



Designation: **D1338 – 99 (Reapproved 2011) D1338 – 99 (Reapproved 2016)**

Standard Practice for Working Life of Liquid or Paste Adhesives by Consistency and Bond Strength¹

This standard is issued under the fixed designation D1338; 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 practice covers two procedures applicable to all adhesives having a relatively short working life. It is intended to determine whether the working life conforms to the minimum specified working life of an adhesive required by consistency tests or by bond strength tests, or by both.

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

D897 Test Method for Tensile Properties of Adhesive Bonds

D906 Test Method for Strength Properties of Adhesives in Plywood Type Construction in Shear by Tension Loading

D907 Terminology of Adhesives

D1002 Test Method for Apparent Shear Strength of Single-Lap-Joint Adhesively Bonded Metal Specimens by Tension Loading (Metal-to-Metal)

D1084 Test Methods for Viscosity of Adhesives

3. Terminology

3.1 *Definitions*—Many terms in this practice are defined in Terminology D907.

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *working life of an adhesive, n*—the time elapsing between the moment an adhesive is ready for use and the time when the adhesive is no longer usable.

4. Significance and Use

4.1 To determine acceptable working life of an adhesive, two procedures are used. This practice is intended to apply to:

4.1.1 Self-contained liquid or paste adhesives,

4.1.2 Adhesives requiring addition of a catalyst, hardener, filler, thinner, and so forth, or combinations of two or more of these materials just prior to use, and

4.1.3 Powdered or flaked adhesives which are dissolved in water or other solvent and are used as liquid or paste adhesives.

CONSISTENCY PROCEDURE

5. Apparatus

5.1 *Viscometer*—Any means of measuring the viscosity or consistency of the adhesive can be selected, provided that it is suitable for the type of adhesive under test and provided that the results can be expressed in fundamental units.

¹ This practice is under the jurisdiction of ASTM Committee D14 on Adhesives and is the direct responsibility of Subcommittee D14.10 on Working Properties. Current edition approved Dec. 1, 2011; May 1, 2016. Published December 2011; May 2016. Originally approved in 1954. Last previous edition approved in 2005 (2011) as D1338 – 99 (2005) (2011). DOI: 10.1520/D1338-99R11; 10.1520/D1338-99R16.

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.