



Designation: C 631 – 95a (Reapproved 2004)

Standard Specification for Bonding Compounds for Interior Gypsum Plastering¹

This standard is issued under the fixed designation C 631; 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.

1. Scope

1.1 This specification covers minimum requirements for bonding compounds for adhering interior gypsum plaster to structurally sound surfaces.

1.2 This specification also covers test methods for determining performance requirements and physical properties.

1.3 The values stated in inch-pound units are to be regarded as the standard. The SI equivalents of inch-pound units are approximate.

1.4 The following safety hazards caveat pertains only to the test methods described in this specification: *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 and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 *ASTM Standards:*²

C 11 Terminology Relating to Gypsum and Related Building Materials and Systems

C 28 Specification for Gypsum Plasters

C 472 Test Methods for Physical Testing of Gypsum, Gypsum Plasters, and Gypsum Concrete

C 511 Specification for Mixing Rooms, Moist Cabinets, Moist Rooms, and Water Storage Tanks Used in the Testing of Hydraulic Cements and Concretes

3. Terminology

3.1 *Definitions*—For definitions relating to gypsum and related building materials and systems, see Terminology C 11.

4. Physical Properties

4.1 *General*—The bonding compound shall be a film forming, non-oxidizing, non-toxic, non-flammable composition

suitable for application by brush, roller, and spray. The compound shall be tinted to show, by visual inspection, where it has been applied. The tinting material shall not show through the material being bonded. The surfaces to which bonding compounds are applied shall be relatively smooth, clean, and dry. Surface coatings shall be removed if their nature indicates an unsatisfactory condition. Surfaces shall be prepared in accordance with the manufacturer's directions.

4.2 *Consistency*—The bonding compound shall be of a homogeneous nature with no settling of the solids. The compound shall be free of foreign matter, and when applied in accordance with the manufacturer's directions, shall cover evenly.

4.3 *Film Characteristics*—A dry film of the bonding compound shall be uniform and smooth and shall remain flexible. The film shall not be noticeably affected by mild acid or alkali.

5. Performance Requirements

5.1 *Bonding Capability*—A dry film of bonding compound shall be capable of bonding gypsum plaster immediately after drying and 10 days after drying when tested as specified in Section 12.

5.2 *Degradation*—Bonding compound that separates shall be able to be re-mixed to a uniform consistency when tested as specified in Section 10.

5.3 *High Temperature Stability*—The bond strength shall be not less than 20 psi (138 kPa) when tested as specified in Section 9.

5.4 *Freeze-Thaw Stability*—The bond strength shall be not less than 20 psi (138 kPa) when tested as specified in Section 11.

5.5 *Bond Strength*—Bond strength of a fresh sample or a 30 day old sample shall be not less than 20 psi (138 kPa) when tested as specified in Section 12.

6. Sampling

6.1 Take a sample of not less than 1 kg from each shipment or consignment for analysis and tests. Except in special cases, take the sample from not less than three separate containers, chosen at random. In addition, take samples from containers that appear to be nonrepresentative, and test separately. Immediately place the samples in airtight glass containers and transport to the testing laboratory in these containers. Take precautions to reduce evaporation or drying to a minimum.

¹ This specification is under the jurisdiction of ASTM Committee C11 on Gypsum and Related Building Materials and Systems and is the direct responsibility of Subcommittee C11.02 on Specifications and Test Methods for Accessories and Related Products.

Current edition approved Oct. 10, 1995. Published December 1995. Originally approved in 1988. Last previous edition approved in 1995 as C 631 – 95.

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.

Thoroughly mix the bonding compound in the container if there is a tendency for liquid phase separation.

7. Apparatus

7.1 *Moist Cabinet*—Specification C 511.

7.2 *Oven*—A forced draft type oven, having a temperature controlled at 140 ± 5 °F (60 ± 3 °C) for high temperature tests and 100 ± 5 °F (38 ± 3 °C) for drying of the briquets.

7.3 *Freezer*—A freezer having a controlled temperature of -10 ± 2 °F (-23 ± 1 °C).

7.4 *Balance*—A balance capable of weighing at least 2500 g at a precision of 0.1 g.

7.5 *Timing Device*—A standard clock or watch with second hand.

7.6 *Tamper*—A tamper made up of a nonabsorptive, non-abrasive, non-brittle material and having a cross section of $\frac{1}{2}$ in. by 1 in. (13 by 25 mm) and approximately 5 to 6 in. (130 to 150 mm) long. The tamping face shall be flat and at right angles to the length of the tamper.

7.7 *Straight Edge*—A steel straight edge not less than 4 in. (100 mm) long and not less than $\frac{1}{16}$ in. (1.6 mm) nor more than $\frac{1}{8}$ in. (3.2 mm) in thickness.

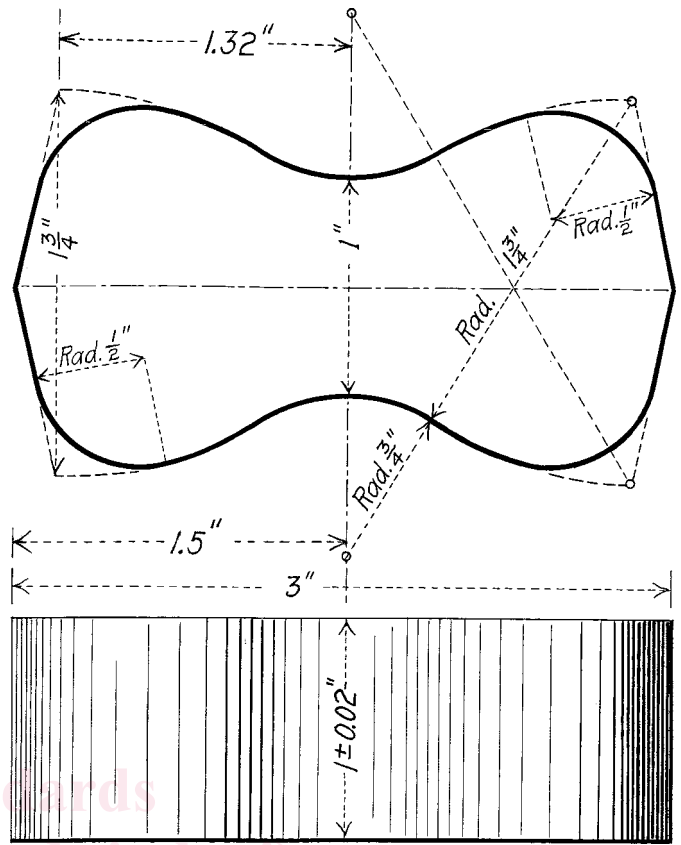
7.8 *Spatula*—A spatula with a metal blade 6 in. (150 mm) in length and $\frac{1}{2}$ in. (13 mm) in width, with straight edges.

7.9 *Paint Brush*—A standard 1 in. (25 mm) wide brush, with natural or synthetic bristles.

7.10 *Testing Machine*—Any type that is of sufficient capacity and that is capable of applying the load continuously and without shock at the rate of 0.05 in. (1.27 mm)/min, with provision for adjustment of the rate of loading.

7.11 *Briquet Molds*—The molds for making test specimens shall be made of metal not attacked by the plaster mortar and shall have sufficient material in the sides to prevent spreading during molding. Gang molds, when used, shall be of the type shown in Fig. 1. The dimensions of the briquet molds shall conform to the following requirements: width of mold, between inside faces, at waist line of the briquet, 1 in. (25.4 mm) with permissible variations of ± 0.01 in. (0.25 mm) for molds in use and ± 0.005 in. (0.13 mm) for new molds; thickness of molds measured at the point of greatest thickness on either side of the mold at the waist line, 1 in. (25.4 mm) with permissible variations of $+ 0.004$ in. (0.10 mm) and $- 0.002$ in. (0.05 mm) for new molds and $- 0.02$ in. (0.5 mm) for molds in use. The inside faces at the waist line shall have a vertical slot 0.03 in. (0.75 mm) wide by 0.06 in. (1.5 mm) deep to accept the divider. The briquet specimens shall conform to the dimensional requirements shown in Fig. 2.

7.12 *Divider*—Sheet brass 0.02 in. (0.05 mm) thick, 1.1 in. (27.8 mm) wide by 1 in. (25.4 mm) high.



NOTE 1—1 in. = 25.4 mm

FIG. 2 Briquet Specimen for Tensile Strength Test

7.13 *Clips for Briquet Testing Machine*— The clips for holding the tension test specimen shall be in accordance with Fig. 3.

8. Conditioning

8.1 *Room Temperature and Humidity*— Maintain the air temperature in the vicinity of the mixing and testing area, 70 ± 5 °F (21 ± 3 °C). Maintain the relative humidity at 50 ± 2 %.

8.2 *Temperature of the Mixing Water*— 72 ± 2 °F (22 ± 1 °C).

9. High Temperature Test

9.1 *Significance and Use*—This test method provides procedures for evaluating the bond strength of adhesives after being exposed to accelerated aging at high temperature.

9.2 *Specimen Preparation*—For each test specimen, transfer the bonding compound, taken from the sample obtained, into a standard 1 pt (400 mL) glass container.

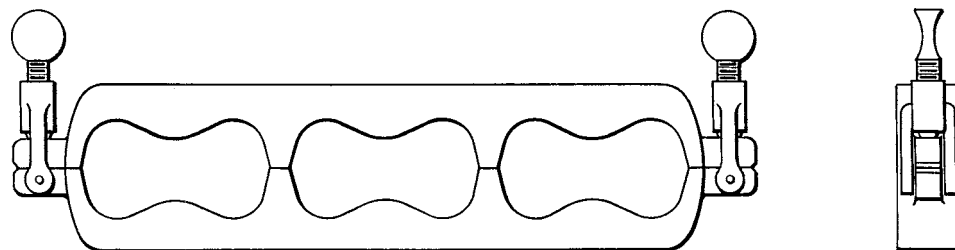


FIG. 1 Briquet Gang Mold