E1749 Terminology Relating to Rigid Wall Relocatable Shelters

3. Terminology

3.1 *Definitions:*

3.1.1 For definitions of general terms related to building construction used in this test method, refer to Terminology

¹ This test method is under the jurisdiction of ASTM Committee E06 on Performance of Buildings and is the direct responsibility of Subcommittee E06.53 on Materials and Processes for Durable Rigidwall Relocatable Structures.

Current edition approved Oct. 1, 2018. Published November 2018. Originally approved in 1999. Last previous edition approved in 2010 as E2004–10. DOI: 10.1520/E2004–18.

² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

E631 and for general terms related to rigid wall relocatable shelters, refer to Terminology E1749.

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *adhesive failure*—failure that is completely within the adhesive layer with no evidence of interfacial disbonding between the core and the adhesive, between the adhesive and the facing, and no evidence of tearing or rupture within the core.

3.2.2 *bond failure*—failure that is interfacial and is either (a) between the adhesive and the core, or (b) between the adhesive and the facing; no core or adhesive failure will be in evidence in this type of failure.

3.2.2.1 *Discussion*—If bond failure occurs it should be specified as to whether it is type (a) or (b).

3.2.3 *core failure*—failure that is completely within the core material and is comprised of a tearing or rupture of the core material with no evidence of interfacial disbonding between the core and the adhesive, within the adhesive itself, or between the adhesive and the facing.

3.2.4 *mixed-mode failure*—failure that shows evidence of more than one of the three failure modes described above.

3.2.4.1 *Discussion*—Visually estimate and report the percent of the total failure surface area that is covered by each type of failure.

4. Significance and Use

4.1 This test method determines the cleavage force required to peel stiff facings from the core of sandwich panels, and is used to determine how well the facing is bonded to the core. Test Method D1781 only works well with flexible facings. As a guideline, the cleavage test method would work better on sandwich panels that have facings with a bending stiffness (EI) of greater than approximately 27.3 lb-in²/inch width (3.09 kN·mm²/mm width). This converts to approximately 0.032 in. (0.81 mm) 6061 T6 aluminum alloy, 0.023 in. (0.57 mm) steel, and 0.046 in. (1.18 mm) fiberglass facings.

5. Apparatus

5.1 *Test Machine*, capable of maintaining a controlled loading rate and indicating the load with an accuracy of $\pm 1\%$ of the indicated value. The accuracy of the test machine shall be verified in accordance with Practices E4.