



Designation: D 1184 – 98

## Standard Test Method for Flexural Strength of Adhesive Bonded Laminated Assemblies<sup>1</sup>

This standard is issued under the fixed designation D 1184; 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 reappraisal. A superscript epsilon ( $\epsilon$ ) indicates an editorial change since the last revision or reappraisal.

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

### INTRODUCTION

The accuracy of the results of strength tests of adhesive bonds will depend on the conditions under which the bonding process is carried out. Unless otherwise agreed upon by the manufacturer and the purchaser, the bonding conditions shall be prescribed by the manufacturer of the adhesive. In order to ensure that complete information is available to the individual conducting the tests, the manufacturer of the adhesive shall furnish numerical values and other specific information for each of the following variables:

(1) Procedure for preparation of surfaces prior to application of the adhesive, including the moisture content of wood, the cleaning and drying of metal surfaces, and special surface treatments such as sanding that are not specifically limited by the pertinent test method.

(2) Complete mixing directions for the adhesive.

(3) Conditions for application of the adhesive including the rate of spread of thickness of film, number of coats to be applied, whether to be applied to one or both surfaces, and the conditions of drying where more than one coat is required.

(4) Assembly conditions before application of pressure, including the room temperature, length of time, and whether open or closed assembly is to be used.

(5) Curing conditions, including the amount of pressure to be applied, the length of time under pressure, and the temperature of the assembly when under pressure. It should be stated whether this temperature is that of the glue line or of the atmosphere at which the assembly is to be maintained.

(6) Conditioning procedure before testing, unless a standard procedure is specified, including the length of time, temperature, and relative humidity.

A range may be prescribed for any variable by the manufacturer of the adhesive if it can be assumed by the test operator that any arbitrarily chosen value within such a range or any combination of such values for several variables will be acceptable to both the manufacturer and the purchaser of the adhesive.

### 1. Scope

1.1 This test method covers the determination of the comparative properties of either metal or wood adhesive bonded assemblies when subjected to flexural stresses with standard shape specimens and under defined conditions of pretreatment,

temperature, relative humidity, and testing technique. The test specimen and testing technique were designed to develop a large portion of shear forces between the laminae of the test piece when the load is applied, rather than to reduce shear stress to a minimum as is done in other ASTM test methods for flexural properties. This method is not applicable to assemblies made with nonrigid adherends. The data obtained are not suitable for design work.

1.2 The values stated in SI units are to be regarded as the standard. The values given in parentheses are for information purposes.

<sup>1</sup> This test method is under the jurisdiction of ASTM Committee D-14 on Adhesives and is the direct responsibility of Subcommittee D14.80 on Metal Bonding Adhesives.

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