

---

---

**Adhesives — Determination of the  
bond strength of engineering-plastic  
joints**

*Adhésifs — Détermination de la résistance de joints collés des  
plastiques industriels*

**iTeh Standards**  
**(<https://standards.itih.ai>)**  
**Document Preview**

[ISO 15509:2019](https://standards.itih.ai/catalog/standards/iso/b455cec9-2bd6-4f6a-af1e-017c4ae8b3a3/iso-15509-2019)

<https://standards.itih.ai/catalog/standards/iso/b455cec9-2bd6-4f6a-af1e-017c4ae8b3a3/iso-15509-2019>



**iTeh Standards**  
**(<https://standards.iteh.ai>)**  
**Document Preview**

[ISO 15509:2019](https://standards.iteh.ai/catalog/standards/iso/b455cec9-2bd6-4f6a-af1e-017c4ae8b3a3/iso-15509-2019)

<https://standards.iteh.ai/catalog/standards/iso/b455cec9-2bd6-4f6a-af1e-017c4ae8b3a3/iso-15509-2019>



**COPYRIGHT PROTECTED DOCUMENT**

© ISO 2019

All rights reserved. Unless otherwise specified, or required in the context of its implementation, no part of this publication may be reproduced or utilized otherwise in any form or by any means, electronic or mechanical, including photocopying, or posting on the internet or an intranet, without prior written permission. Permission can be requested from either ISO at the address below or ISO's member body in the country of the requester.

ISO copyright office  
CP 401 • Ch. de Blandonnet 8  
CH-1214 Vernier, Geneva  
Phone: +41 22 749 01 11  
Fax: +41 22 749 09 47  
Email: [copyright@iso.org](mailto:copyright@iso.org)  
Website: [www.iso.org](http://www.iso.org)

Published in Switzerland

# Contents

	Page
Foreword.....	iv
Introduction.....	v
<b>1 Scope</b> .....	<b>1</b>
<b>2 Normative references</b> .....	<b>1</b>
<b>3 Terms and definitions</b> .....	<b>1</b>
<b>4 Principle</b> .....	<b>1</b>
<b>5 Specimen</b> .....	<b>2</b>
5.1 Preparation.....	2
5.1.1 General.....	2
5.1.2 Mould.....	2
5.1.3 Injection-moulding parameters.....	3
5.1.4 Removal of the sprue.....	3
5.1.5 Geometry.....	3
5.2 Surface preparation.....	3
5.3 Assembly of the specimen in the mounting jig.....	4
5.4 Application of the adhesive.....	5
5.5 Conditioning and testing atmosphere.....	5
<b>6 Apparatus</b> .....	<b>5</b>
<b>7 Procedure</b> .....	<b>5</b>
<b>8 Expression of results</b> .....	<b>8</b>
<b>9 Precision</b> .....	<b>8</b>
<b>10 Test report</b> .....	<b>8</b>

ISO 15509:2019

<https://standards.iteh.ai/catalog/standards/iso/b455cec9-2bd6-4f6a-af1e-017c4ae8b3a3/iso-15509-2019>