



Designation: E1801 – 09

Standard Practice for Adhesive Bonding of Aluminum Facings in Foam and Beam Type Shelters¹

This standard is issued under the fixed designation E1801; 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 Department of Defense.

1. Scope

1.1 This practice covers the materials, processes, and quality controls to be used in the manufacture of adhesive-bonded, aluminum-faced, foam core sandwich panels for tactical shelters.

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

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 and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 *ASTM Standards:*²

[B209 Specification for Aluminum and Aluminum-Alloy Sheet and Plate](#)

[E1730 Specification for Rigid Foam for Use in Structural Sandwich Panel Cores](#)

[E1749 Terminology Relating to Rigid Wall Relocatable Shelters](#)

[E1793 Practice for Preparation of Aluminum Alloy for Bonding in Foam and Beam Type Transportable Shelters](#)

[E1794 Specification for Adhesive for Bonding Foam Cored Sandwich Panels \(200°F Elevated Humidity Service\), Type II Panels](#)

[E1800 Specification for Adhesive for Bonding Foam Cored Sandwich Panels \(160°F Elevated Humidity Service\), Type I Panels](#)

¹ This practice 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.

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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.

2.2 *Federal Standard:*³

[QQ-A-250/11 Aluminum Alloy 6061-T6 Plate and Sheet](#)

3. Significance and Use

3.1 The formation of reproducible, durable adhesive bonds in structural units requires great care in the performance of the steps in the bonding process. Experience has shown that adhesive bonding carried out in accordance with this practice produces reproducible adhesive bonds. This practice is applicable to both the Type 1, 71°C (160°F), and Type 2, 93°C (200°F), elevated humidity service type of foam and beam shelter.

4. Facilities

4.1 *Panel Assembly Layup Area*—The panel assembly layup area shall be a ventilated area maintained at a minimum temperature of 20°C (68°F). The area shall be free of oils, grease, silicone, lint, or other contaminants detrimental to the production of adhesive bonds.

4.2 *Post-Curing Rooms*—The post-curing rooms shall provide a uniform temperature distribution over all panels and over all portions of the panels exposed for post-curing. The total temperature range shall be no more than 14°C (25°F).

5. Apparatus

5.1 *Pressure Equipment*—Pressure equipment for bonding of shelter panels shall be large enough to permit the bonding of a complete panel in one step. The manufacturer shall provide calibration and test data demonstrating that the temperature on the two facings of the press platens during bonding will be equal and uniform within $\pm 3^\circ\text{C}$ ($\pm 5^\circ\text{F}$) of the indicated temperature. The platens shall be flat to within 0.08 mm/305 mm (0.003 in./ft) and shall be smooth having a maximum surface roughness of 125 rms. The pressure equipment shall be equipped with temperature and pressure recorders and controls that accurately control heat-up, pressure applied, and dwell time.

³ Available from Standardization Documents Order Desk, DODSSP, Bldg. 4, Section D, 700 Robbins Ave., Philadelphia, PA 19111-5098, <http://dodssp.daps.dla.mil>.

5.2 *Calibrations, Temperature and Pressure Requirements, and Controls*—Gages shall be calibrated every 6 months by an accredited independent laboratory or by the panel manufacturer if approved by the purchaser. All calibrations shall be traceable to the National Institute of Standards and Technology. The latest calibration certificate shall be attached to the equipment near each gage. Thermocouples placed at each corner and at the center of each facing shall be used to demonstrate the uniformity of the temperature. A permanent record of the pressure, time, and temperature during bonding shall be maintained.

5.3 *Calibration of Testing Equipment*— Calibration of the required testing equipment shall be done in accordance with the equipment manufacturer's instructions. All calibrations of test equipment required by this practice shall be traceable to the National Institute of Standards and Technology.

6. Materials

6.1 The materials used in bonded panels shall meet the requirements of the contract or specified drawings. All materials shall be stored and handled in such manner so as to provide protection against degrading environments and mechanical damage.

6.2 Aluminum:

6.2.1 *Facings*—The facings shall be aluminum alloy conforming to Specification **B209** and shall be certified as complying with the alloy, temper, and thickness requirements of the shelter specification. Facings shall be free of corrosion, excessive oil canning (snap-buckling), dents, gouges, or other defects that may adversely affect the structural integrity of the bonded panel. Manufacturers' certification or reports of tests for mechanical properties and chemical composition shall be available or included with each shipment, or both.

6.2.2 *Preparation of Aluminum-Alloy Parts for Bonding:*

6.2.2.1 *Type 1, 71°C (160°F), Elevated Humidity Service Shelters*—The aluminum-alloy parts used in the manufacture of Type 1 foam and beam panels shall be prepared for bonding in accordance with Practice **E1793** and Specification **E1800**. The surface resistance of 6061-T6 aluminum alloy (QQ-A-250/11) test coupons cleaned by the same process, shall be no more than 100 microhms when measured under a nominal electrode force of 4.14 ± 1.70 MPa (600 ± 25 psi) and a current of 10 ± 0.2 amperes. Five coupons shall be tested during each 4 h of cleaning operations.

6.2.2.2 *Type 2, 93°C (200°F), Elevated Humidity Service Shelters*—The aluminum-alloy parts used in the manufacture of Type 2 foam and beam panels shall be prepared for bonding in accordance with Practice **E1793** and Specification **E1794**. The surface resistance of the cleaned parts, or test coupons of the same alloy and cleaned by the same process, shall be no more than 100 microhms when measured under a nominal electrode force of 4.14 ± 1.7 MPa (600 ± 25 psi) and a current of 10 ± 0.2 amperes. Five coupons shall be tested during each 4 h of cleaning operations.

6.3 *Foam Core*—The foam core material shall be as specified in the shelter specification and shall meet the requirements of Specification **E1730**. Manufacturers' certification or reports of tests for conformance to this specification shall be available or included with each shipment, or both.

6.4 *Adhesives*—The adhesive shall conform to Specification **E1800** for Type 1 shelters or Specification **E1794** for Type 2 shelters. The adhesive shall be stored and used in accordance with the manufacturer's recommendations. Manufacturers' certification or reports of tests for conformance to this specification shall be available or included with each shipment, or both.

6.5 *Preparation of Nonmetallic Parts Prior to Bonding*—If necessary, all plastic, wood, and foam parts used in the construction of these shelters shall be prepared for bonding prior to the application of the adhesive. Parts with gouges, broken edges, splits or cracks, or other defects shall not be used.

7. Bonding and Curing

7.1 *Preparation of Materials Bonding*— All cutting, trimming, and sizing of aluminum, plastic, and wood parts shall be made prior to surface preparation or on the panel following completion of the bonding operation. The faying surfaces of aluminum parts to be bonded shall be prepared as designated in **7.2.2**. All prepared aluminum for bonded panels shall be stored to prevent contamination of the bonding surface. Prepared parts that are not bonded within 72 h after cleaning shall be reprocessed as designated in **7.2**. The faying surfaces of plastic and foam and wood parts to be bonded shall be as designated in **7.5** and **7.6** respectively. All material prepared for bonding shall be handled with clean cotton gloves to prevent contamination of surfaces prior to bonding.

7.1.1 *Adhesive Application*—Adhesive shall be applied uniformly on all faying surfaces of the parts being bonded. It shall be applied in such a manner and in sufficient quantity to fill all voids between faying surfaces and to ensure a continuous bond between parts as evidenced by adhesive flash (squeeze-out) at the edges when the parts are cured.

7.2 *Assembly of Panels:*

7.2.1 *Type 1 Panels*—No more than 75 min at 25°C (77°F) (45 min at 38°C (100°F)) shall elapse between the first application of adhesive to the panel and the application of pressure to that panel.

7.2.2 *Type 2 Panels*—No more than 2 h at 25°C (77°F) (45 min at 38°C (100°F)) shall elapse between the application of adhesive to the panel and the application of pressure to that panel.

7.3 *Cure of Bonded Panels:*

7.3.1 *Type 1 Panels*—Panels shall be cured at a temperature of not less than 52°C (125°F) for 4 h or at a temperature of 63°C (145 ± 5 °F) for not less than 1 h. Timing of the cure shall not start until the panel skins have reached the specified temperature. Either cure shall be under a pressure of 0.05 ± 0.007 MPa (8.0 ± 0.5 psi). The temperature for either cure shall be fully attained within 2 h after the application of adhesive.

7.3.2 *Type 2 Panels*—Panels shall be cured at a temperature of not less than 93°C (200°F) for 90 min or at a temperature of 107°C (225°F) for 60 min. Timing of cure shall not start until the panel skins have reached the specified temperature. Either cure shall be under a pressure of 0.05 ± 0.007 MPa (8.0 ± 0.5