



Adhesive Technology: Surface Preparation Techniques on Aluminum

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Henkel-Loctite

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Table of Contents

Table of Contents.....	2
List of Figures.....	6
List of Tables	8
List of Tables	8
Acknowledgements.....	9
Abstract.....	10
Executive Summary	11
Introduction.....	16
1.0 Literature Review.....	20
1.1 History of Adhesives.....	21
1.1.1 Importance of Adhesives in Industry Today.....	22
1.2 Surface Preparation Techniques.....	24
1.2.1 Chromic Acid Etch	25
1.2.2 Sulfuric Acid Anodizing and “Hard” Anodizing.....	27
1.2.3 Phosphoric Acid Anodizing.....	28
1.2.4 Chromic Acid Anodizing.....	29
1.3 Adhesive Chemistry	30
1.3.1 Epoxy Resin Adhesives	31
1.3.1.1 Amine Hardeners	33
1.3.1.2 Polyamide Hardeners	34
1.3.2 Acrylic Adhesives.....	34
1.3.2.1 Cyanoacrylate Adhesives.....	35
1.3.2.2 Methacrylates and Acrylates.....	37

1.4	Loctite® Standard Test Method.....	39
2.0	Experimental Techniques.....	41
2.1	Assembly Method for Chromic Acid Bath	43
2.2	Adhesive Selection Testing.....	45
2.2.1	Methodology.....	46
2.2.2	Results & Discussion.....	48
2.2.2.1	Loctite® E-40FL™.....	49
2.2.2.2	Loctite® H4800™	50
2.2.2.3	Loctite® 435™	52
2.2.2.4	Loctite® 332™	54
2.3	Design of Experiments Using IPA Cleaning and Chromic Acid Etching Treatment	57
2.3.1	Methodology.....	57
2.3.2	Results & Discussion	58
2.4	Post Treatment Cleaning Method Analysis.....	61
2.4.1	Methodology.....	62
2.4.2	Results & Discussion	63
2.5	Bath Degradation Testing.....	65
2.5.1	Methodology.....	66
2.5.2	Results & Discussion	67
2.6	Comparative Analysis Study on Chemical Surface Treatments for Aluminum	70
2.6.1	Methodology.....	71
2.6.2	Results & Discussion	75
2.6.2.1	Results by Conditioning.....	75
2.6.2.1.1	Unconditioned Assemblies	75

2.6.2.1.1.1	Loctite® H4800™	77
2.6.2.1.1.2	Loctite® 435™	80
2.6.2.1.1.3	Loctite® 332™	82
2.6.2.1.2	Salt Fog Conditioned Assemblies	84
2.6.2.1.2.1	Loctite® H4800™	86
2.6.2.1.2.2	Loctite® 435™	88
2.6.2.1.2.3	Loctite® 332™	90
2.6.2.1.3	Condensing Humidity Conditioned Assemblies	92
2.6.2.1.3.1	Loctite® H4800™	94
2.6.2.1.3.2	Loctite® 435™	96
2.6.2.1.3.3	Loctite® 332™	98
2.6.2.1.4	Heat 1 Assemblies (100°C for 435, 125°C for H4800 & 332)	100
2.6.2.1.4.1	Loctite® H4800™	102
2.6.2.1.4.2	Loctite® 435™	104
2.6.2.1.4.3	Loctite® 332™	106
2.6.2.1.5	Heat 2 Assemblies (125°C for 435, 175°C for H4800 & 332)	108
2.6.2.1.5.1	Loctite® H4800™	110
2.6.2.1.5.2	Loctite® 435™	112
2.6.2.1.5.3	Loctite® 332™	114
2.6.2.2	Results by Surface Treatment	116
2.6.2.2.1	Visual Observations	119
3.0	Conclusions	121
3.1	Chromic Acid Etching Process	122
3.1.1	Design and Assembly of System	122
3.1.2	Degradation	123

3.1.3	Cleaning Method.....	123
3.2	Comparative Surface Treatment Analysis.....	124
3.2.1	Performance	124
3.2.2	Cost	124
3.2.3	Ease of Use – Safety	125
3.2.4	Use in Industry	127
4.0	Recommendations.....	128
Appendix A:	STM 700.....	130
Appendix B:	Chromic Acid Bath Calculations.....	142
Appendix C:	Adhesive Selection Testing – Raw Data	143
Appendix D:	DOE Full Minitab Results.....	144
Appendix E:	Aluminum Powder Addition Calculations	145
Appendix F:	ASTM E 1508-93a.....	146
Appendix G:	STM 40.....	153
Appendix H:	ASTM B117-94.....	166
Appendix I:	Chromic Acid Anodizing Specifications	174
Appendix J:	Sulfuric “Hard” Anodizing Specifications	175
Appendix K:	Phosphoric Acid Anodizing Specifications	176
Appendix L:	Comparative Analysis Raw Data.....	181

List of Figures

Figure 1: Stereo STEM Micrograph of Chromic Acid Etched Surface of Aluminum.....	25
Figure 2: Drawing of Oxide Structure for Chromic Acid Etching	26
Figure 3: Stereo STEM Micrograph of Aluminum Surface after Phosphoric Acid Anodizing.....	28
Figure 4: Drawing of the Oxide Structures after Phosphoric Acid Anodizing.....	29
Figure 5: Contact Angle.....	30
Figure 6: Diglycidyl Ether of Bisphenol A (DGEBA Resins).....	32
Figure 7: Amine Reaction Sequence.....	33
Figure 8: Aromatic Amine.....	33
Figure 9: Condensation Reaction.....	34
Figure 10: Ethyl Cyanoacrylate.....	35
Figure 11: Electron Withdrawing Groups	36
Figure 12: Ethyl Cyanoacrylate Mechanism of Polymerization	36
Figure 13: Basic Monomeric Structures	37
Figure 14: Final Polymers	38
Figure 15: Adhesive Failure.....	40
Figure 16: Cohesive Failure	40
Figure 17: Complete Assembly of Chromic Acid Bath.....	43
Figure 18: Spraying of De-Ionized Water on Treated Specimens	44
Figure 19: Clamped Assembly	46
Figure 20: Testing of Specimen on Instron	47
Figure 21: Results of Average Bond Strengths for Adhesive Selection Testing	48
Figure 22: Individual Value Plot for H4800.....	51
Figure 23: Individual Value Plot for 435.....	53
Figure 24: Individual Value Plot for 332.....	55
Figure 25: Residue that Remained on Specimen.....	57
Figure 26: Averaged Bond Strength Results	59
Figure 27: "New" Cleaning Method (right) vs. "Old" Cleaning Method (right).....	61
Figure 28: ANOVA Analysis for Cleaning Methods.....	63
Figure 29: ANOVA Analysis for Bath Degradation Testing	67
Figure 30: EDS Spectrum of Aluminum on Etched Surface, Fresh Bath	68
Figure 31: EDS Spectrum of Aluminum on Etched Surface, Degraded Bath.....	69
Figure 32: (Near to Far) Chromic Acid Anodized, Sulfuric "Hard" Anodized, Phosphoric Acid Anodized, Sulfuric Acid Anodized, Chromic Acid Etched, No Treatment	70
Figure 33: Bond Strength vs. Surface Treatment (No Conditioning).....	76
Figure 34: Individual Value Plot - H4800 (No Conditioning).....	77
Figure 35: Tukey's Analysis - H4800 (No Conditioning).....	78
Figure 36: Individual Value Plot - 435 (No Conditioning).....	80
Figure 37: Tukey's Analysis - 435 (No Conditioning).....	81
Figure 38: Individual Value Plot - 332 (No Conditioning).....	82
Figure 39: Tukey's Analysis - 332 (No Conditioning).....	83
Figure 40: Bond Strength vs. Surface Treatment (Salt Fog).....	85
Figure 41: Individual Value Plot - H4800 (Salt Fog).....	86
Figure 42: Tukey's Analysis - H4800 (Salt Fog).....	87
Figure 43: Individual Value Plot - 435 (Salt Fog).....	88
Figure 44: Tukey's Analysis - 435 (Salt Fog).....	89
Figure 45: Individual Value Plot - 332 (Salt Fog).....	90

<i>Figure 46: Tukey's Analysis - 332 (Salt Fog)</i>	91
<i>Figure 47: Bond Strength vs. Surface Treatment (Condensing Humidity)</i>	93
<i>Figure 48: Individual Value Plot - H4800 (Condensing Humidity)</i>	94
<i>Figure 49: Tukey's Analysis - H4800 (Condensing Humidity)</i>	95
<i>Figure 50: Individual Value Plot - 435 (Condensing Humidity)</i>	96
<i>Figure 51: Tukey's Analysis - 435 (Condensing Humidity)</i>	97
<i>Figure 52: Individual Value Plot - 332 (Condensing Humidity)</i>	98
<i>Figure 53: Tukey's Analysis - 332 (Condensing Humidity)</i>	99
<i>Figure 54: Bond Strength vs. Surface Treatment (Heat 1)</i>	101
<i>Figure 55: Individual Value Plot - H4800 (125°C)</i>	102
<i>Figure 56: Tukey's Analysis - H4800 (125°C)</i>	103
<i>Figure 57: Individual Value Plot - 435 (100°C)</i>	104
<i>Figure 58: Tukey's Analysis - 435 (100°C)</i>	105
<i>Figure 59: Individual Value Plot - 332 (125°C)</i>	106
<i>Figure 60: Tukey's Analysis - 332 (125°C)</i>	107
<i>Figure 61: Bond Strength vs. Surface Treatment (Heat 2)</i>	109
<i>Figure 62: Individual Value Plot - H4800 (175°C)</i>	110
<i>Figure 63: Tukey's Analysis - H4800 (175°C)</i>	111
<i>Figure 64: Individual Value Plot - 435 (125°C)</i>	112
<i>Figure 65: Tukey's Analysis - 435 (125°C)</i>	113
<i>Figure 66: Individual Value Plot - 332 (175°C)</i>	114
<i>Figure 67: Tukey's Analysis - 332 (175°C)</i>	115
<i>Figure 68: Surface Treatment's Resistance to Humid Environments</i>	119
<i>Figure 69: Large Water Bath</i>	128

List of Tables

<i>Table 1: Mechanical Properties</i>	38
<i>Table 2: Adhesive Selection Test Matrix</i>	45
<i>Table 3: F-Test for E-40FL</i>	49
<i>Table 4: t-test for E-40FL</i>	49
<i>Table 5: F-test for H4800</i>	50
<i>Table 6: t-test for H4800</i>	50
<i>Table 7: F-test for 435</i>	52
<i>Table 8: t-test for 435</i>	52
<i>Table 9: F-test for 332</i>	54
<i>Table 10: t-test for 332</i>	54
<i>Table 11: Design of Experiments Test Matrix</i>	58
<i>Table 12: DOE Results for IPA Wipe Testing</i>	58
<i>Table 13: Bond Strength Results</i>	63
<i>Table 14: Bath Degradation Results</i>	67
<i>Table 15: Comparative Analysis Experimental Test Matrix</i>	71
<i>Table 16: Comparative Analysis Experimental Test Matrix</i>	72
<i>Table 17: Comparative Analysis Experimental Test Matrix</i>	73
<i>Table 18: No Conditioning – Pulled After at Least 72 Hours</i>	75
<i>Table 19: Salt Fog Conditioning Results</i>	84
<i>Table 20: Condensing Humidity Conditioning Results</i>	92
<i>Table 21: Heat 1 Conditioning Results</i>	100
<i>Table 22: Heat 2 Conditionings Results</i>	108
<i>Table 23: Pass/Fail Test for Conditioned Assemblies</i>	117
<i>Table 24: Cost of Surface Treatments</i>	125

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Abstract

Chemical surface treatment of aluminum has a significant effect on the bonding characteristics and the applications in which adhesive bonding of aluminum is used. Chromic acid etching is one of the oldest and most widely conducted treatment methods in industry. Henkel Loctite often receives requests to perform the chromic acid etching process on aluminum but it can be hazardous and inefficient. An actual chromic acid etching system for aluminum was designed and compared to other surface treatment methods to determine if this system would be of benefit to the sponsor in the future.

Executive Summary

Our sponsor, Henkel Loctite, is the world's largest manufacturer and supplier of consumer and industrial adhesives. Loctite conducts in-house services to outside companies to improve any products using adhesives manufactured by Henkel Loctite. For many applications, products using adhesives need special material treatment prior to adhesion. Certain materials, such as aluminum, steel, and various plastics, undergo surface treatment preparation prior to adhesion bonding in order to improve the strength and durability of the products.

One of the most common surface treatment methods, chromic acid etching, was actually conducted on site at Henkel Loctite's laboratories. Chromic acid etching involves submersing materials into a heated chromic acid bath for approximately ten minutes then cleaning the treated parts with water prior to bonding. Chromic acid consists of 10 parts by weight sulfuric acid, 1 part by weight sodium dichromate, and 30 parts by weight water.

However, there were many flaws in the process and our sponsor decided that it was a worthwhile investment to improve the chromic acid etching process and determine if it would be of benefit to the company to implement a permanent on-site system. This process is used on a wide variety of materials before the bonding process, but it is used most extensively on aluminum, mostly because aluminum is one of the least costly materials in industry. This project focused entirely on the treating and bonding of aluminum, and more importantly focused on the chromic acid surface preparation treatment of aluminum compared to four other commonly used treatment processes.

These four were chromic acid anodizing, sulfuric acid anodizing, “hard” anodizing, and phosphoric acid anodizing. All five of these methods are used extensively in the transportation, consumer cookware, and manufacturing industries, as well as many other industries. The goal of the project was to:

- Set up and design an actual working chromic acid etching system
- Treat multiple aluminum parts using the same bath
- Identify any flaws and faulty conditions associated with the system
- Conduct various experiments to improve these flaws
- Determine when the acid bath began to degrade to the point where it was no longer effective
- Compare the chromic acid etching treatment method to various other surface treatment methods done outside of Henkel Loctite to determine if a permanent system should be implemented on site or if all parts should be shipped out for treatment prior to bonding

The chromic acid bath was constructed using a temperature-controlled water bath and placing a Pyrex baking dish, containing the chromic acid, half way into the bath. A stand was also constructed to hold the aluminum parts as they were being treated. For this project, aluminum lap shears with dimensions of 1 inch by 4 inches, provided by Henkel Loctite, were used throughout all experimentation. This apparatus was able to treat a maximum of 18 lap shears at a time, and the lap shears were submerged into the chromic acid bath at a depth of at least 0.5 inches, as this was the required bond area for testing.

In order to insure that quality results were obtained throughout the project, an appropriate adhesive had to be chosen. Given 10 adhesives recommended by the supervisor, 10 lap shears were treated with the chromic acid for each of the 10 different adhesives. Once all bonded assemblies cured, they were tested for maximum shear strength using an Instron machine. All bond strengths were recorded and the statistical software Minitab was used to analyze the data. It was proven that only three of the 10 tested adhesives had higher average bond strengths after treatment compared to bonded non-treated aluminum, and only one adhesive, H4800, had statistically significantly better bond strength after treatment. Therefore, H4800 was the chosen adhesive to be used throughout the project.

When analyzing data from the adhesive selection process, it was found to have an unusual amount of variance from substrate to substrate, even within the same adhesive. When bonding the aluminum lap shears after treatment, there appeared to be some residue left over on the lap shears possibly affecting bond strength. Therefore, a design of experiments analysis was proposed to determine if cleaning the treated surface with isopropyl alcohol would improve the bond strength and limit the variance. After analyzing the data on Minitab, it could not be proven that cleaning the lap shears with isopropyl alcohol had any impact on results.

There was still an observed water stain or some sort of residue remaining on the surface of the treated aluminum parts. A different experiment was conducted to determine if wiping the parts after treatment with a tissue instead of drying them in an oven for 10 minutes would improve the process. When testing was complete, a significant increase in bond strength occurred with the tissue-wiped specimens and it was

proven that the tissue-cleaned lap shears had statistically significantly better bond strength and less variance. Therefore, this cleaning procedure was used throughout the rest of the project.

One of the main goals of the project was to determine how long it would take for the chromic acid bath to degrade to a point where it was no longer effective in treating the aluminum lap shears. According to Henkel Loctite, a project should never require more than 500 lap shears to be bonded at once. To be on the safe side, 1000 lap shears were treated. Instead of actually treating 1000 lap shears, a calculated amount of aluminum powder was dropped into the chromic acid bath to simulate the amount in order to save time and resources. Another experiment was conducted in which 10 assemblies were treated and bonded with a fresh bath and another 10 assemblies were treated and bonded with the “degraded” bath. There was no proven indication that bond strength was affected before and after the addition of the aluminum powder. Also, the chromic acid bath was analyzed before and after the aluminum powder was added to determine the difference in composition of the bath. The same was conducted for treated aluminum specimens and it was determined that very little difference occurred after 1000 lap shears were treated. This assured Henkel Loctite that the bath would not degrade during any future projects.

Once the chromic acid treatment system was fully established, this treatment method had to be compared to others to determine if the company should use this process in the future. Aluminum lap shears were sent out to various companies to perform four other treatment methods: chromic acid anodizing, sulfuric acid anodizing, sulfuric “hard” anodizing, and phosphoric acid anodizing. A control group of untreated aluminum was

also used in the analysis for comparative purposes. All treatment methods were bonded with adhesives H4800, 435, and 332, and some were sent for environmental conditioning for two weeks. Environmental conditioning consisted of a salt fog chamber, a regular fog chamber, and lower temperature oven, and a higher temperature oven. The lap shears that were not conditioned were compared to those that were and various treatment methods were compared to each other of the same adhesive used for bonding. Again, using Minitab, it was proven that phosphoric acid anodizing had overall stronger bond strengths than other treatment methods, but also was the only treatment method that didn't show a statistical significant drop in bond strength after being exposed to environmental conditioning. We also examined other factors such as cost, ease of use (safety), and use in industry to determine the best overall surface treatment. It was determined that the best performing surface treatment, phosphoric acid anodizing, was also the safest and most widely used in industry. It was concluded that phosphoric acid anodizing was the best aluminum surface treatment for Henkel to pursue for future testing.

Introduction

The first adhesives can be traced back to 4000 B.C., when archaeologists uncovered clay pots that had been repaired using tree sap. Adhesives have a history of about 6000 years, longer than most current industries. The Greeks and Romans used many natural adhesives, including tar and beeswax, used for several military purposes such as naval vessels and bows used by troops. Beginning around 1700, the first glue factory opened up in Holland to manufacture animal glue from hides. It was not until the Industrial Revolution that technical advances in adhesives began to improve. At this time, the first glue made from a polymer was introduced, and as plastics were discovered during the early 1900s, new and specific advances developed in adhesive technology, such as flexibility, toughness, and chemical resistance.¹ Currently, the adhesive industry is a multi-billion dollar industry and is located throughout 125 countries in the world. Today, adhesives hold together almost every piece of manufactured equipment used throughout the world. Whether it is the automotive industry, electronics, aerospace, metal, assembly, or construction industries, products could not be made without the application of adhesives.

Our sponsor, Henkel Loctite, has been in the adhesive industry for over 50 years. With products currently being marketed in more than 80 countries around the world, Henkel Loctite is the leading developer and manufacturer of adhesives, sealants and other specialty chemicals.² Henkel Loctite offers a service to its clients where engineers find the best solution to their needs based on desired specifications and cost. In some instances, in order to increase bond strength, the surface of the substrate prior to bonding is altered in some way. The focus for this specific application was the analysis of various

chemical surface preparation techniques. The first and most important technique is known as chromic acid etching or FPL (Forest Product Laboratory) etch, named after the company where it was invented in 1950, where a chemical alteration of the surface of a given substrate undergoes an oxidation process which “eats away” at the surface, creating a rough texture, thus increasing the surface area. Chromic acid is simply a mixture of 10 parts by weight sulfuric acid, 1 part by weight sodium dichromate, and 30 parts by weight water. By increasing the surface area of substrate, the adhesive has more available area to bond. However, there was a limit as to how many preparations could be completed using a single batch of the chromic acid. Henkel Loctite’s primary interest was to know how long the bath could be used before having to replace it and the issues associated with having to replace the acid bath.

The chromic acid etching process had been used before at Henkel Loctite but was not permanently implemented. Testing on aluminum samples had previously been conducted using set temperatures, bath exposure times, and certain adhesives, but the testing apparatus was taken down since it was only used for one at a time custom procedures. Because chromic acid etching of aluminum used as a preparation for adhesion is not a widely used process, Henkel believed that it would not be economical to run the testing process on a continuous basis.

However, with the adhesives industry becoming more technologically advanced and the need for more improved product performance, the implementation of this testing apparatus appeared to provide excellent future opportunities and benefits for Henkel Loctite. It could have allowed them to interact with a larger number of customers and other companies who could find the need for Henkel Loctite to perform these tests on

their products. The main purpose of this project, determining the life of the chromic acid bath, gave the company a good idea as to how efficient this process was. Other chemical surface preparation techniques were evaluated as well, such as various anodizing processes. These other techniques were not analyzed to the extent of the chromic acid etching process; however, they were used for comparative data.

Using standard aluminum test specimens provided by Henkel Loctite, a bench top etching system was designed. By submersing and exposing the desired bond area to this chromic acid bath for a set time and temperature, the area was prepared for adhesion. The design was able to handle 40 standard Lap Shears and the concentration profile of acid throughout the system was equal at all points. Also in order to determine when the chromic acid bath began to degrade, various tests were performed on the solution throughout the entire process to evaluate pH, aluminum content, and chromate levels. The system allowed for an easy and safe removal of the acid solution. Structural adhesives with different curing mechanisms were evaluated in order to identify possible trends. These standard bonded test specimens were then evaluated using different mechanical property tests. These tests determined the bond area's maximum shear strength. Environmental chambers were used in order to simulate advance aging in a short period of time. A design of experiments was established in order to avoid variations in data and to provide accurate statistical analysis of the results. This statistical analysis ranked each run according to bond strength. By using the previous tests based on the content of the solution at various times and bond strengths of the corresponding test specimen, it was determined when the bath needed to be altered or changed. This provided information with regards to how many test specimens could be treated before

the bath was no longer effective. Using this information, other surface preparation techniques were investigated in order to analyze if this process was indeed reasonable for future implementation.

1.0 Literature Review

Before proposing the designs for certain bench-top surface preparation systems, we had to be well versed in the technology that was being used. To truly understand the scope of this project, we must look at what had been done previously and in the current industry today.

1.1 History of Adhesives

The adhesives industry is one of the largest in the world, spanning over 750 companies comprising of the multi-billion dollar industry. 50 of those 750 companies are responsible for 50% of sales in the adhesive world. Henkel-Loctite, one of those 50 companies, is one of the largest adhesive companies in the world, and because adhesives are literally found in almost every piece of manufactured equipment in today's high and ever-changing technological world, Henkel-Loctite has a huge impact not only on the adhesives industry, but also in everyday life.³

In order to understand the importance of the role adhesives play in the world, it was necessary to understand the history behind adhesives. The first observed adhesive can be dated back to 4000 B.C. in which pre-historic tribes plugged broken pottery vessels with tree sap in which they stored foodstuffs in the coffins of dead people. Between 2000 and 1000 B.C., animal glue began to be used throughout civilization, as paintings, murals, and caskets contained glue in their construction. Artifacts from ancient Egypt, such as the tombs of pharaohs, were observed to be bonded or laminated with some form of animal glue.⁴

The Greeks and Romans, approximately 2000 years later, began to improve on this glue by incorporating various natural substances into adhesives to provide better bonding strength. Ingredients such as egg whites, blood, bones, hide, milk, cheese vegetables, grains, beeswax, and tar were all used in various forms of manufacturing and artwork, such as ship construction and veneering and marquetry, in which thin sections of layers of wood were bonded together.⁵

For the next several hundred years, adhesives became more widespread as furniture and cabinet makers incorporated adhesives into their work. Some of these makers can be recognized today, such as Chippendale and Duncan Phyfe. Adhesives also have played an important role in military history, as most weapons parts in the early part of the millennium were bonded solely with adhesives. Violins were laminated with a specialty adhesive, and violin makers today have yet to recreate the lamination process of the 1500 and 1600s.⁶

In the 1700s, the adhesive industry really began to take off, as the first glue factory was constructed in Holland in which animal glues were manufactured from hides. In the late 1700s, patents began to be issued for glues and adhesives, as fish glue and adhesives using natural rubber, animal bones, fish, starch, and milk protein were all patented. By the start of the industrial revolution, the United States had several large glue-producing factories. As the 1900s progressed, the discovery of oil helped the adhesive industry take off in great proportion, as this led to the discovery of plastics. The introduction of Bakelite phenolic allowed adhesives using resin to be put on the market, and within the next 40 years, as new plastics and rubbers were being synthetically produced, the present day technology of adhesives were discovered. This development of plastics and elastomers has allowed the properties of adhesives to be changed and improved, such as flexibility, toughness, curing or setting time, temperature and chemical resistance.⁷

1.1.1 Importance of Adhesives in Industry Today

Adhesives are everywhere in the highly technological manufacturing world today, and it is no surprise that adhesives are one of the most important substances used in industry. Many adhesives have taken the place of other joining processes, such as bolts

and welding, which reduced the cost of manufacturing and labor. Adhesive companies on-sell their products to companies in the construction sector, aircraft manufacturers, automotive manufacturers, and packaging industries.⁸ The following is a list of several commonly used adhesives and their role in industry and every-day products.

Fish Glue: Used for photo emulsion for photo films and photo resist coatings.

Casein Glue: A waterproof adhesive used in the sealing of cigarette paper.

Starch: Used to bond paper products such as bookbinding, corrugated boxes, paper bags, wallpaper paste.

Cellulose Adhesive: The adhesive used on decals on windows and on strippable wallpaper.

Rubber-based Solvent Cements: Used on counter tops, cabinets, desks and tables.

Also used on self sealing envelopes and shipping containers, and widely used in the shoe and leather industries.

Epoxies: Often used to bond metals and have replaced some traditional metal-joining processes, such as rivets, bolts, welding, brazing, and soldering. These metals are used to build rotor blades on helicopters and to build skis and snowboards.

RTV Silicone Adhesives: Used as sealant and caulking compounds in the construction industry as well as sealants for windows and doors on space shuttles.

Anaerobic Adhesives: Used in any industry that needs fasteners, gaskets, bearings or any mechanical device to be sealed or secured.

Cyanoacrylates: Also known as Super Glue. Used in electronics for printed circuit board wires and components and on disposable plastic medical devices.⁹

1.2 Surface Preparation Techniques

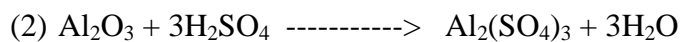
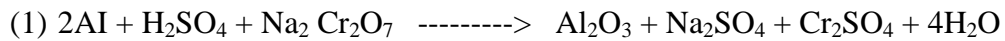
The purpose of surface treatment in preparation of adhesion is to modify the material to provide the best conditions for bonding. In this project, the material to be tested for adhesion was aluminum. Metal surfaces usually have an oxide layer on their surface, making it highly polar and ideal for adhesion. The major focus of surface treatment for metals, in particular chemical treatment, is to enhance the bonding strength and most importantly, to increase the endurance of metal bonds, especially in humid environments.¹⁰

In preparation of metals, the organic adhesive is intended to only make contact with the adherend material, as there should be no layers of oxide film, paint, chromate coating, chromate-free coating, phosphate coating, or silicon release agents. These are called weak boundary layers and drastically reduce the effectiveness of adhesion. When the materials are bonded to the adhesive, the bond should always be broken within the organic adhesive material, and not between the adhesive and the adherend. A *cohesive failure* is the desired failure in which the adhesive remains on both pieces of adherend, whereas an *adhesive failure* is one that occurs at the interface between the layers. 100 % cohesive failure is always the desired failure mechanism when describing materials bonded to organic adhesives.¹¹

In preparing the test aluminum samples for adhesion, the three most important steps involve cleaning, abrading the surface mechanically to increase contact surface, and chemical treatment to improve corrosion resistance. In this project, chemical treatment was the variable studied and several different chemical surface treatments were compared based upon their effectiveness of bonding with a particular adhesive.

1.2.1 Chromic Acid Etch

The chemical treatment that was under the most investigation for this project was chromic acid etching, or the Forest Products Laboratory (FPL) etch, named after the aluminum surface preparation for Clad 24S-T3 in 1950, and later revised in 1975. The etching bath consists of 10 parts by weight sulfuric acid, 1 part by weight sodium dichromate, and 30 parts by weight distilled water. This solution is commonly referred to as chromic acid. When the aluminum is etched with the chromic acid, a layer of aluminum oxide is formed. There are two reactions present in this etching process¹²:



The first reaction produces the aluminum oxide, which then reacts with the sulfuric acid to produce aluminum sulfate. However, the first reaction proceeds much faster than the second one,

allowing a controlled amount of aluminum oxide on the surface. It was part of the project to determine not only how long it took for the chromic acid bath to lose the effective amount of sulfuric acid,

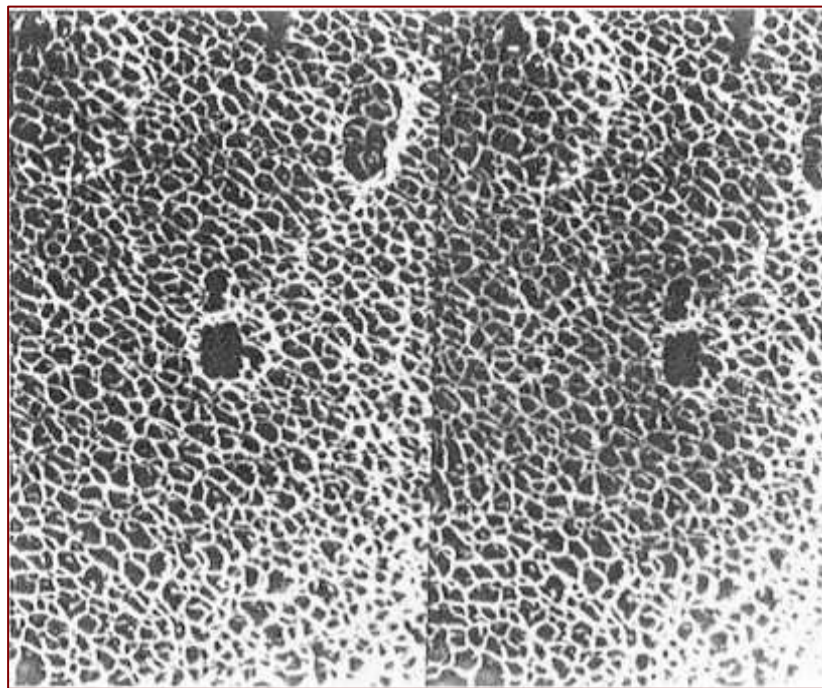


Figure 1: Stereo STEM Micrograph of Chromic Acid Etched Surface of Aluminum

but also if there was an appropriate amount of aluminum oxide on the surface of the test sample ready for adhesion.

Figure 1¹³ shows the surface of the aluminum after chromic acid etching, and **Figure 2**¹⁴ shows a proposed sketch of the aluminum oxide structures.

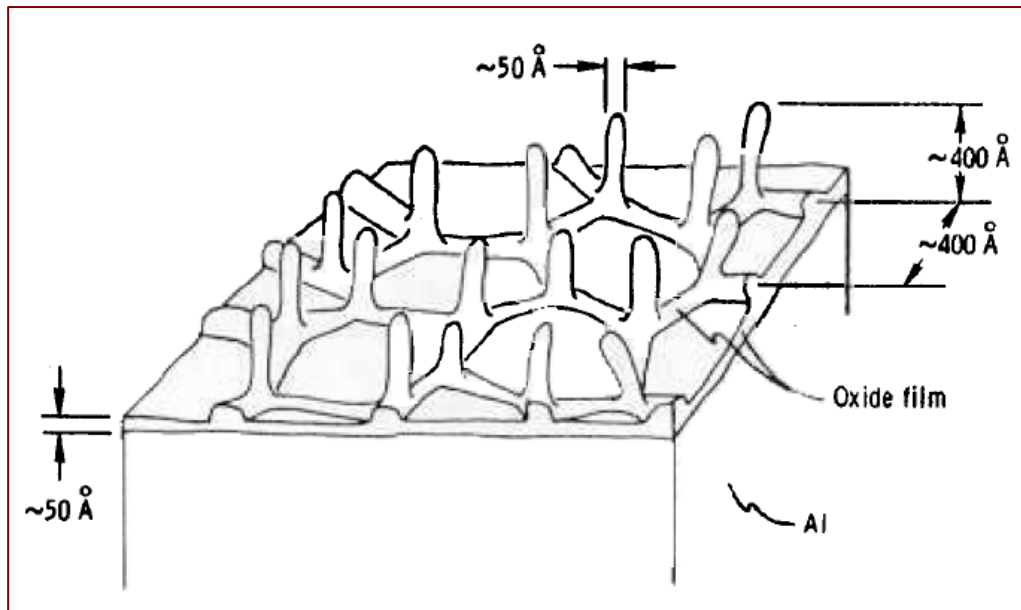


Figure 2: Drawing of Oxide Structure for Chromic Acid Etching

After the etching process is complete, the sample must be rinsed with water, but it is a better idea to spray the aluminum surface instead of submerging it because residue from the surface will eventually contaminate the water bath, thus lowering the pH level and possibly leading to bond failures.

1.2.2 Sulfuric Acid Anodizing and “Hard” Anodizing

In addition to submerging the aluminum in an acid bath and removing it after a given period of time, another surface preparation process involves running an electric current through a sulfuric acid/water bath while the aluminum sample is submerged. The solution is similar to chromic acid minus the sodium dichromate. Like the chromic acid etch, a very thin layer of aluminum oxide is formed on the surface of aluminum. This is called sulfuric acid anodizing and is used considerably by the automotive and consumer cookware industries.

A variation of sulfuric acid anodizing is hard anodizing, which uses the same process as regular sulfuric acid anodizing except the acid is cooled to the freezing point of water and the current through the bath is substantially increased. Compared to the regular anodizing process, a much thicker layer of aluminum oxide is produced, as holes and fissures in the surface give the treated aluminum a more uniform appearance. The oxide layer has a much stronger bond to the original aluminum surface, making it more durable in harsh weather and salty environments, as well as increasing bond strength when an adhesive is applied to the treated surface.¹⁵

1.2.3 Phosphoric Acid Anodizing

Aside from etching, anodizing is one of the most widely used surface treatments of metals, especially in the aerospace industry. During the process, stable coatings or films are formed on the aluminum surface in a wide variety of electrolytes. The test samples are submerged in a bath of 9-12 weight % phosphoric acid at 19-25 degrees Celsius between a voltage from 9 to 16 V under a direct current. Compared to the chromic acid etch, this process is less dependent on certain variables, such as time between treatment and rinsing. This is the preferred treatment in the aerospace industry because the oxide layer formed is thicker than the chromic acid, and the “whiskers,” as shown in **Figure 2** (above), are generally longer in the anodizing process. However, the immersion time is almost twice as long compared to the chromic acid etching process, which only lasts for about 10 minutes, compared to the 20 to 25 minutes required for anodizing.¹⁶

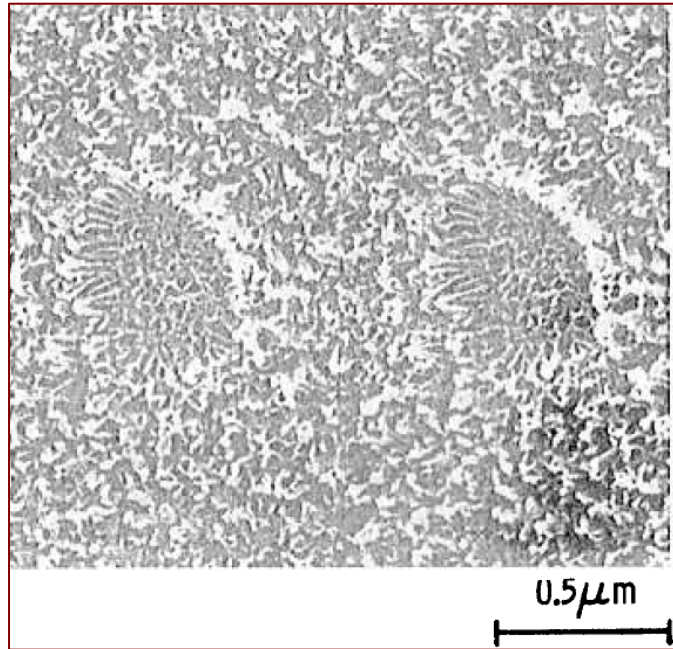


Figure 3: Stereo STEM Micrograph of Aluminum Surface after Phosphoric Acid Anodizing

Figure 3¹⁷ shows the surface of the same aluminum test sample as shown in **Figure 1** Error! Reference source not found., but after phosphoric acid anodizing treatment.

Figure 4¹⁸ shows the oxide layer drawing of the aluminum surface.

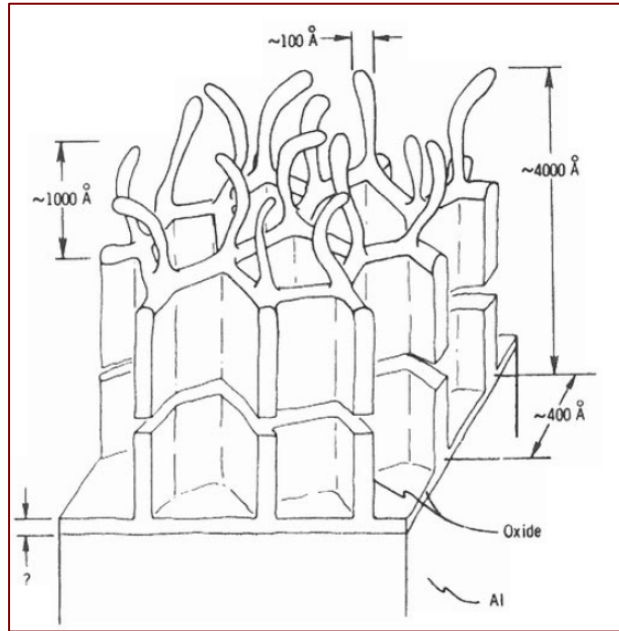


Figure 4: Drawing of the Oxide Structures after Phosphoric Acid Anodizing

1.2.4 Chromic Acid Anodizing

Finally, the chromic acid anodizing process is similar to phosphoric acid anodizing, in which the aluminum test specimen is subjected to a voltage and applied current, thus forming an electrolyte layer. The chromic acid in the solution leaves a strong layer of aluminum oxide on the surface, allowing for a strong bonding environment.¹⁹

An actual chromic acid etching process was devised in this project and the main variable to be tested was how long an individual bath could be used until it was no longer effective. The bonding strengths of the adhesives used on the chromic acid etched samples were compared to those of the three other surface treatment methods discussed.

1.3 Adhesive Chemistry

In order to adhere properly and efficiently to a substrate, an adhesive must first do two things. First it must “wet” the surface, by spreading material throughout the entire bond area and making a contact angle approaching zero. The contact angle is the angle at which the vapor/liquid interface meets the solid surface [See **Figure 5**].²⁰ Secondly the adhesive must harden to a cohesively strong solid.²¹

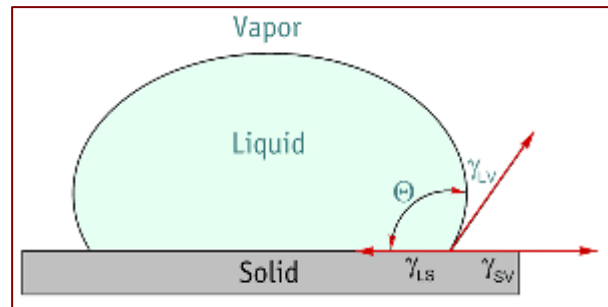


Figure 5: Contact Angle

Wetting is important since it involves making intimate contact between the molecules of the adhesive and the molecules in the surface of the substrate. This application technique is extremely important with every adhesive. By applying adhesive in this fashion, it permits maximum interactions on the surface of the substrate, in turn, increasing bond strength. After the substrates are mated, hardening can occur by chemical reaction, loss of solvent or water, or by cooling/heating. When this intimate contact is made, van der Waals forces are built, but other intermolecular forces may occur such as chemical bonds. This is where things can vary depending on the chemistry of the particular adhesive and substrate being used. If the adhesive can penetrate into the substrate before hardening, then mechanical interlocking will contribute to the overall strength of the bonded area. Intertwining of polymer molecules in the adhesive with those in the substrate would result in molecular interdiffusion across the interface. These four phenomena underlie the *physical adsorption*, *chemical bonding*, *mechanical*

interlocking and *diffusion* theories of adhesion. The remaining two theories that provide a backing as to how adhesives work are *electrostatic* theory and *weak boundary layer* theory. Electrostatic theory states that if two metal substrates are placed in contact, electrons will be transferred from one to the other. This forms an electrical double layer, which in turn gives a force of attraction. Lastly, weak boundary layer theory proposes that clean surfaces give stronger bonds to adhesives. Some contaminants such as rust and oils produce a layer which is cohesively weak, which in turn, weakens the overall bond strength.²²

The remainder of this section covers the particular chemistries involved with the type of adhesives that were evaluated.

1.3.1 Epoxy Resin Adhesives

Epoxy resins are reactive with a number of different curing agents and yield a wide variety of products with different cure requirements and end use performance. Epoxy resins cure with no byproducts, have low shrinkage and adhere to many different substrates. Although epoxy adhesives represent only a small part of the total adhesives market, they are unequalled in performance where high strength and endurance properties are significant.²³

Epoxy adhesives are made up of the resins themselves, plus the hardeners that produce the curing reactions. The first commercial epoxy resins, and still the most important, are those from the diglycidyl ether of bisphenol A (DGEBA resins). Bisphenol A epoxy resins are difunctional, with epoxide groups on the ends of the chain. As the molecular weight is increased, the resin retains its epoxide difunctionality while adding n repeating groups as shown above.²⁴ [See Figure 6]²⁵

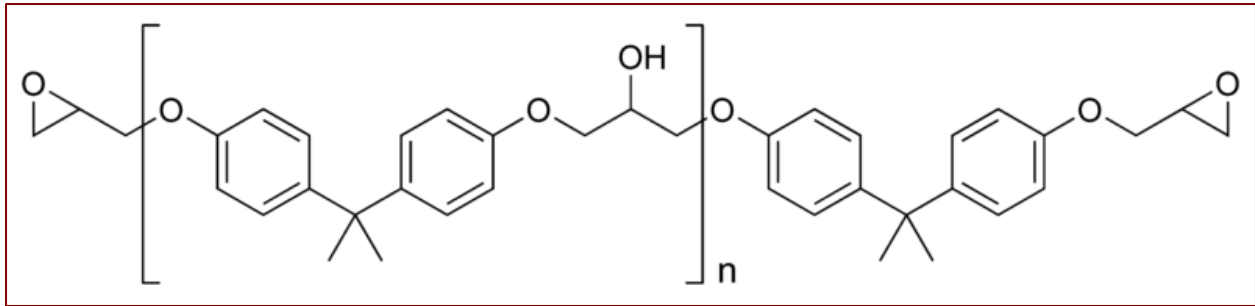


Figure 6: Diglycidyl Ether of Bisphenol A (DGEBA Resins)

Hardeners, or curing agents, determine the type of chemical bonds formed and the degree of crosslinking which occur with the epoxy resin. The type of curing agent will also determine the rate of reactivity, degree of exotherm, gel time, formulation viscosity, and the heat requirement during the cure cycle. These factors, in turn, affect the electrical and physical properties, chemical resistance, and the heat resistance of the cured adhesive. The types and number of curing agents available continues to grow rapidly.²⁶ The two types of curing agents that will be focused on are amine based hardeners and polyamide based hardeners.

1.3.1.1 Amine Hardeners

The functionality of an amine is determined by the number of amine hydrogens present on the molecule. A primary amine group (nitrogen with two hydrogens bound to it) will react with two epoxide groups. A secondary amine group (nitrogen with only one hydrogen bound to it) will react

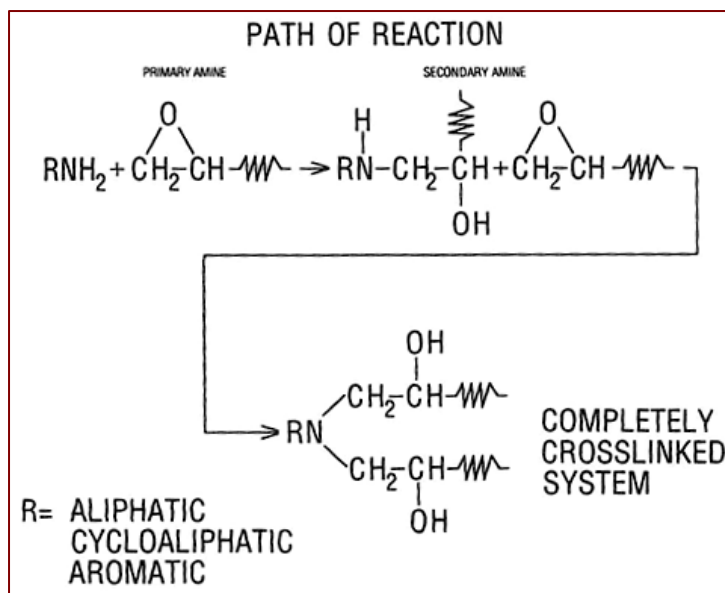


Figure 7: Amine Reaction Sequence

with on epoxide group. A tertiary amine group (nitrogen with no hydrogens bound to it) will not react readily with any epoxide groups; however it will serve as a catalyst to accelerate epoxy reactions [See

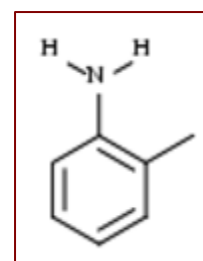


Figure 8:
Aromatic Amine

Figure 7).²⁷ There are three types of amines that when used will affect the various adhesive properties as discussed in section 2.4.1. These

three types are aliphatic amines, cycloaliphatic amines, and aromatic amines.²⁸ In all cases, regardless of the type, an amine group must be present in order for it to be considered an amine. In aliphatic compounds, atoms can be joined together in straight chains, branched chains, or non aromatic rings. Cycloaliphatic amines are when atoms are joined in a ring structure that is not aromatic. Lastly, aromatic amines are atoms joined in a ring structure that is in fact aromatic. Aromaticity is a chemical property in which a conjugated ring of unsaturated bonds, lone pairs, or empty orbitals exhibit a

stabilization stronger than would be expected by the stabilization of conjugation alone [See Figure 8].²⁹

1.3.1.2 Polyamide Hardeners

The most commonly used polyamides are the condensation products of dimerized fatty acids and aliphatic amines such as diethylene triamine. The amide link is produced from the condensation reaction of an amino group and a carboxylic acid or acid chloride group, at which point a small molecule, usually water, is eliminated³⁰ [See Figure 9].³¹

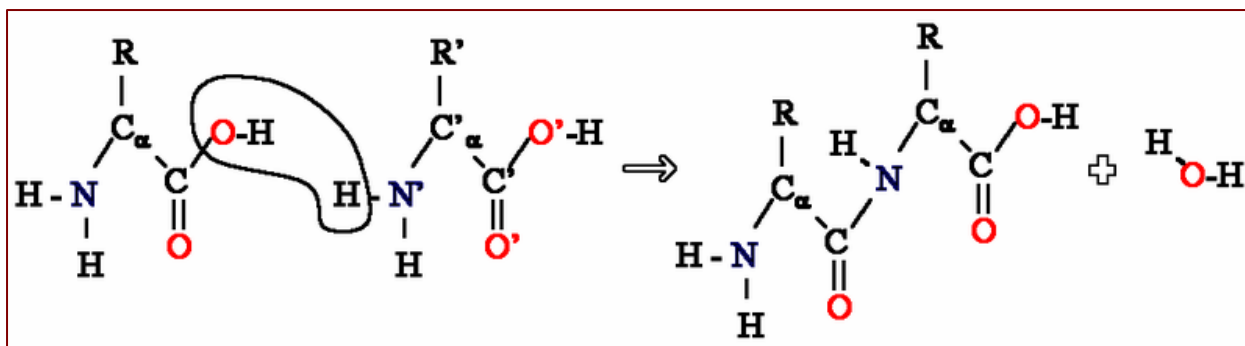


Figure 9: Condensation Reaction

The polyamides react with epoxide groups through the unreacted amine functional groups in the polyamide backbone, similar to that of basic amine hardeners. However, as a result of their relatively large molecular weight, the ratio of polyamide to epoxy resin is more forgiving (less critical) than with low molecular weight polyamines.³²

1.3.2 Acrylic Adhesives

Acrylic adhesives today are a large class of specifically designed products made to meet the needs of industry in the assembly of a wide variety of components.³³ These adhesives are solvent-free 'reactive' engineering adhesives that include but are not limited to cyanoacrylate, anaerobic and modified acrylic adhesives.³⁴

Acrylic adhesive polymers are widely used for applications such as pressure sensitive tapes, labels, and other decorative and functional pressure sensitive products. These applications thrive on the adhesive's versatile adhesion ability and excellent aging characteristics. Acrylic adhesives are also widely used as elastomers and thickener components in a variety of waterborne construction adhesives, laminating adhesives, and packaging adhesives.³⁵

Acrylic chemistry is the basis for a number of 100% solids reactive engineering adhesives used in structural bonding applications, generally involving a metal or plastic nonporous surface.³⁶

1.3.2.1 Cyanoacrylate Adhesives

Cyanoacrylate adhesives are unique among the many classes of adhesives, in that they are the only single component, instant bonding adhesives that cure at ambient conditions without requiring an external energy source. This characteristic, and its ability to bond to a wide variety of substrates, has made cyanoacrylate adhesives ideal for numerous bonding applications.

In this case we focused particularly on ethyl cyanoacrylate³⁷ [See Figure 10].³⁸

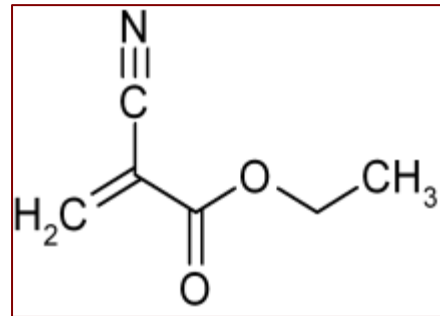


Figure 10: Ethyl Cyanoacrylate

The reactivity of cyanoacrylates is directly traceable to the presence of two strong electron withdrawing groups (designated X and Y) [See Figure 11].³⁹

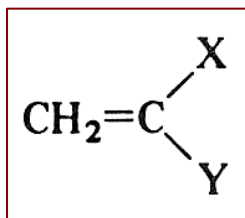


Figure 11: Electron Withdrawing Groups

Where: X = CN
Y = COO-CH₂-CH₃

These groups make the double bond highly susceptible to attack by weak bases. More specifically, cyanoacrylate rapidly polymerizes in the presence of water (specifically hydroxide ions) in air, forming long, strong chains which join the bonded surfaces together [See Figure 12]. The nucleophile represents the hydroxide ions found in air.

This reaction will continue until all available monomer is consumed or until growth is interrupted by the presence of an acidic species.

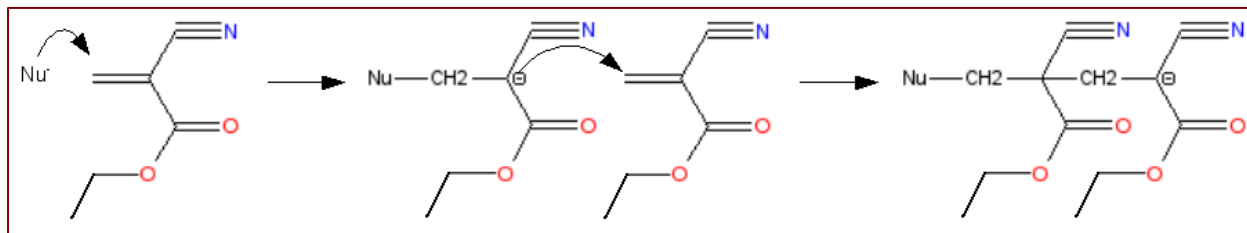


Figure 12: Ethyl Cyanoacrylate Mechanism of Polymerization

1.3.2.2 Methacrylates and Acrylates

Polymers made from esters of methacrylic and acrylic acids have been widely used for many years. As a result of this, many methacrylate and acrylate monomers are available commercially for use in making liquid monomeric adhesives. Also, the technology for making other monomers as required is well established, therefore, it is now possible to have monomers specifically designed to meet particular adhesive requirements.⁴⁰ These monomers, which during cure form long polymeric chains, can have many different traits based on the chemical structure of said monomers. The characteristic properties of a polymer are greatly influenced by the conditions of polymerization. Variations in catalyst level, reaction time, temperature, and monomer concentration make it possible to adjust the polymer's molecular weight and ultimately its physical properties.⁴¹ The basic monomeric structures for acrylates and methacrylates can be seen below in **Figure 13**.⁴²

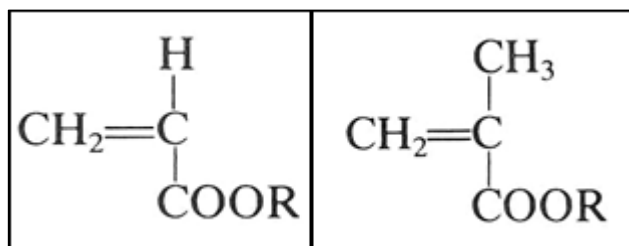


Figure 13: Basic Monomeric Structures

Polymerization is started by a free-radical initiator, often times a peroxide. The monomers then polymerize rapidly, adding onto the growing chain to form the final polymer [See Figure 14].⁴³

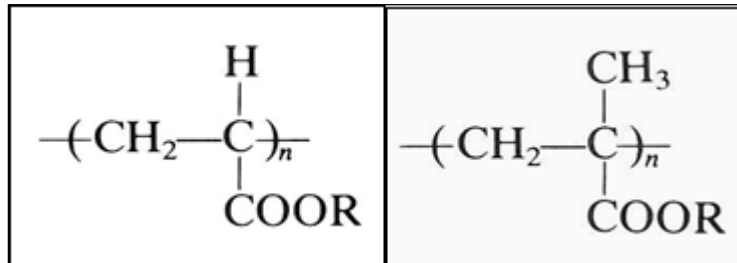


Figure 14: Final Polymers

The acrylate polymers have an alpha hydrogen adjacent to the carbonyl group and, therefore, have more rotational freedom than the methacrylates. The substitution of a methyl group for the hydrogen atom (producing a methacrylate polymer) restricts the freedom of rotation of the polymer and thus produces harder, higher tensile strength and lower elongation polymers than their acrylate counterparts (See Table 1).

Table 1: Mechanical Properties		
Polymethacrylate	Tensile Strength (psi)	Elongation (%)
Methyl	9,000	4
Ethyl	5,000	7
Butyl	1,000	230
Polyacrylates	Tensile Strength (psi)	Elongation (%)
Methyl	1,000	750
Ethyl	33	1,800
Butyl	3	2,000

1.4 Loctite® Standard Test Method

Loctite standard test methods were used to evaluate various properties with certain bonded substrates. The main concern for our specific application is bond strength. There were various ways of observing bond strength, and different types of bond strength. For our particular application, we observed the shear strength of our bonded assemblies. In order to do so we used STM (Standard Test Method) 700: *Shear Strength of Adhesives Using Lap-Shear Specimens*.

This involved the lap shears being pulled on the Instron 4505 machine using a 50 kN load cell at 0.05 inches per minute. Peak load and failure mode were then recorded after bond failure.

Shear strength is the strength of a material or part of an assembly in which the material fails in shear. Shearing is the deformation of a material in which parallel surfaces slide past each other. The aluminum lap shears used in this project were 1 inch by 4 inches and bonded together at an area of 0.5 inches. Force was applied in opposite directions at each end of the bonded assemblies until failure occurred. Even though substrate failure was the desired goal when testing bonded assemblies, many times the substrates underwent adhesive and cohesive failures, resulting in various bond strengths. For an image of adhesive failure, see **Figure 15** and for an image of cohesive failure see **Figure 16**.

Please See Appendix A for STM 700.

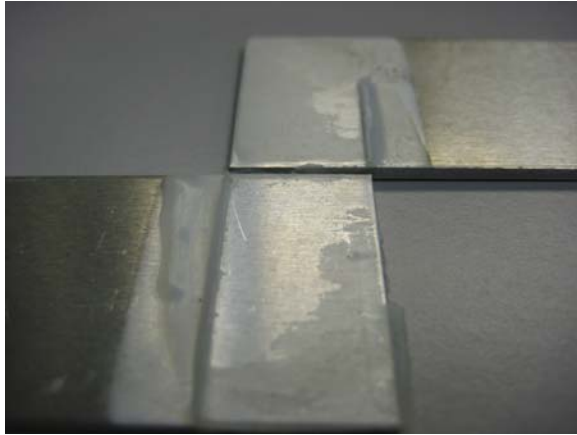


Figure 15: Adhesive Failure

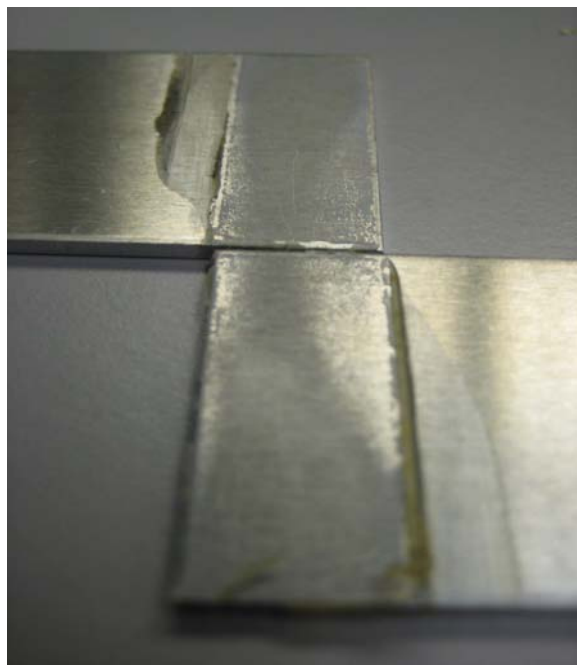


Figure 16: Cohesive Failure

2.0 Experimental Techniques

The overall goal was to design and evaluate a bench-top chromic acid etching system for aluminum prior to adhesion. Once that was completed, the results of this system were compared to other chemical surface preparation techniques. These techniques could use the system previously created for the chromic acid etch, or a completely new system. The previous chromic acid etching system at Henkel-Loctite consisted of a large beaker filled with the acid on a hot plate in which the lap shears were hand placed into the beaker and then hand removed after 10 minutes. The other surface preparation techniques could also be provided by an outside vendor in the interest of time and lack of resources. In order to complete this task, mission objectives were laid out.

- 1) Design and build a Bench-top chromic acid etching System.
 - 2) Determine when the batch of chromic acid degraded to a point where it was no longer useable.
 - 3) Evaluate other possible surface preparation techniques.
 - 4) Determine which system suited the needs of our sponsor the best.
-
- 1) Using our knowledge of safe lab practices obtained over a four year period at WPI, and researching previous systems used by our sponsor and other companies alike, a system was designed. The designed system also took into account sizing specifications, as well as repeatability.
 - 2) Appropriate adhesives were selected for use during testing in order to ensure the best results. The most optimal cleaning method prior to bonding was also determined.

3) By evaluating the strength of our bonded assemblies, we were able to determine when the batch began to degrade. By using the same batch for multiple assemblies, it became apparent when the strength of the bonds began to decrease or become erratic. Evaluating the aluminum content and chromate levels of the batch throughout the entire preparation process gave us a closer look at the changes in the bath as the bond strengths of the samples decreased.

4) Evaluating the bond strengths of the chromic acid etching samples, compared to those of different surface preparation techniques, allowed us to determine which technique was best for adhesion. By having multiple surface preparation techniques for aluminum, it allowed the company to rely on multiple options. It also opened up opportunities to explore avenues that Henkel had yet to observe.

5) Using statistical analysis, it was determined which surface preparation techniques yielded the best bond strengths. Using that data, and other information such as the cost, safety of the techniques, and efficiency it was determined which system best suited our sponsor.

2.1 Assembly Method for Chromic Acid Bath

Since the acid bath being constructed needed to hold a constant temperature of 70°C, it was necessary to evaluate various possibilities of achieving this. After consulting with several lab managers both on the WPI campus and here at Henkel-Loctite, a water bath was decided on because it provided the most accurate acid temperature in the safest manner. Assembly of the

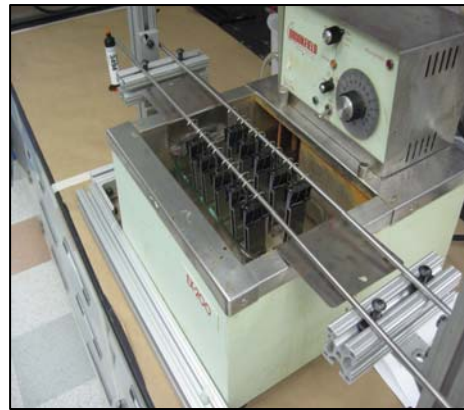


Figure 17: Complete Assembly of Chromic Acid Bath

acid bath first began by selecting an appropriate vessel to place the acid into. Since glass was one of the only materials that could be used with chromic acid, because of its highly reactive potential with other materials, we settled on a Pyrex baking dish. By partially submerging the dish into the water bath, above the line of the chromic acid, good heat transfer throughout the dish and the bath was assured. Aluminum handles were then glued to the sides of the dish to act as stops to keep the dish remaining at the proper level, and to also aid in removing the dish from the water bath for waste disposal.

The chromic acid bath was created using 10 parts by weight sulfuric acid, 1 part by weight sodium dichromate dehydrate, and 30 parts by weight water, which after conducting several conversion calculations, resulted in 82 mL of sulfuric acid, 15.25 grams of sodium dichromate, and 452 mL of water [See Appendix B for Calculations]. The bath was stirred regularly with a glass rod and placed into the water bath. In order to keep the chromic acid bath at 70 degrees Celsius, the water bath temperature had to be kept at 80 degrees Celsius. The apparatus, as shown in **Figure 17**, which was fabricated

at the machine shop here at Henkel-Loctite, was used as a fixture to hold the aluminum test specimens in place during the etching process. It also was used to hold the specimen in place during the rinsing process, shown in **Figure 18**, once etching was completed.



Figure 18: Spraying of De-Ionized Water on Treated Specimens

2.2 Adhesive Selection Testing

An appropriate adhesive candidate for an eventual chromic acid bath degradation study was chosen based on a study evaluating 10 adhesives, as shown in the test matrix in **Table 2**. 10 replicates per run were chosen based on a Minitab analysis, assuming that a minimum difference of 383 psi could be detected using the same adhesive from treated to non-treated specimen with a 90% chance that this difference would be found. The candidate was selected based on the greatest mean difference in bond strengths achieved from treated to non-treated specimen, given the difference in the mean was statistically significant.

Table 2: Adhesive Selection Test Matrix					
Run	Adhesive	Treatment	Test Method	Primer	Reps
1	E-60HP	None	STM 700	None	6*
2	E-30UT	None	STM 700	None	10
3	H8010	None	STM 700	None	10
4	E-40FL	None	STM 700	None	10
5	H4800	None	STM 700	None	10
6	H8000	None	STM 700	None	10
7	480	None	STM 700	None	10
8	435	None	STM 700	None	10
9	331/7387**	None	STM 700	7387	10
10	332/7387**	None	STM 700	7387	10
11	E-60HP	Chromic Acid	STM 700	None	10
12	E-30UT	Chromic Acid	STM 700	None	10
13	H8010	Chromic Acid	STM 700	None	10
14	E-40FL	Chromic Acid	STM 700	None	10
15	H4800	Chromic Acid	STM 700	None	10
16	H8000	Chromic Acid	STM 700	None	10
17	480	Chromic Acid	STM 700	None	10
18	435	Chromic Acid	STM 700	None	10
19	331/7387**	Chromic Acid	STM 700	7387	10
20	332/7387**	Chromic Acid	STM 700	7387	10
21	E-60HP	Chromic Acid	STM 700	None	10

* Data acquisition was only obtained for 6 specimens on the 1st run due to software issues.

** 7387 Primer was used for Runs 9, 10, 19 & 20 NOTE: Run 21 was completed in order to see if the bath began to degrade after a set order of runs, based on the performance of this specific adhesive (E-60HP).

2.2.1 Methodology

The first tests consisted of applying adhesive to untreated aluminum lap shear specimens and letting them cure for at least 3 days. Prior to the application of the adhesive, all bonding surfaces were cleaned with isopropyl alcohol. Adhesive was then manually applied to one lap shear specimen and was mated with a second lap shear with a 0.5” overlap. The mated assembly was clamped with two (2) Brink and Cotton No. 1 clamps and allowed to cure for at least 72 hours at ambient conditions prior to testing [See Figure 19].

The same testing procedure was then conducted on the chromic acid treated lap shear specimens using the same adhesives.



Figure 19: Clamped Assembly

The aluminum lap shears, with a clamp holding 2 specimens separated by a polypropylene block, were lowered into the bath 20 at a time for 10 minutes as 1 inch of the specimens were submerged into the bath. After 10 minutes, each batch of 20 aluminum lap shears were sprayed with de-ionized water and dried in an oven held constant at 80 degrees Celsius for another 10 minutes. Both the temperature of the water bath and acid bath were monitored in between each run to ensure the correct temperature was maintained. Once the test specimens were taken out of the oven, they were immediately bonded with the selected adhesive and let out to cure for 72 hours.

The bond strengths of the lap shears from the adhesive selection process were determined using the Instron 4505 machine using a 50 kN load cell. All assemblies were tested according to STM-700 where samples were pulled at 0.05 inches per minute and peak load and failure mode were recorded [See **Figure 20**]. The bond strengths were then analyzed by maximum strength and adhesive type using an F-test to determine if there was a significant difference in the variance between the treated and untreated specimen and a t-test to determine if there was a significant difference between the means.

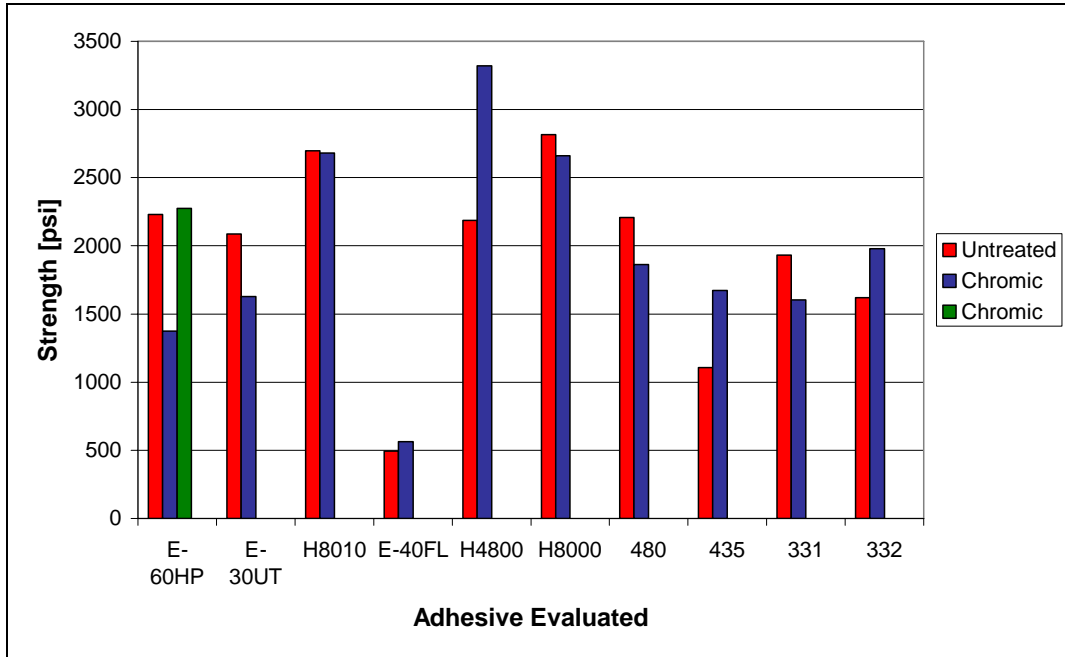


Figure 20: Testing of Specimen on Instron

2.2.2 Results & Discussion

The mean maximum bond strengths of all 10 adhesives are shown in **Figure 21**, and the full tabulation of results is shown in **Appendix C**.

Figure 21: Results of Average Bond Strengths for Adhesive Selection Testing



NOTE: Run 21 (represented here by the green bar) was completed in order to see if the bath began to degrade after a set order of runs, based on the performance of this specific adhesive (E-60HP).

As shown in the above chart, the four adhesives that produced improved bond strength from untreated to treated were E-40FL, H4800, 435, and 332. Data analysis was performed on these adhesives to determine if the improvement in bond strength was statistically significant. Therefore, we used both Excel and Minitab to perform a t-test and F-test for the bond strength data from the following adhesives: E-40FL, H4800, 435, and 332.

2.2.2.1 Loctite® E-40FL™

F-Test Two-Sample for Variances

Table 3: F-Test for E-40FL		
	Untreated	Treated
Mean	493.5	562.7
Variance	10673	35410
Observations	10	10
df	9	9
F	0.301	
P(F<=f) one-tail	0.044	
F Critical one-tail	0.315	

From this result, since the p-value <0.05, at a 95% confidence level, we could conclude that the variances were statistically significantly different.

t-Test: Two-Sample Assuming Unequal Variances

Table 4: t-test for E-40FL		
	Untreated	Treated
Mean	493.5	562.7
Variance	10673	35410
Observations	10	10
Hypothesized Mean Difference	0	
df	14	
t Stat	-1.02	
P(T<=t) one-tail	0.165	
t Critical one-tail	1.76	
P(T<=t) two-tail	0.325	
t Critical two-tail	2.14	

From this result, since the p-value >0.05, at a 95% confidence level we could not prove that the differences in the means between the treated and untreated samples were statistically significant.

2.2.2.2 Loctite® H4800™

F-Test Two-Sample for Variances

Table 5: F-test for H4800		
	Untreated	Treated
Mean	2185.9	3319.8
Variance	70694	73684
Observations	10	10
df	9	9
F	0.959	
P(F<=f) one-tail	0.476	
F Critical one-tail	0.315	

From this result, since the p-value >0.05 , at a 95% confidence level, we could not conclude that the variances were statistically significantly different.

t-Test: Two-Sample Assuming Equal Variances

Table 6: t-test for H4800		
	Untreated	Treated
Mean	2185.9	3319.8
Variance	70694	73684
Observations	10	10
Pooled Variance	72189	
Hypothesized Mean Difference	0	
df	18	
t Stat	-9.44	
P(T<=t) one-tail	1.08E-08	
t Critical one-tail	1.73	
P(T<=t) two-tail	2.16E-08	
t Critical two-tail	2.10	

From this result, since the p-value is <0.05 , at a 95% confidence level we could assume that the differences in the means between the treated and untreated samples were statistically significant.

A graphical representation for the strength values obtained for H4800 is shown in the individual value plot shown below [Figure 22].

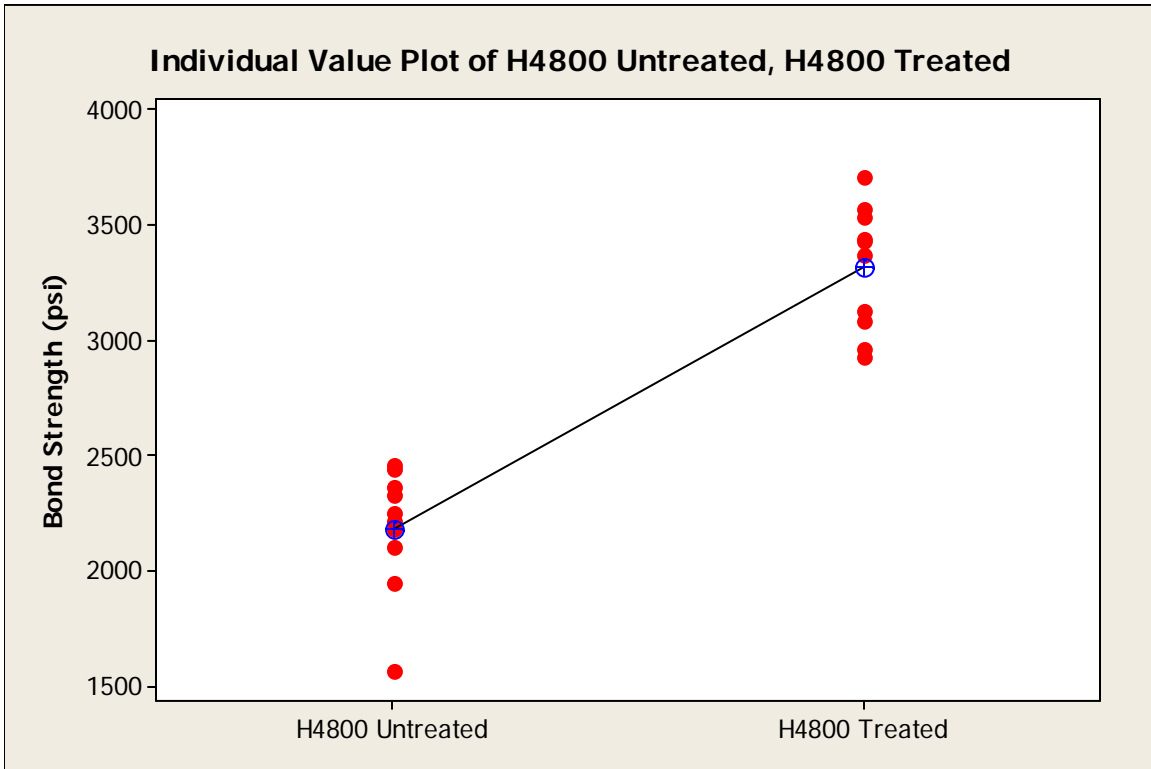


Figure 22: Individual Value Plot for H4800

The previous individual value plot presents the difference in the data from treated to untreated specimen while also identifying the scatter.

2.2.2.3 Loctite® 435™

F-Test Two-Sample for Variances

Table 7: F-test for 435		
	Untreated	Treated
Mean	1106.5	1671.8
Variance	172581	410221
Observations	10	10
df	9	9
F	0.421	
P(F<=f) one-tail	0.107	
F Critical one-tail	0.315	

From this result, since the p-value >0.05, at a 95% confidence level, we could not conclude that the variances were statistically significantly different.

t-Test: Two-Sample Assuming Equal Variances

Table 8: t-test for 435		
	Untreated	Treated
Mean	1106.5	1671.8
Variance	172581	410221
Observations	10	10
Pooled Variance	291401	
Hypothesized Mean Difference	0	
df	18	
t Stat	-2.34	
P(T<=t) one-tail	0.015	
t Critical one-tail	1.73	
P(T<=t) two-tail	0.031	
t Critical two-tail	2.10	

From this result, since the p-value is <0.05, at a 95% confidence level we could assume that the differences in the means between the treated and untreated samples were statistically significant.

A graphical representation for the strength values obtained for 435 is shown in the individual value plot shown below [Figure 23].

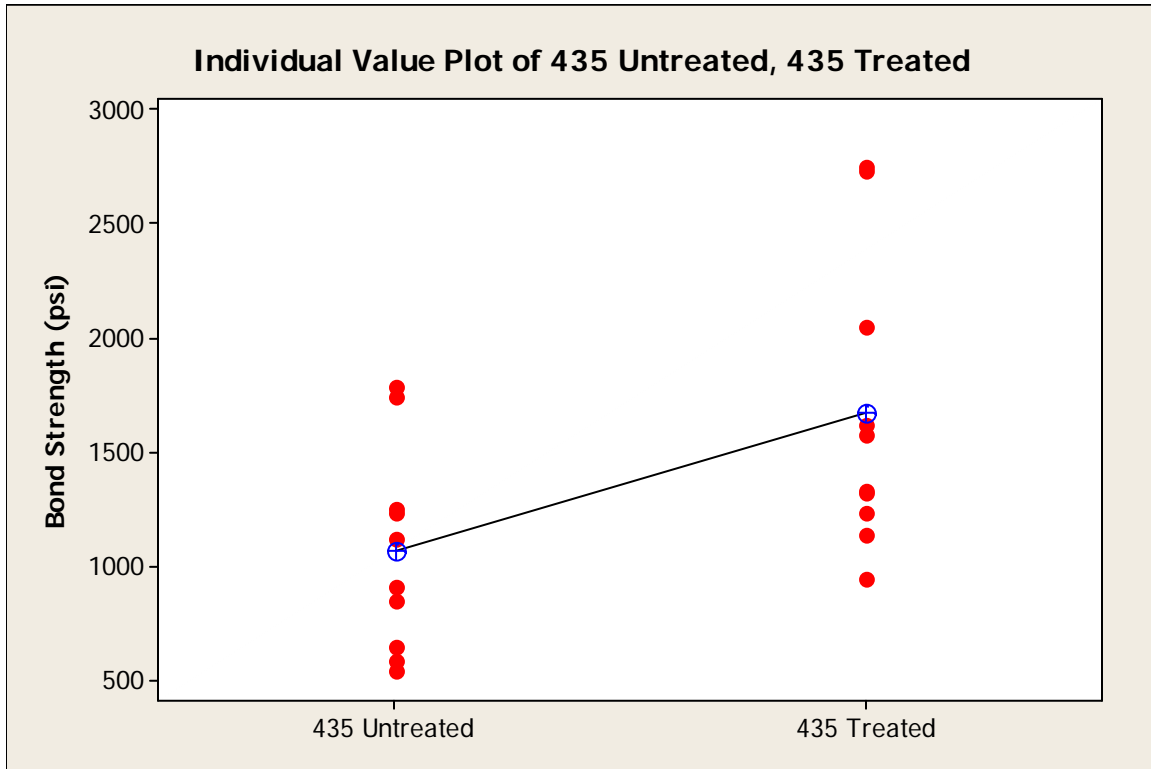


Figure 23: Individual Value Plot for 435

The previous individual value plot presents the difference in the data from treated to untreated specimen while also identifying the scatter.

2.2.2.4 Loctite® 332™

F-Test Two-Sample for Variances

Table 9: F-test for 332		
	Untreated	Treated
Mean	1619.2	1978.2
Variance	12339.73333	323025.2889
Observations	10	10
df	9	9
F	0.038200518	
P(F<=f) one-tail	2.0925E-05	
F Critical one-tail	0.314574906	

From this result, since the p-value <0.05, at a 95% confidence level, we could conclude that the variances were statistically significantly different.

t-Test: Two-Sample Assuming Unequal Variances

Table 10: t-test for 332		
	Untreated	Treated
Mean	1619.2	1978.2
Variance	12339.73333	323025.2889
Observations	10	10
Hypothesized Mean Difference	0	
df	10	
t Stat	-1.960358798	
P(T<=t) one-tail	0.03919477	
t Critical one-tail	1.812461102	
P(T<=t) two-tail	0.078389541	
t Critical two-tail	2.228138842	

From this result, since the p-value is <0.05, at a 95% confidence level we could assume that the differences in the means between the treated and untreated samples were statistically significant.

A graphical representation for the strength values obtained for 332 is shown in the individual value plot shown below [Figure 24].

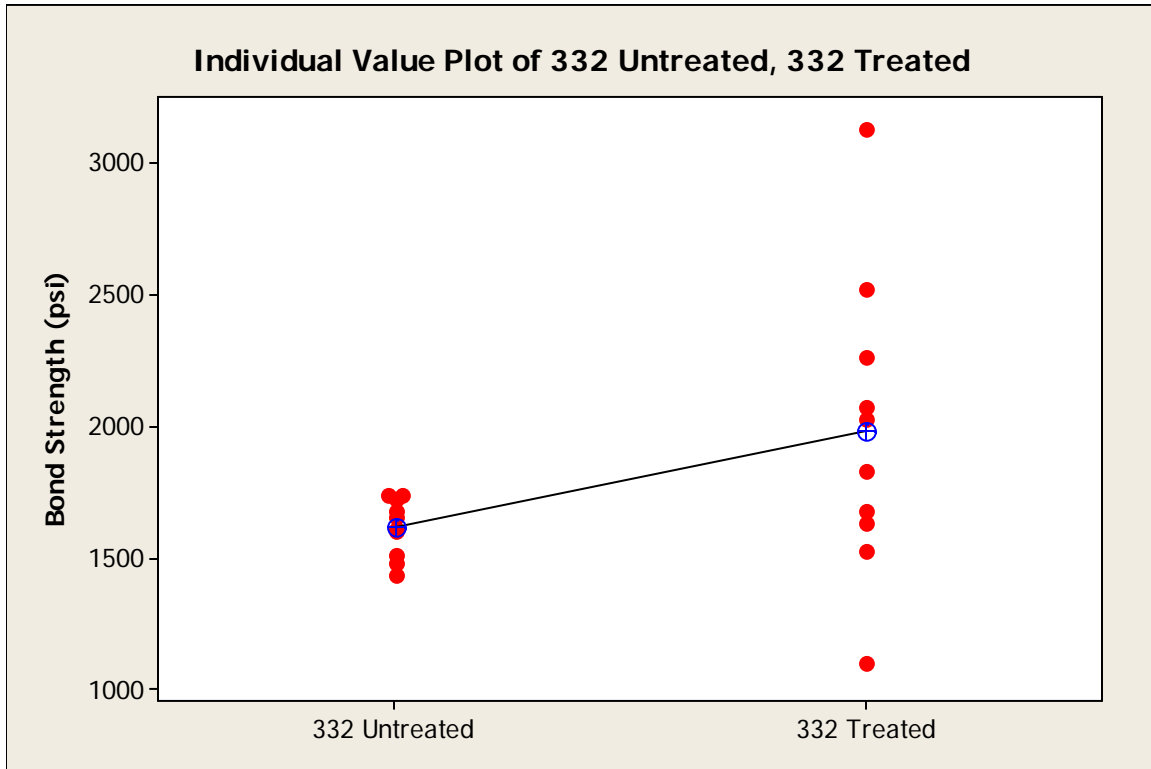


Figure 24: Individual Value Plot for 332

The previous individual value plot presents the difference in the data from treated to untreated specimen while also identifying the scatter.

It was observed that H4800 had the greatest mean difference in strength from untreated to treated specimens, a value of 1184 psi. According to the t-test for H4800, the difference in the means was also determined to be statistically significant, thus qualifying this to be the adhesive used to perform the upcoming bath degradation testing. Also, because 435 and 332 proved to have statistically significantly different means, these adhesives were also chosen to be used in the upcoming comparative analysis of different aluminum surface treatments. Since many of the treated specimens had

coefficients of variance above 15%, it was decided that a further test to discover whether or not an IPA wipe prior to bonding had any affect on the variance was appropriate.

2.3 Design of Experiments Using IPA Cleaning and Chromic Acid Etching Treatment

The variance in the results of the adhesive selection experiment was undesirable, therefore it was decided that further experimentation was warranted. It was important to investigate the reason for the variance, as one possible reason was some residue from the bath remained on the specimens [See Figure 25]. An additional cleaning method was proposed in which isopropyl alcohol (IPA) was applied to the treated area and wiped off prior to bonding. A Design of Experiments (DOE) analysis was created using Minitab to determine if the IPA cleaning process did have an effect on the variance as well as bond strength.



Figure 25: Residue that Remained on Specimen

2.3.1 Methodology

Minitab was used to perform a Design of Experiments investigation in which lap shears were etched with chromic acid and bonded with adhesive H4800, while others were bonded without treatment. Half of these were cleaned with isopropyl alcohol prior to bonding, while others were not. The test matrix, as shown in **Table 11**, indicates that only 5 replicates were performed at once and were let to cure for 72 hours.

Table 11: Design of Experiments Test Matrix					
Standard Order	Run Order	Treatment	Cleaning	Cure	Replicates
1	1	None	None	72 hr	5
4	2	Chromic Acid	IPA wipe	72 hr	5
5	3	None	None	72 hr	5
7	4	None	IPA wipe	72 hr	5
2	5	Chromic Acid	None	72 hr	5
6	6	Chromic Acid	None	72 hr	5
3	7	None	IPA wipe	72 hr	5
8	8	Chromic Acid	IPA wipe	72 hr	5

The lap shears were treated and cleaned in the exact order listed in the test matrix, and the same procedure for treating and bonding mentioned in section 2.2.1 was used in this experiment, except that half were sprayed with IPA then wiped off before the adhesive was applied.

2.3.2 Results & Discussion

The average bond strengths and the standard deviations of each of the 8 runs are shown in **Table 12**. It was apparent that cleaning the surface with isopropyl alcohol prior to bonding had little to no effect on the bond strength, while treating the aluminum with chromic acid had a significant effect on strengthening the bond of the adhesive.

Table 12: DOE Results for IPA Wipe Testing							
Standard Order	Run Order	Treatment	Cleaning	Average	Std. Dev.	Res. 1	Res. 2
1	1	none	none	1815	165	-3	0.5
4	2	treated	IPA wipe	2975	164	206	-206.5
5	3	none	none	1821	164	3	-0.5
7	4	none	IPA wipe	1956	42	80	-81
2	5	treated	none	2885	476	297.5	-200.5
6	6	treated	none	2290	877	-297.5	200.5
3	7	none	IPA wipe	1796	204	-80	81
8	8	treated	IPA wipe	2563	577	-206	206.5

Figure 26 is a graphical representation averaging the bond strengths of the 4 different types preparations used during this experiment.

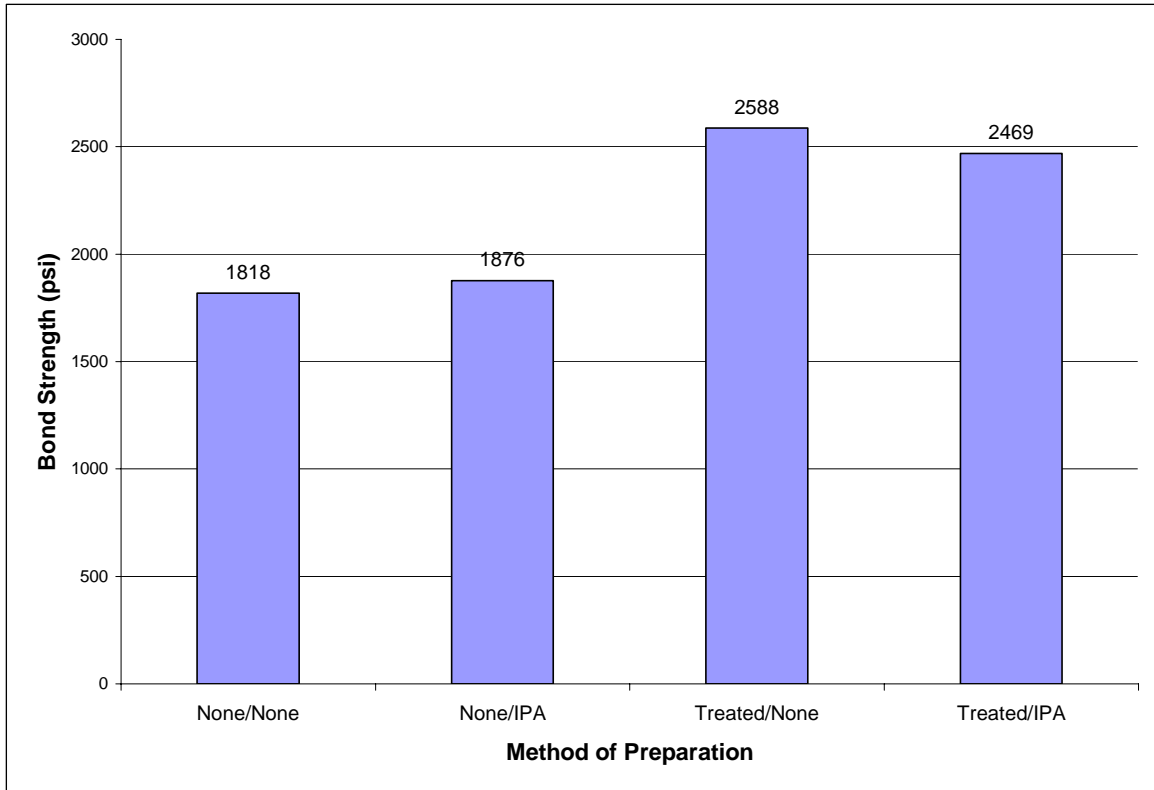


Figure 26: Averaged Bond Strength Results

The residuals indicate the difference between the averages of two similar runs. For example, the average of the means of runs 1 and 3 is 1818 and the residual 1 of each run is just the difference between the average of this particular run and the average of both runs. Residual 2 works the same way for the standard deviations of two similar runs.

Minitab performed a factorial fit for the average versus treatment and cleaning and for the standard deviation versus treatment and cleaning. The calculated P-value for average versus treatment was 0.011 and the P-value for standard deviation versus

treatment was 0.064 [see full Minitab results in Appendix D]. Because the P-value for average versus treatment was less than 0.05, it was proven that the means were statistically significantly different, indicating that treatment had an effect on average bond strength. The P-value for standard deviation versus treatment was slightly greater than 0.05, thus at a confidence interval of 95%, it could not be proven that the difference was statistically significant. However, at a confidence interval of 93.6%, it can be proven that the standard deviations are statistically significantly different from treated to untreated assemblies.

2.4 Post Treatment Cleaning Method Analysis

It was observed during previous analysis that the method used to clean the aluminum lap shears after they were taken out of the chromic acid bath often left behind a water stain that may have had an effect on bond strength, possibly contributing to large variances in bond strengths. The new proposed method involved wiping the lap shears clean with DI water and a Kimwipe (sterile tissues used in the Loctite® lab), as opposed to drying them in a convection oven at 80° C for 10 minutes. The surfaces of the etched aluminum appeared to be much cleaner after wiping them with Kimwipes, as shown in **Figure 27**, therefore an experiment was performed to determine if the new proposed cleaning method had a significant effect on the bond strength.



Figure 27: "New" Cleaning Method (right) vs. "Old" Cleaning Method (right)

2.4.1 Methodology

10 replicates were treated in the chromic acid bath in the same manner as discussed in section 2.2.1. After being sprayed with de-ionized water, they were placed in the oven at 80 degrees Celsius for 10 minutes. Once removed from the oven, the etched surfaces were cleaned with isopropyl alcohol prior to bonding. Again, the lap shears were bonded with adhesive H4800 in the same procedure as outlined in section 2.2.1 and let to cure for 48 hours.

An additional 10 replicates were treated in the chromic acid bath, but instead of being placed in the oven for 10 minutes, they were hand wiped with Kimwipes, ensuring no water or residue remained on the surface when complete. Like the “oven dried” specimens, they were then cleaned with isopropyl alcohol prior to bonding and let to cure for 48 hours.

2.4.2 Results & Discussion

Once the bonded lap shears were allowed to cure for 48 hours, the bond strengths were determined using STM 700 on the Instron machine, as discussed in section 2.2.1. The bond strengths of the two different cleaning methods are shown in **Table 13**.

Table 13: Bond Strength Results				
Replicate	Cleaning Method			
	"Old"		"New"	
	Strength [psi]	Failure Mode	Strength [psi]	Failure Mode
1.	1008	Adh/Coh	3137	Cohesive
2.	1519	Adh/Coh	3406	Cohesive
3.	1367	Adh/Coh	3219	Cohesive
4.	2282	Adh/Coh	3400	Cohesive
5.	1059	Adh/Coh	3498	Cohesive
6.	1267	Adh/Coh	3886	Cohesive
7.	1972	Adh/Coh	3445	Cohesive
8.	2518	Adh/Coh	3663	Cohesive
9.	2054	Adh/Coh	3209	Cohesive
10.	1196	Adh/Coh	4160	Cohesive
Average	1624		3502	
Stand. Dev.	540		321	
COV	0.332		0.092	
Minimum	1008		3137	

A one-way ANOVA analysis was performed using Minitab and is shown in

Figure 28 below:

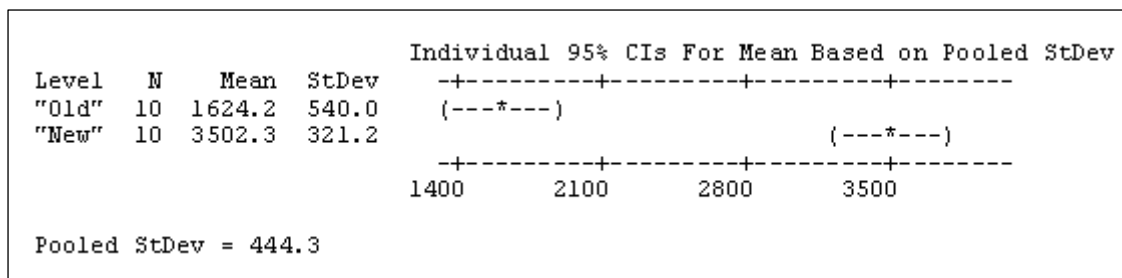


Figure 28: ANOVA Analysis for Cleaning Methods

As shown in the data, the average bond strength of the assemblies cleaned using the “Old” method were considerably less than those cleaned using the “New” method. On average, the new cleaning method produced bond strengths more than double those achieved from the old cleaning method using the oven (1624 psi vs. 3502 psi).

According to the Minitab analysis, since the p-value was less than 0.05, at a 95% confidence interval, it was proven that the bond strengths were statistically significantly different. This can be interpreted visually on the above Minitab output in which the distributions of the two sets of data do not overlap. Therefore, it was concluded that the new cleaning method using Kimwipes instead of an oven after acid treatment should be used in the overall chromic acid etching process at Henkel Corporation.

2.5 Bath Degradation Testing

After a certain number of lap shears are treated in the chromic acid, the bath will eventually begin to degrade, as indicated by the chemical equation shown in section 2.2.1, when aluminum reacts with chromic acid (sulfuric acid and sodium dichromate). The bond strengths of the treated assemblies will be a direct reflection of this bath degradation, as the oxide layer on the surface of aluminum will become thinner. Henkel should never receive a single order requiring more than 500 aluminum lap shears to be treated at once, so it was essential to determine if treating 500 specimens would degrade the bath. To be safe, it was decided that 1000 lap shears were to be treated before analyzing the chromic acid bath. However, treating 1000 lap shears would be rather tedious, and instead a calculated amount of aluminum powder was added to the acid bath to simulate 1000 lap shears. Specimens were treated before and after the addition of the aluminum powder, bonded, and tested for their bond strengths. The shear strengths of assemblies before and after the 1000 lap shear simulation were then compared and determined if the differences were statistically significant. Two specimens (1 before addition of Al powder, 1 after addition of Al powder) were submitted for energy dispersive X-ray spectroscopy (EDS) analysis to determine the chromium content on the etched surface of the aluminum. Two liquid samples (1 before addition of Al powder, 1 of after addition of Al powder) of the acid bath were submitted for ICP-AES (Inductively Coupled Plasma-Atomic Emission Spectroscopy) to determine the chromium content in solution. If the bond strengths between the two runs were proven to be statistically significantly different, it would be confirmed that the bath did degrade before 1000 lap

shears were treated and a critical ratio of chromium to aluminum content could later be determined.

2.5.1 Methodology

A fresh bath of chromic acid was prepared and 10 lap shear replicates were treated using the same procedure used throughout the project and cleaned using Kimwipes as discussed in the previous experiment. They were then bonded with adhesive H4800 and let to cure for 48 hours.

0.16 grams of aluminum powder was added to the acid bath to simulate 1000 aluminum lap shears [**calculations shown in Appendix E**], and 10 more replicates were treated, cleaned, and bonded in the same procedure as those before the powder was added. For both runs, a designated test specimen was submitted for energy dispersive X-ray spectroscopy (EDS) analysis to determine the chromium content on the etched surface of the aluminum, according to ASTM E1508-93a [**see Appendix F for ASTM E1508-93a**]. The EDS analysis was conducted using a Kevex detector attached to Hitachi S-570 SEM. An accelerating voltage of 20 KeV and a sampling scan duration of 200 seconds was used for data collection.

Also an approximate 3 mL sample of the chromic acid bath was taken before and after the addition of aluminum powder and submitted for ICP-AES (Inductively Coupled Plasma-Atomic Emission Spectroscopy) to determine the chromium content in solution. These liquid samples were tested and analyzed according to STM-40 [**See Appendix G for STM-40**] using a Varian Vista. 0.2 grams of the sample was diluted to 25 mL with de-ionized water and a 10 fold dilution was then prepared and analyzed.

2.5.2 Results & Discussion

The bonded assemblies were pulled using the Instron machine according to STM-700 and the maximum bond strengths of the two runs are shown in **Table 14**.

Table 14: Bath Degradation Results				
Replicate	Bath Condition			
	Before Addition of Al Powder		After Addition of Al Powder	
	Strength [psi]	Failure Mode	Strength [psi]	Failure Mode
1.	3538	Cohesive	3173	Cohesive
2.	3383	Cohesive	3405	Cohesive
3.	3425	Cohesive	3586	Cohesive
4.	3586	Cohesive	3709	Cohesive
5.	3345	Cohesive	3676	Cohesive
6.	3285	Cohesive	3262	Cohesive
7.	3132	Cohesive	3089	Cohesive
8.	2944	Cohesive	3493	Cohesive
9.	3108	Cohesive	3392	Cohesive
10.	3455	Cohesive	3467	Cohesive
Average	3320		3425	
Stand. Dev.	204		206	
COV	0.061		0.060	
Minimum	2944		3089	

A one-way ANOVA analysis was performed using Minitab and is shown in **Figure 29** below:

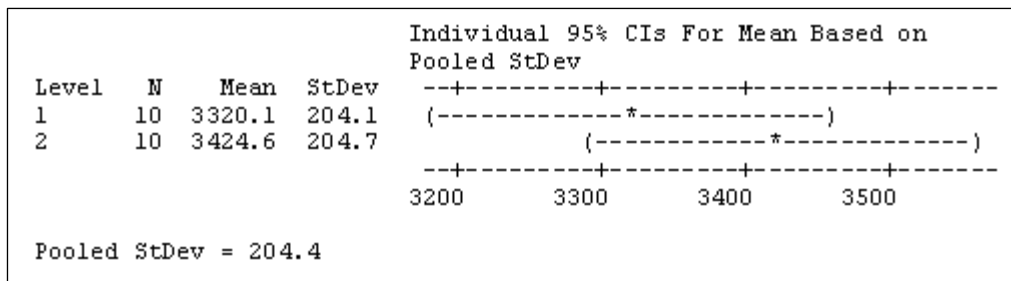


Figure 29: ANOVA Analysis for Bath Degradation Testing

According to the Minitab analysis, no statistical significant difference in bond strength from the fresh to degraded chromic acid bath can be determined. Since the P-value was greater than 0.05, with a 95% confidence interval, it could not be proven that the difference in the means between the fresh and degraded samples was statistically significant.

The EDS spectrum of the etched area of the aluminum lap shear sample before the addition of aluminum powder is shown in **Figure 30**, and the spectrum after the addition of aluminum powder is shown in **Figure 31**.

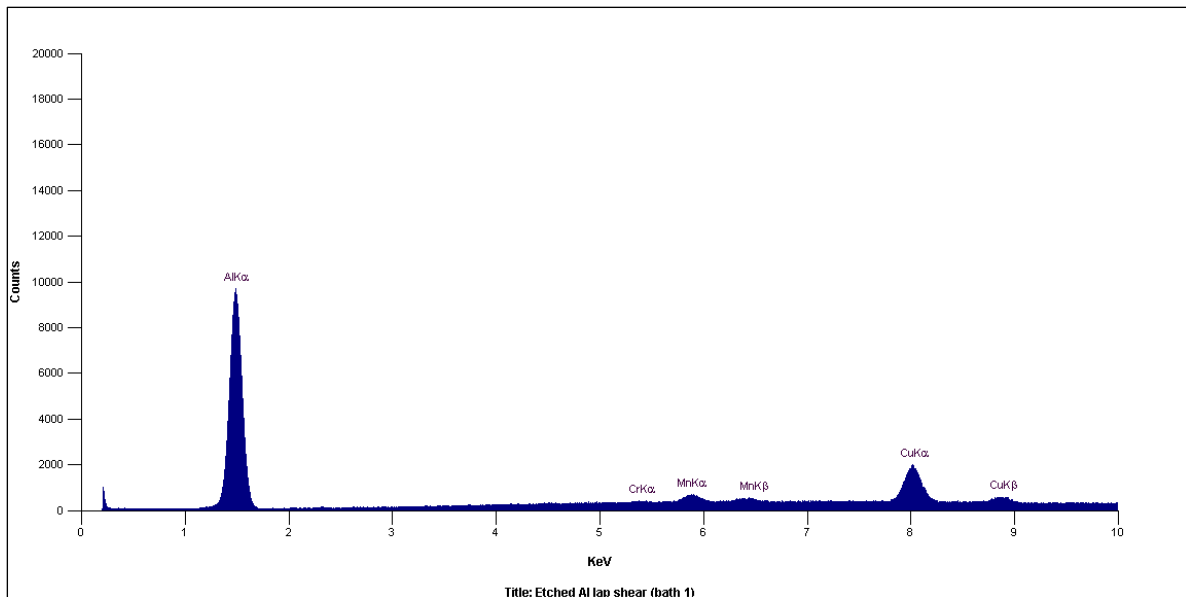


Figure 30: EDS Spectrum of Aluminum on Etched Surface, Fresh Bath

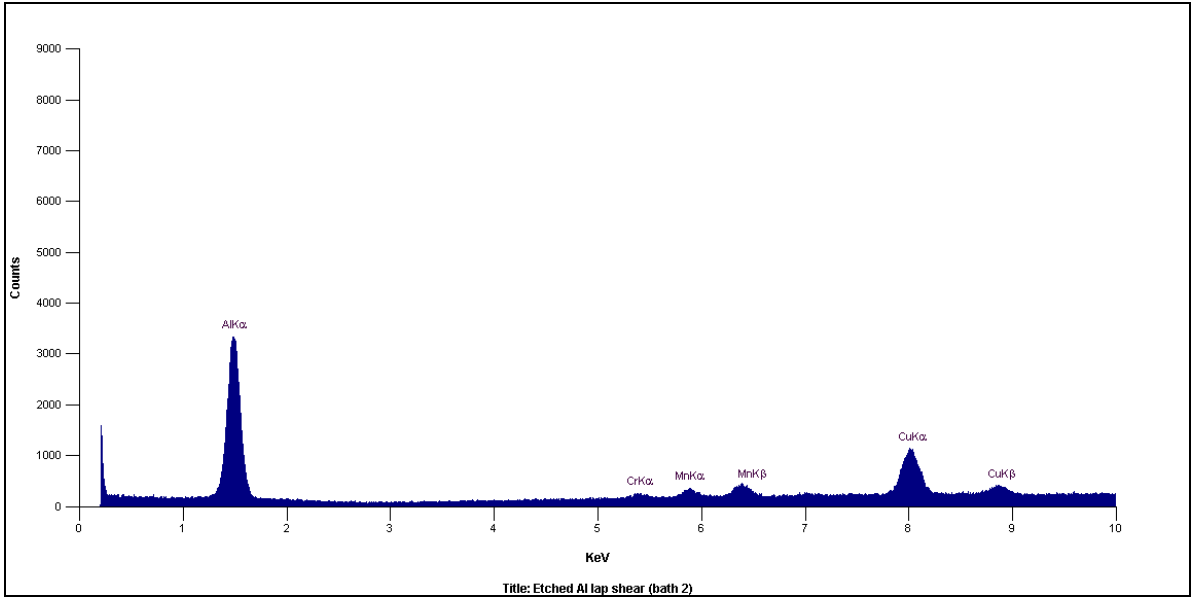


Figure 31: EDS Spectrum of Aluminum on Etched Surface, Degraded Bath

According to these EDS spectrums, the etched area of the aluminum lap shear treated before aluminum powder was added contained 63.9 weight % aluminum, 0.52 weight % chromium, 3.49 weight % manganese, and 32.05 weight % copper. The lap shear treated after the addition of aluminum powder contained 56.10 weight % aluminum, 1.59 weight % chromium, 3.89 weight % manganese, and 38.43 weight % copper.

The ICP-AES revealed that the chromium content of the acid bath before the addition of aluminum powder was 1.45 % and the chromium content after the addition of aluminum powder was 1.24 %.

It was concluded that after the addition of 0.16 grams of aluminum powder to the chromic acid bath (simulating 1000 lap shears), no significant difference in bond strength was apparent, warranting no further investigative analysis of the physical data obtained on the etched surfaces and acid bath samples.

2.6 Comparative Analysis Study on Chemical Surface Treatments for Aluminum

A comparative analysis study was performed on multiple chemical surface preparation techniques for aluminum prior to adhesion bonding. Five of the most commonly used surface treatment techniques in industry were chosen to be used on aluminum lap shears: sulfuric acid anodizing, sulfuric "hard" anodizing, chromic acid etching, chromic acid anodizing and phosphoric acid anodizing [See Figure 1]. The experiment used three different adhesives (H4800, 435, and 332), which were chosen from the adhesive selection process because they produced higher mean bond strengths after surface treatment. Treated assemblies along with the control (untreated aluminum) underwent heat aging and humidity testing for a period of two weeks. After environmental conditioning was complete, the data was analyzed to determine the best chemical surface treatment for maximizing bond strength and minimizing variance. Once the ideal treatment was identified, other variables such as cost, safety, and time efficiency were taken into consideration for the final determination of the best chemical surface treatment to be used at Henkel in the future.

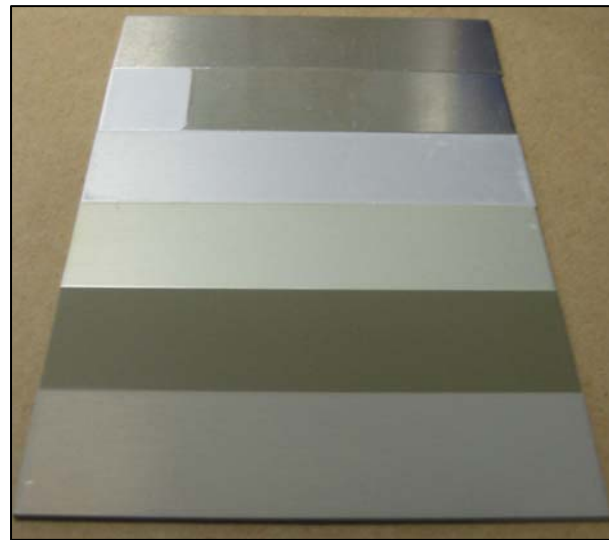


Figure 32: (Near to Far) Chromic Acid Anodized, Sulfuric "Hard" Anodized, Phosphoric Acid Anodized, Sulfuric Acid Anodized, Chromic Acid Etched, No Treatment

2.6.1 Methodology

Aluminum lap shears were treated and bonded as shown in the test matrix in **Table 15**.

Table 15: Comparative Analysis Experimental Test Matrix				
Run	Adhesive	Treatment	Conditioning	Replicates
1	H4800	Chromic Acid Etch	None	10
2	H4800	Chromic Acid Etch	Salt Fog	10
3	H4800	Chromic Acid Etch	Condensing Humidity	10
4	H4800	Chromic Acid Etch	125° C	10
5	H4800	Chromic Acid Etch	175° C	10
6	435	Chromic Acid Etch	None	10
7	435	Chromic Acid Etch	Salt Fog	10
8	435	Chromic Acid Etch	Condensing Humidity	10
9	435	Chromic Acid Etch	100° C	10
10	435	Chromic Acid Etch	125° C	10
11	332/7387	Chromic Acid Etch	None	10
12	332/7387	Chromic Acid Etch	Salt Fog	10
13	332/7387	Chromic Acid Etch	Condensing Humidity	10
14	332/7387	Chromic Acid Etch	125° C	10
15	332/7387	Chromic Acid Etch	175° C	10
16	H4800	Chromic Acid Anodized	None	10
17	H4800	Chromic Acid Anodized	Salt Fog	10
18	H4800	Chromic Acid Anodized	Condensing Humidity	10
19	H4800	Chromic Acid Anodized	125° C	10
20	H4800	Chromic Acid Anodized	175° C	10
21	435	Chromic Acid Anodized	None	10
22	435	Chromic Acid Anodized	Salt Fog	10
23	435	Chromic Acid Anodized	Condensing Humidity	10
24	435	Chromic Acid Anodized	100° C	10
25	435	Chromic Acid Anodized	125° C	10
26	332/7387	Chromic Acid Anodized	None	10
27	332/7387	Chromic Acid Anodized	Salt Fog	10
28	332/7387	Chromic Acid Anodized	Condensing Humidity	10
29	332/7387	Chromic Acid Anodized	125° C	10
30	332/7387	Chromic Acid Anodized	175° C	10
31	H4800	Sulfuric Acid Anodized	None	10
32	H4800	Sulfuric Acid Anodized	Salt Fog	10

Table 16: Comparative Analysis Experimental Test Matrix

Run	Adhesive	Treatment	Conditioning	Replicates
33	H4800	Sulfuric Acid Anodized	Condensing Humidity	10
34	H4800	Sulfuric Acid Anodized	125° C	10
35	H4800	Sulfuric Acid Anodized	175° C	10
36	435	Sulfuric Acid Anodized	None	10
37	435	Sulfuric Acid Anodized	Salt Fog	10
38	435	Sulfuric Acid Anodized	Condensing Humidity	10
39	435	Sulfuric Acid Anodized	100° C	10
40	435	Sulfuric Acid Anodized	125° C	10
41	332	Sulfuric Acid Anodized	None	10
42	332	Sulfuric Acid Anodized	Salt Fog	10
43	332	Sulfuric Acid Anodized	Condensing Humidity	10
44	332	Sulfuric Acid Anodized	125° C	10
45	332/7387	Sulfuric Acid Anodized	175° C	10
46	H4800	Sulfuric 'Hard' Anodized	None	10
47	H4800	Sulfuric 'Hard' Anodized	Salt Fog	10
48	H4800	Sulfuric 'Hard' Anodized	Condensing Humidity	10
49	H4800	Sulfuric 'Hard' Anodized	125° C	10
50	H4800	Sulfuric 'Hard' Anodized	175° C	10
51	435	Sulfuric 'Hard' Anodized	None	10
52	435	Sulfuric 'Hard' Anodized	Salt Fog	10
53	435	Sulfuric 'Hard' Anodized	Condensing Humidity	10
54	435	Sulfuric 'Hard' Anodized	100° C	10
55	435	Sulfuric 'Hard' Anodized	125° C	10
56	332/7387	Sulfuric 'Hard' Anodized	None	10
57	332/7387	Sulfuric 'Hard' Anodized	Salt Fog	10
58	332/7387	Sulfuric 'Hard' Anodized	Condensing Humidity	10
59	332/7387	Sulfuric 'Hard' Anodized	125° C	10
60	332/7387	Sulfuric 'Hard' Anodized	175° C	10
61	H4800	Phosphoric Acid Anodized	None	10
62	H4800	Phosphoric Acid Anodized	Salt Fog	10
63	H4800	Phosphoric Acid Anodized	Condensing Humidity	10
64	H4800	Phosphoric Acid Anodized	125° C	10
65	H4800	Phosphoric Acid Anodized	175° C	10
66	435	Phosphoric Acid Anodized	None	10
67	435	Phosphoric Acid Anodized	Salt Fog	10
68	435	Phosphoric Acid Anodized	Condensing Humidity	10

Table 17: Comparative Analysis Experimental Test Matrix				
Run	Adhesive	Treatment	Conditioning	Replicates
69	435	Phosphoric Acid Anodized	100° C	10
70	435	Phosphoric Acid Anodized	125° C	10
71	332/7387	Phosphoric Acid Anodized	None	10
72	332/7387	Phosphoric Acid Anodized	Salt Fog	10
73	332/7387	Phosphoric Acid Anodized	Condensing Humidity	10
74	332/7387	Phosphoric Acid Anodized	125° C	10
75	332/7387	Phosphoric Acid Anodized	175° C	10
76	H4800	None	None	10
77	H4800	None	Salt Fog	10
78	H4800	None	Condensing Humidity	10
79	H4800	None	125° C	10
80	H4800	None	175° C	10
81	435	None	None	10
82	435	None	Salt Fog	10
83	435	None	Condensing Humidity	10
84	435	None	100° C	10
85	435	None	125° C	10
86	332/7387	None	None	10
87	332/7387	None	Salt Fog	10
88	332/7387	None	Condensing Humidity	10
89	332/7387	None	125° C	10
90	332/7387	None	175° C	10

Note:

- The condensing humidity chamber operated at 50°C.
- See **Appendix H** for operating conditions of the salt fog chamber.

All 5 types of surface treated aluminum lap shears and the non-treated laps were bonded in the same manner as described in section 2.2.1. The chromic acid etched specimens were treated on site in the same procedure outlined in section 2.2.1 and the sulfuric acid anodized samples were taken from inventory at Henkel-Loctite. Aluminum lap shears were sent out to various companies to be phosphoric acid anodized, sulfuric “hard” anodized, and chromic acid anodized. The addresses for these companies are as follows:

Chromic Acid Anodized:

Plainville Plating Company
21 Forestville Ave
Plainville, CT 06062

See Appendix I for specifications on treatment methods used.

Sulfuric “Hard” Anodized:

Plainville Plating Company
21 Forestville Ave
Plainville, CT 06062

See Appendix J for specifications on treatment methods used.

Phosphoric Acid Anodized:

Aerospace Defense Coatings of Georgia
7700 N. Industrial Blvd
Macon, GA 31206

See Appendix K for specifications on treatment methods used.

2.6.2 Results & Discussion

In this section the results are presented in a specific structure. First, they are presented with respect to conditioning, more specifically, how all the bonded assemblies compared when they were exposed to specific environmental conditioning. Next, they are presented with respect to surface treatment, where it shows how a specific surface treatment reacted after being exposed to various environmental conditions.

See Appendix L for full tabulation of results

2.6.2.1 Results by Conditioning

2.6.2.1.1 Unconditioned Assemblies

Table 18 presents a summary of the results obtained for the unconditioned assemblies.

Table 18: No Conditioning – Pulled After at Least 72 Hours							
Adhesive		Aluminum Surface Treatment					
		None	Chromic Acid Etch	Chromic Acid Anodize	Sulfuric Anodize	Sulfuric “Hard” Anodize	Phosphoric Acid Anodize
H4800	Average Strength (psi)	2217	2845	2563	2709	2614	2910
	Stand. Dev.	921	570	116	349	362	202
	COV	0.415	0.201	0.045	0.129	0.139	0.069
	Minimum	682	2164	2412	2223	1767	2546
435	Average Strength (psi)	2104	2522	2264	1687	2394	3609
	Stand. Dev.	243	241	142	203	137	178
	COV	0.116	0.096	0.063	0.120	0.057	0.049
	Minimum	1870	2196	1969	1195	2215	3256
332	Average Strength (psi)	1871	2998	2129	2511	834	2174
	Stand. Dev.	100	184	96	223	406	142
	COV	0.053	0.061	0.045	0.089	0.487	0.065
	Minimum	1695	2580	1982	1971	285	1959

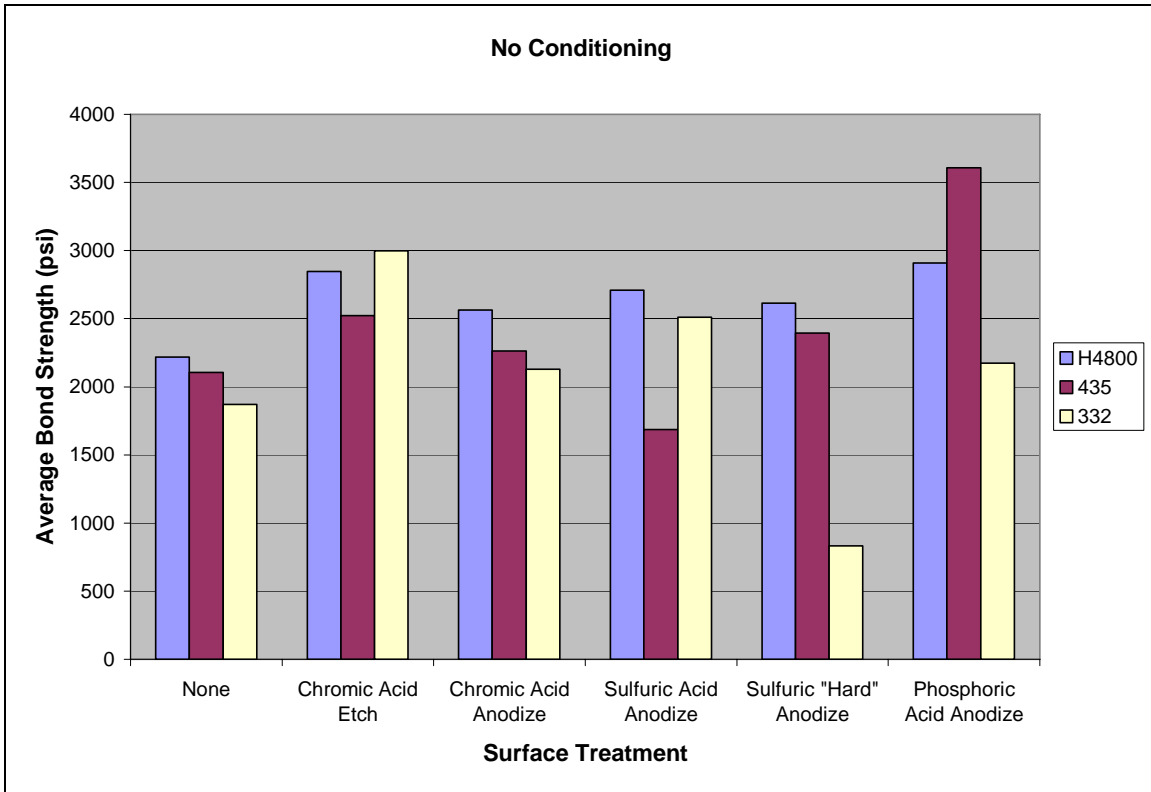


Figure 33: Bond Strength vs. Surface Treatment (No Conditioning)

As shown in **Figure 33**, bond strength varied greatly by not only treatment method, but also by adhesive type. To organize this data, each adhesive type was analyzed separately using Minitab.

2.6.2.1.1.1 Loctite® H4800™

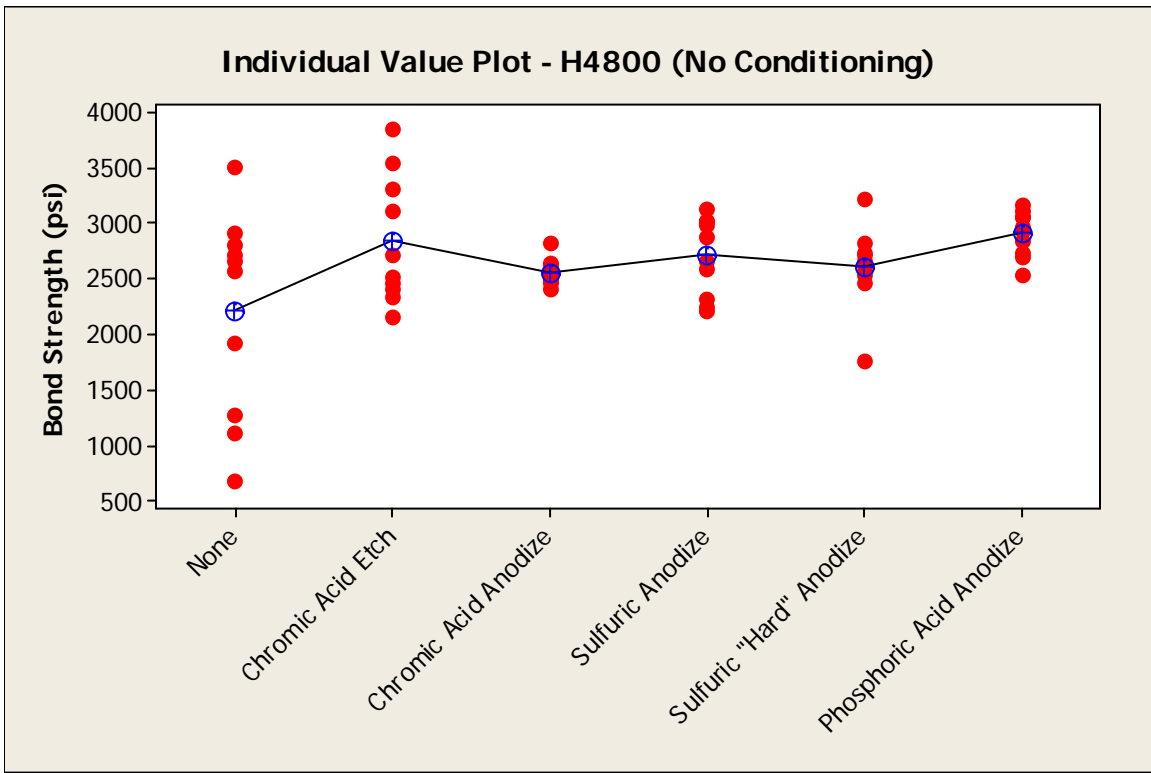


Figure 34: Individual Value Plot - H4800 (No Conditioning)

The above individual value [See Figure 34] plot may also be referred to as a scatter plot. Essentially, it plots every single bond strength result obtained for each particular surface treatment. It gives the viewer an idea to the amount of scatter associated with each run.

Shown in **Figure 35** is a method of statistical analysis known as Tukey's. The lower and upper values of the Tukey analysis represent the difference in the range of bond strengths of the treated assemblies from the bond strengths of the control assemblies. If a given treatment had all positive values from lower to upper, it proved that the bond strengths were statistically significantly stronger than the non-treated samples at a 95 % confidence

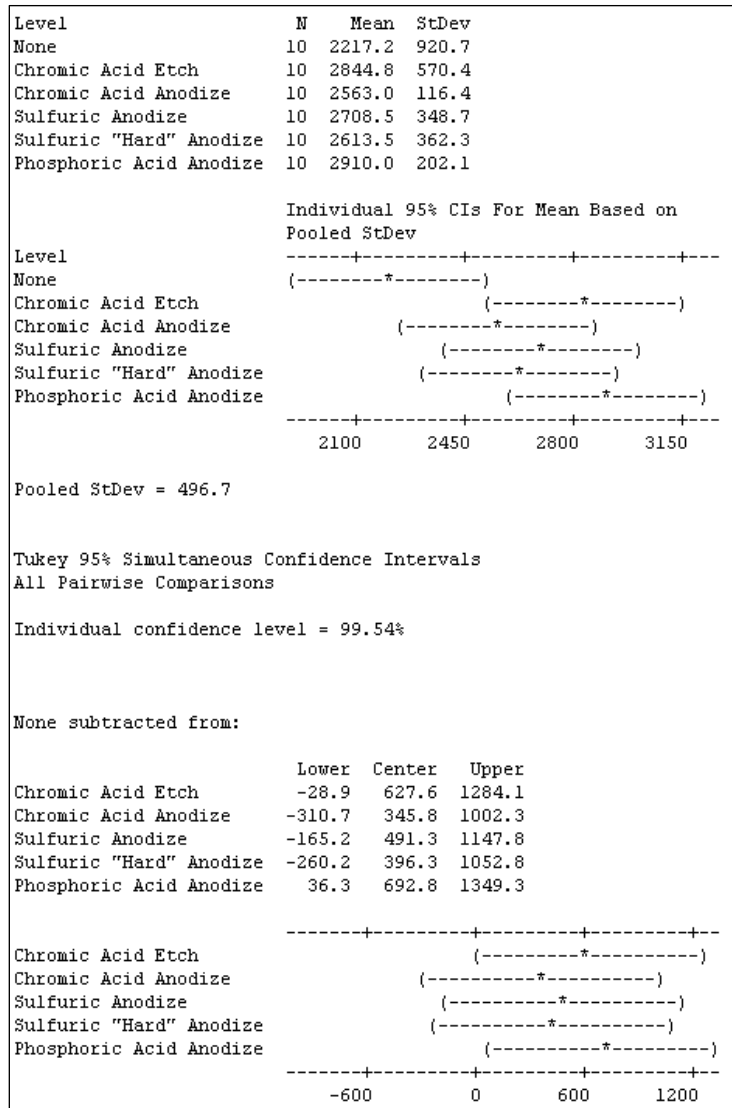


Figure 35: Tukey's Analysis - H4800 (No Conditioning)

interval. On the other hand, if a given treatment had all negative values from lower to upper, it would prove that the bond strengths were statistically significantly weaker than then non-treated samples at a 95% confidence interval. Lastly, if a given treatment contained the value zero from lower to upper, it could not be proven that the bond strengths were statistically significantly different at a 95% confidence interval.

Ranked Average Bond Strengths (psi) – H4800 (No Conditioning):

1. Phosphoric Acid Anodize (2910)*
2. Chromic Acid Etch (2845)
3. Sulfuric Anodize (2709)
4. Sulfuric “Hard” Anodize (2614)
5. Chromic Acid Anodize (2563)
6. None (2217)

According to the Tukey analysis [See Figure 35], only one of the previous surface treatments had a greater average bond strength that proved to be statistically significantly different from the control (None) at a 95% confidence interval. The lower and upper values of the Tukey analysis represent the difference in the range of bond strengths of the treated assemblies from the bond strengths of the control assemblies. Since phosphoric acid anodizing had all positive values from lower to upper, it proved that the bond strengths were statistically significantly better than the non-treated samples at a 95 % confidence interval.

2.6.2.1.1.2 Loctite® 435™

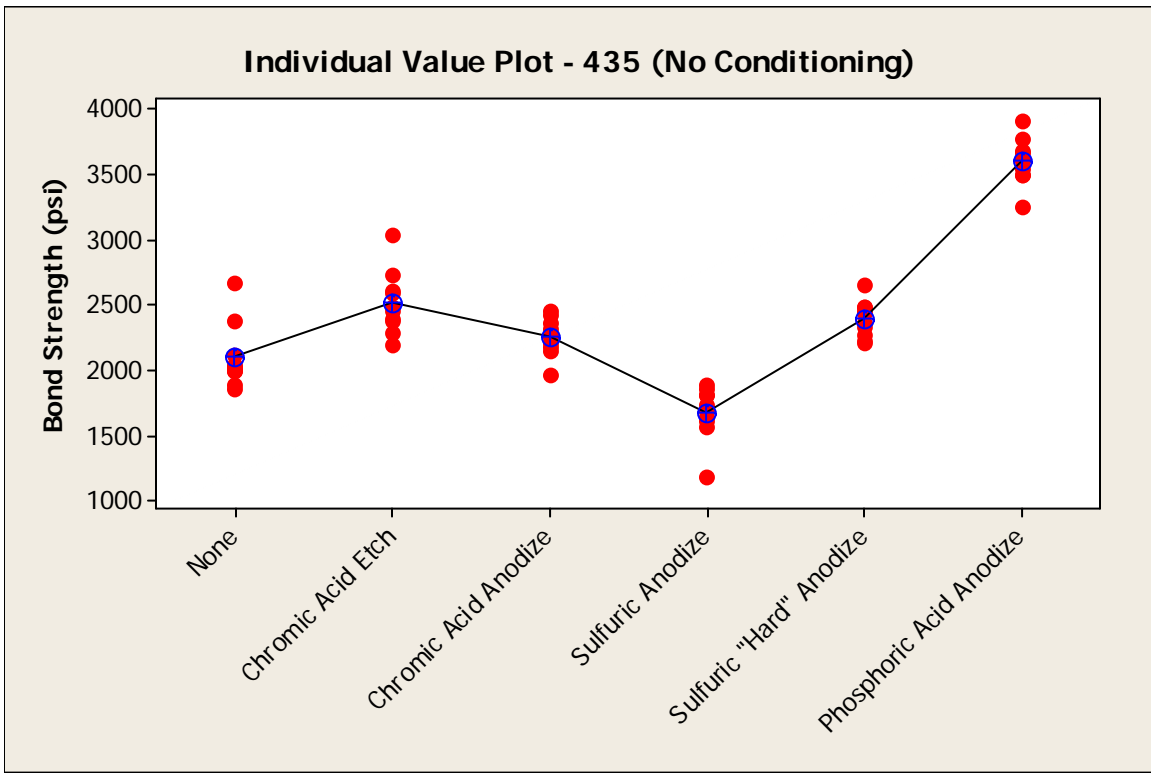


Figure 36: Individual Value Plot - 435 (No Conditioning)

The previous individual value plot presents the difference in the data for all surface treatments evaluated while also identifying the scatter.

Ranked Average Bond Strengths (psi) – 435 (No Conditioning):

1. Phosphoric Acid Anodize (3609)*
2. Chromic Acid Etch (2522)*
3. Sulfuric “Hard” Anodize (2394)*
4. Chromic Acid Anodize (2264)
5. None (2104)
6. Sulfuric Anodize (1687)

According to the Tukey analysis [See Figure 37], phosphoric acid anodize, chromic acid etch & sulfuric “hard” anodize all had greater average bond strengths that proved to be statistically significantly different from the control (None) at a 95% confidence interval.

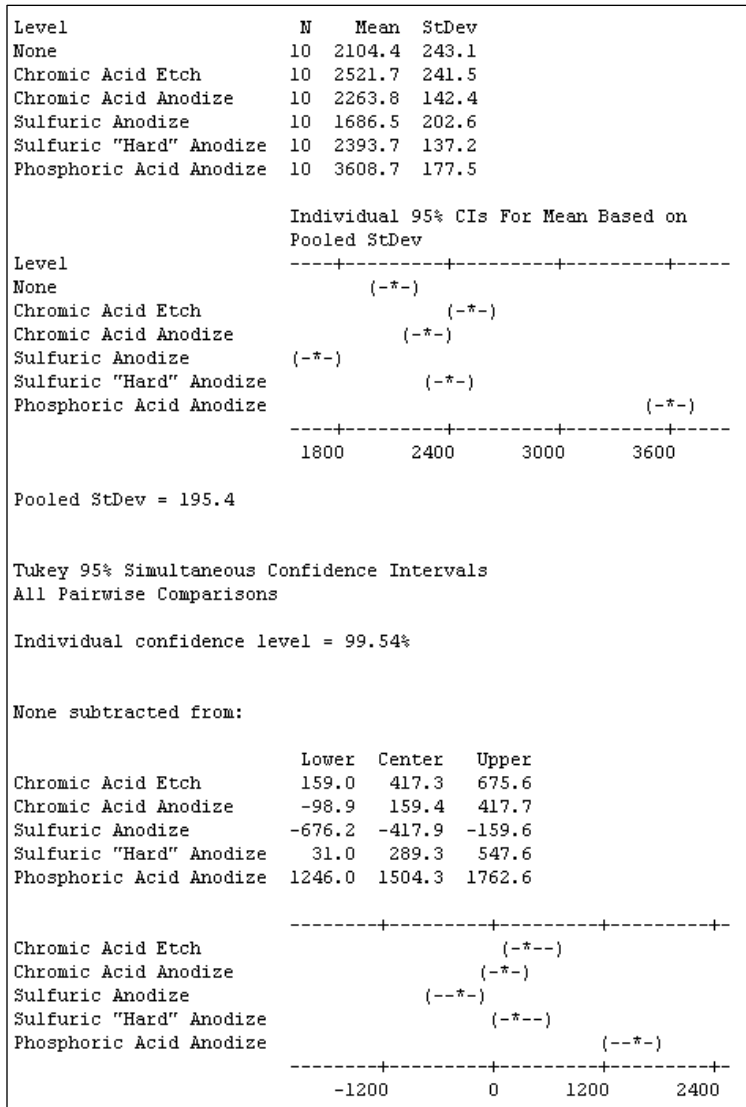


Figure 37: Tukey's Analysis - 435 (No Conditioning)

2.6.2.1.1.3 Loctite® 332™

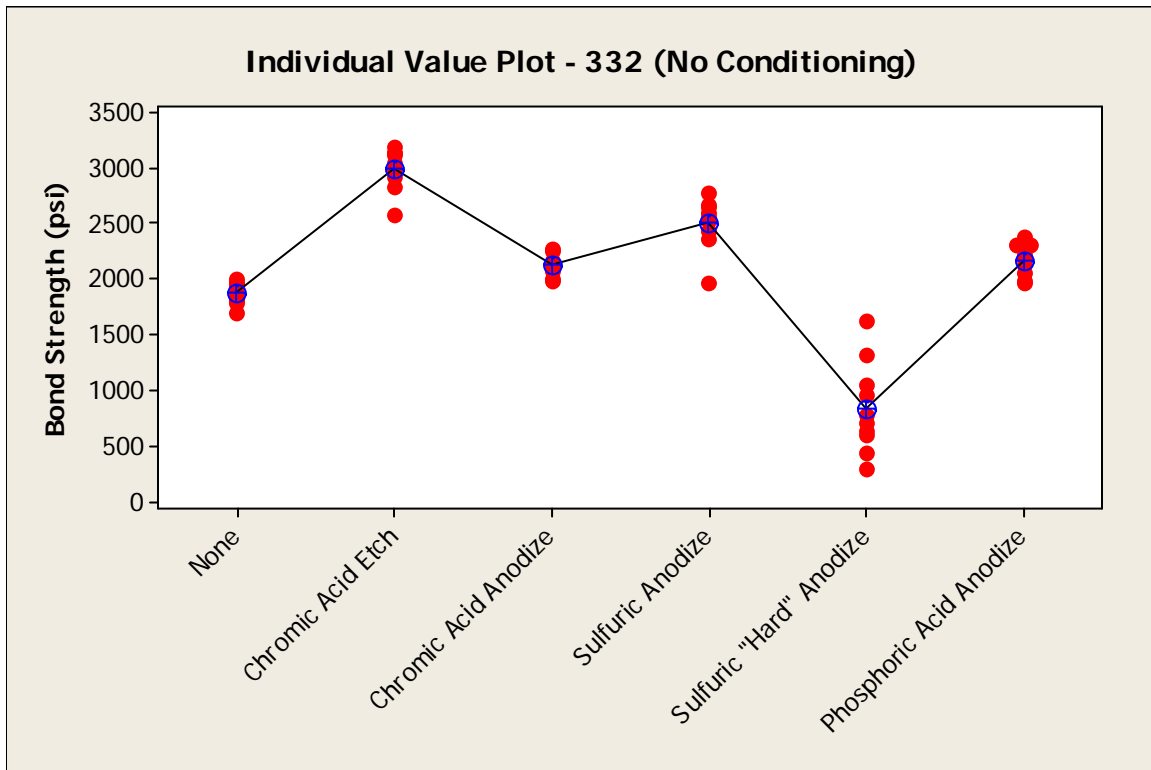


Figure 38: Individual Value Plot - 332 (No Conditioning)

The previous individual value plot presents the difference in the data for all surface treatments evaluated while also identifying the scatter.

Ranked Average Bond Strengths (psi) – 332 (No Conditioning):

1. Chromic Acid Etch (2998)*
2. Sulfuric Anodize (2511)*
3. Phosphoric Acid Anodize (2174)*
4. Chromic Acid Anodize (2129)
5. None (1871)
6. Sulfuric Hard Anodize (834)

According to the Tukey analysis [See Figure 39], chromic acid etch, sulfuric anodize & phosphoric acid anodize all had greater average bond strengths that proved to be statistically significantly different from the control (None) at a 95% confidence interval.

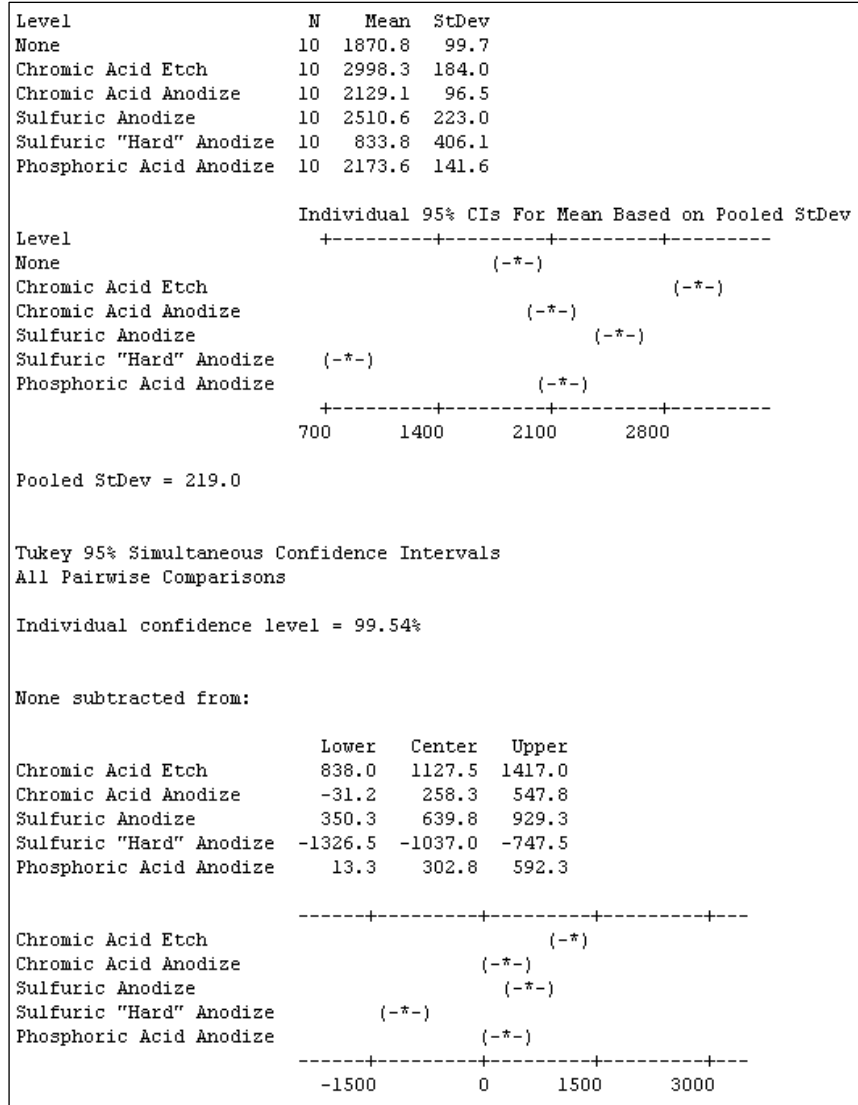


Figure 39: Tukey's Analysis - 332 (No Conditioning)

2.6.2.1.2 Salt Fog Conditioned Assemblies

Table 19 presents a summary of the results obtained for the salt fog assemblies.

Table 19: Salt Fog Conditioning Results							
Adhesive		Aluminum Surface Treatment					
		None	Chromic Acid Etch	Chromic Acid Anodize	Sulfuric Anodize	Sulfuric "Hard" Anodize	Phosphoric Acid Anodize
H4800	Average Strength (psi)	2058	1334	2351	2562	1900	3005
	Stand. Dev.	406	790	306	244	176	494
	COV	0.197	0.592	0.130	0.095	0.093	0.164
	Minimum	2058	1334	2351	2562	1900	3005
435	Average Strength (psi)	0	64	2296	1278	2203	3468
	Stand. Dev.	0	202	356	130	147	441
	COV	--	3.162	0.155	0.102	0.067	0.127
	Minimum	0	64	2296	1278	2203	3468
332	Average Strength (psi)	1247	1540	1921	2436	549	2094
	Stand. Dev.	222	671	166	167	279	76
	COV	0.178	0.436	0.086	0.068	0.508	0.036
	Minimum	936	0	1561	2079	130	1974

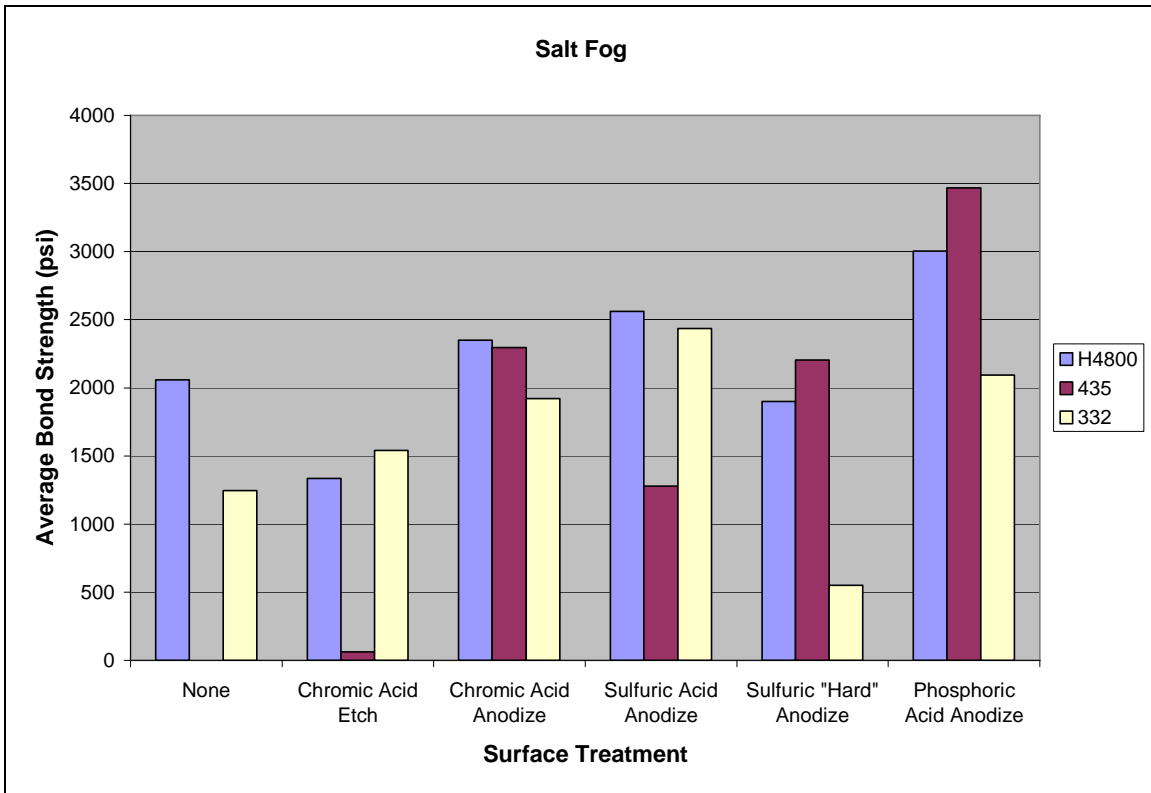


Figure 40: Bond Strength vs. Surface Treatment (Salt Fog)

As shown in **Figure 40**, bond strength varied greatly by not only treatment method, but also by adhesive type. To organize this data, each adhesive type was analyzed separately using Minitab.

2.6.2.1.2.1 Loctite® H4800™

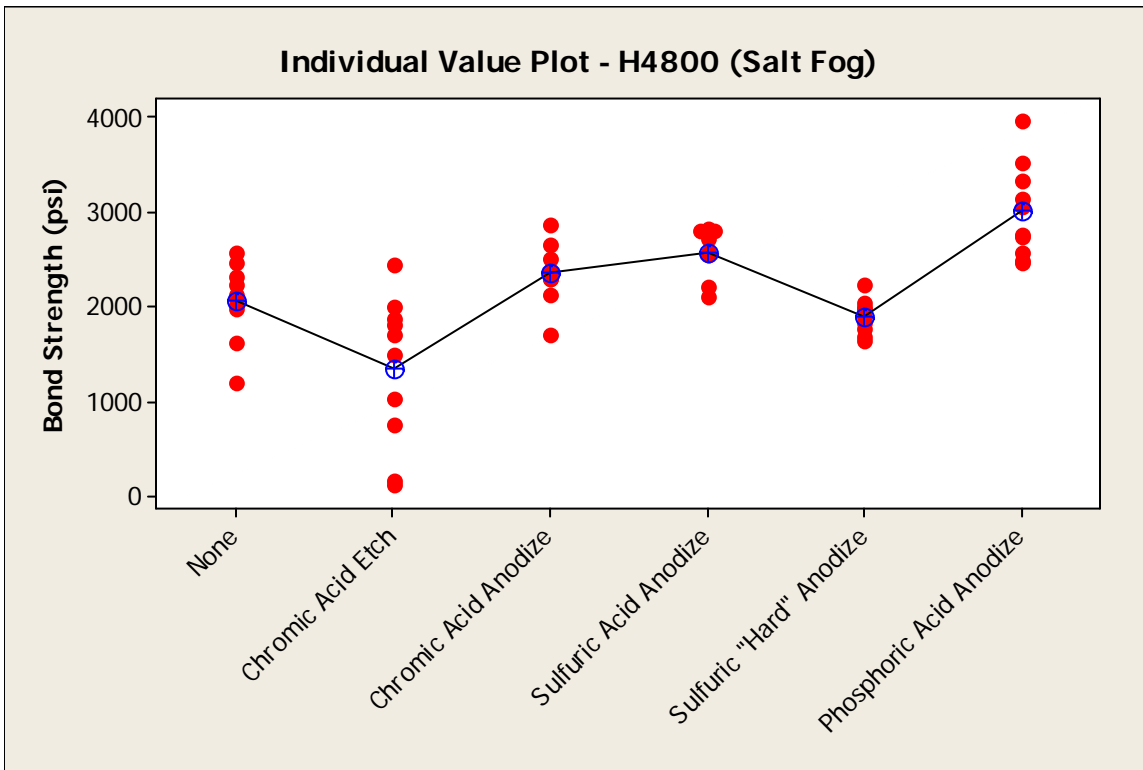


Figure 41: Individual Value Plot - H4800 (Salt Fog)

The previous individual value plot presents the difference in the data for all surface treatments evaluated while also identifying the scatter.

Ranked Average Bond Strengths (psi) – H4800 (Salt Fog):

1. Phosphoric Acid Anodize (3005)*
2. Sulfuric Anodize (2562)
3. Chromic Acid Anodize (2351)
4. None (2058)
5. Sulfuric “Hard” Anodize (1900)
6. Chromic Acid Etch (1334)

According to the Tukey analysis [See Figure 42], only phosphoric acid anodize had a greater average bond strength that proved to be statistically significantly different from the control (None) at a 95% confidence interval.

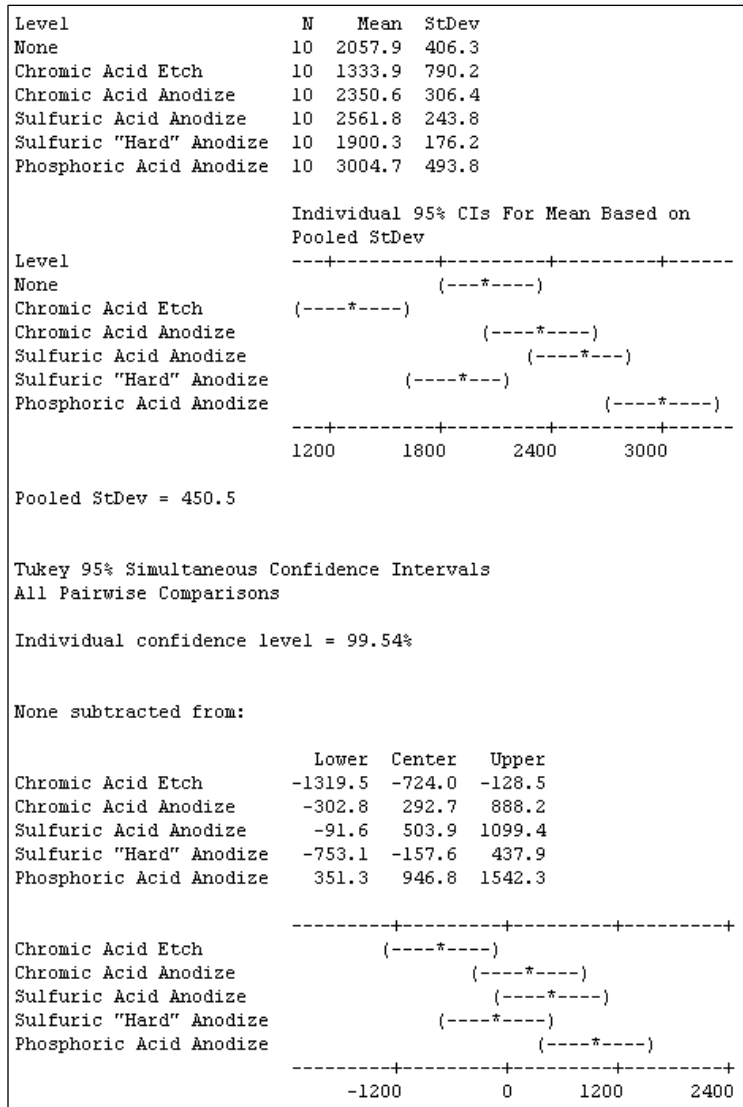


Figure 42: Tukey's Analysis - H4800 (Salt Fog)

2.6.2.1.2.2 Loctite® 435™

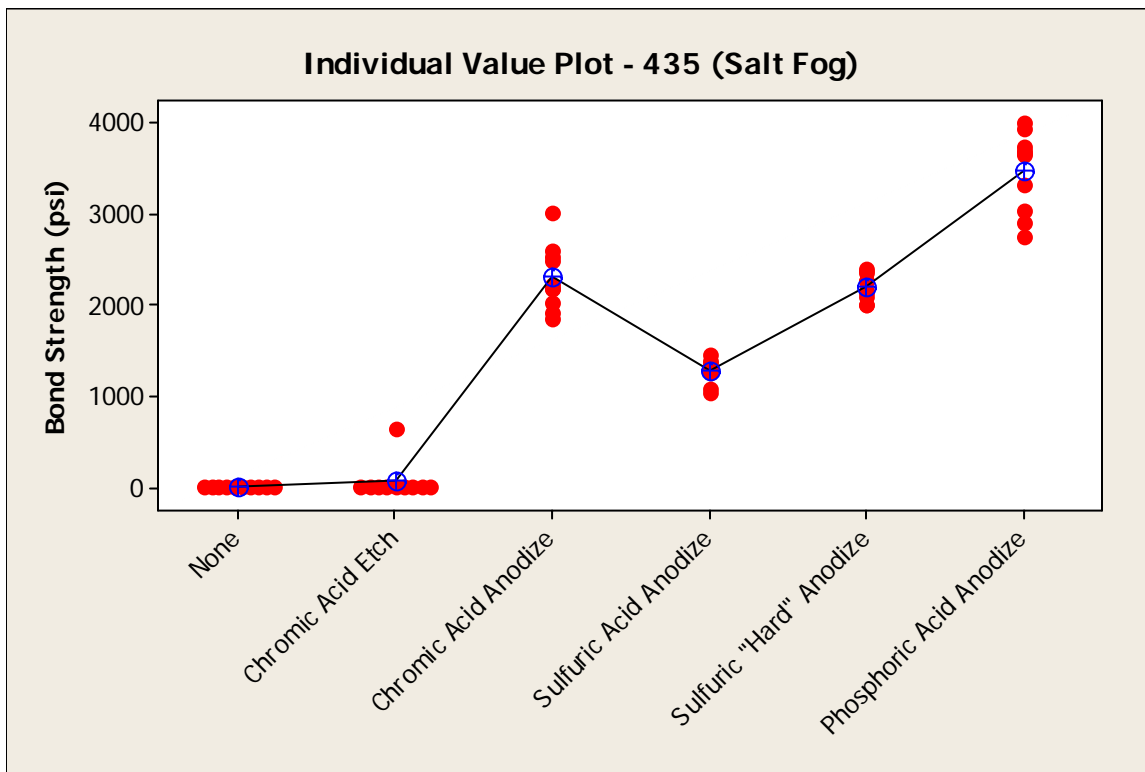


Figure 43: Individual Value Plot - 435 (Salt Fog)

The previous individual value plot presents the difference in the data for all surface treatments evaluated while also identifying the scatter.

Ranked Average Bond Strengths (psi) – 435 (Salt Fog):

1. Phosphoric Acid Anodize (3468)*
2. Chromic Acid Anodize (2296)*
3. Sulfuric “Hard” Anodize (2203)*
4. Sulfuric Anodize (1278)*
5. Chromic Acid Etch (64)
6. None (0)

According to the Tukey analysis [See Figure 44], phosphoric acid anodize, chromic acid anodize, sulfuric “hard” anodize & sulfuric anodize all had greater average bond strengths that proved to be statistically significantly different from the control (None) at a 95% confidence interval.

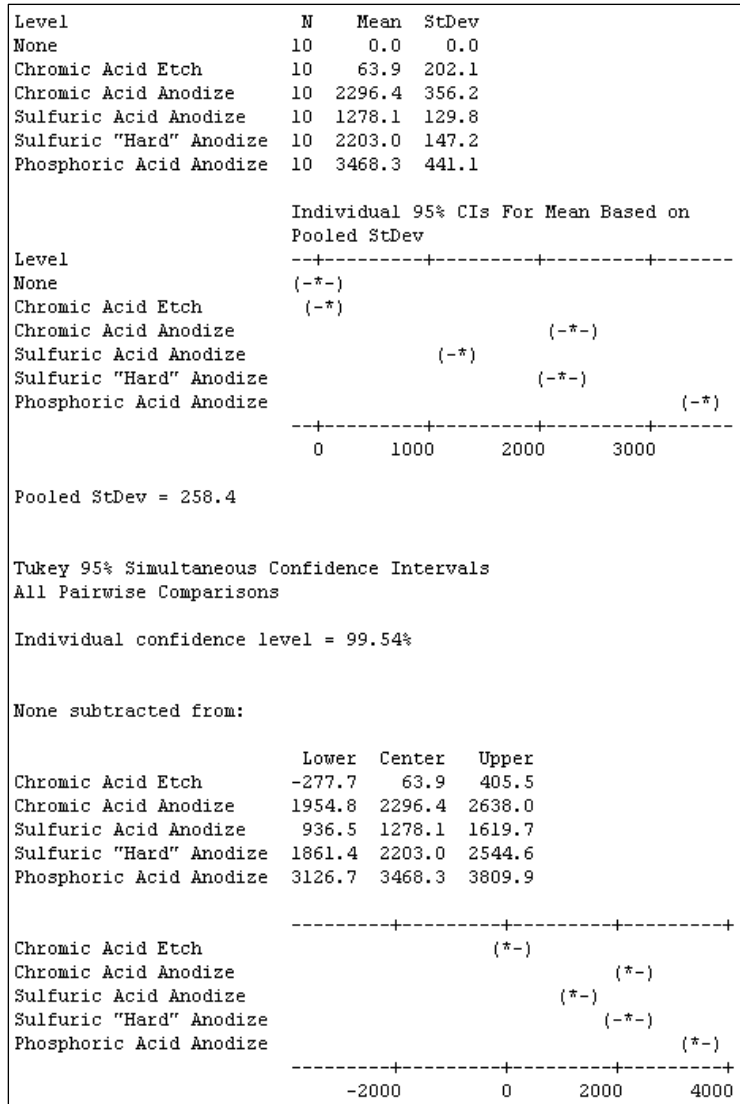


Figure 44: Tukey's Analysis - 435 (Salt Fog)

2.6.2.1.2.3 Loctite® 332™

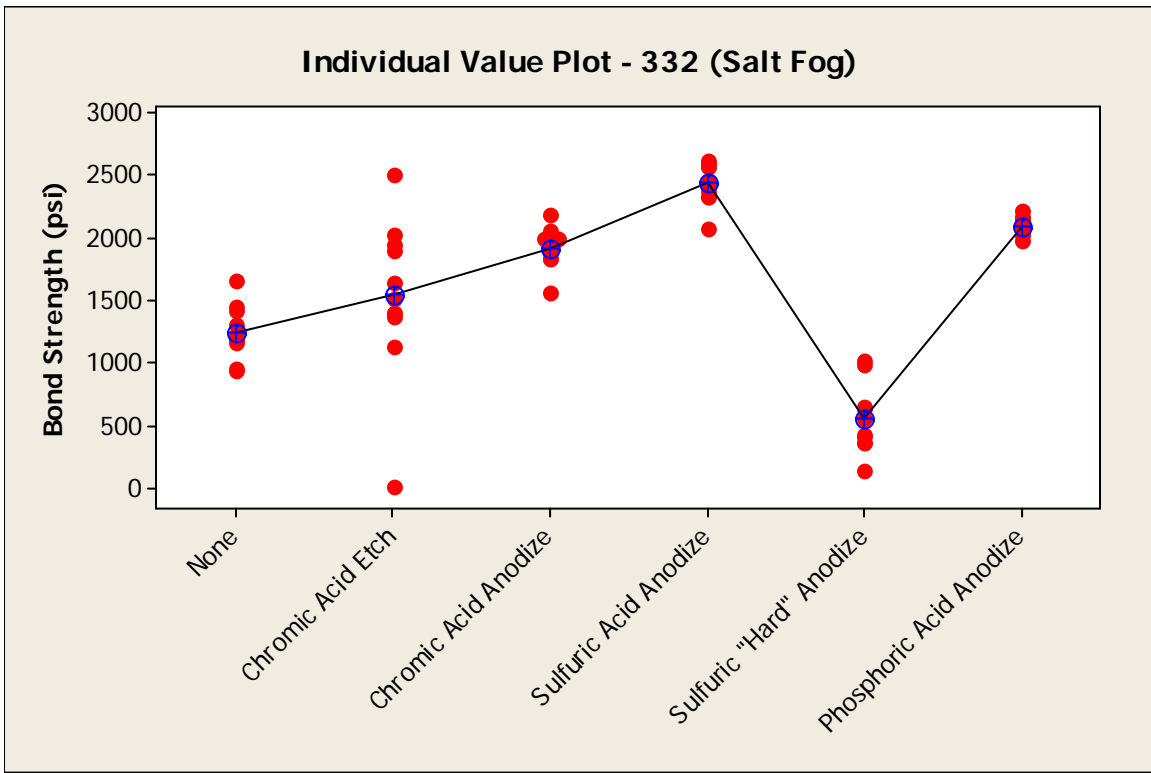


Figure 45: Individual Value Plot - 332 (Salt Fog)

The previous individual value plot presents the difference in the data for all surface treatments evaluated while also identifying the scatter.

Ranked Average Bond Strengths (psi) – 332 (Salt Fog):

1. Sulfuric Anodize (2436)*
2. Phosphoric Acid Anodize (2094)*
3. Chromic Acid Anodize (1921)*
4. Chromic Acid Etch (1540)
5. None (1247)
6. Sulfuric “Hard” Anodize (549)

According to the Tukey analysis [See Figure 46], sulfuric anodize, phosphoric acid anodize & chromic acid anodize all had greater average bond strengths that proved to be statistically significantly different from the control (None) at a 95% confidence interval.

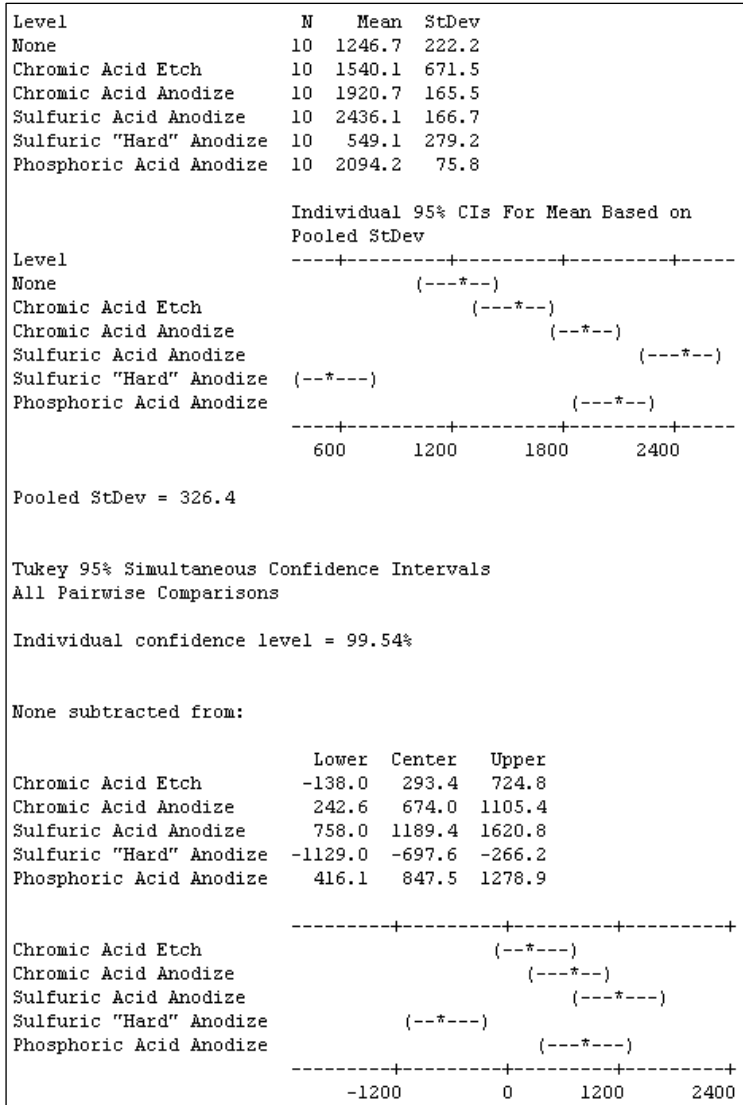


Figure 46: Tukey's Analysis - 332 (Salt Fog)

2.6.2.1.3 Condensing Humidity Conditioned Assemblies

Table 20 presents a summary of the results obtained for the condensing humidity assemblies.

Table 20: Condensing Humidity Conditioning Results							
Adhesive		Aluminum Surface Treatment					
		None	Chromic Acid Etch	Chromic Acid Anodize	Sulfuric Anodize	Sulfuric "Hard" Anodize	Phosphoric Acid Anodize
H4800	Average Strength (psi)	1684	1867	1732	2347	1813	2710
	Stand. Dev.	401	437	155	213	194	325
	COV	0.238	0.234	0.089	0.091	0.107	0.120
	Minimum	1684	1867	1732	2347	1813	2710
435	Average Strength (psi)	1531	1629	1664	950	1561	3902
	Stand. Dev.	159	558	163	129	304	341
	COV	0.104	0.343	0.098	0.136	0.195	0.087
	Minimum	1531	1629	1664	950	1561	3902
332	Average Strength (psi)	1303	1963	1899	2337	997	2213
	Stand. Dev.	250	397	124	100	374	146
	COV	0.192	0.202	0.065	0.043	0.375	0.066
	Minimum	774	963	1666	2108	546	1910

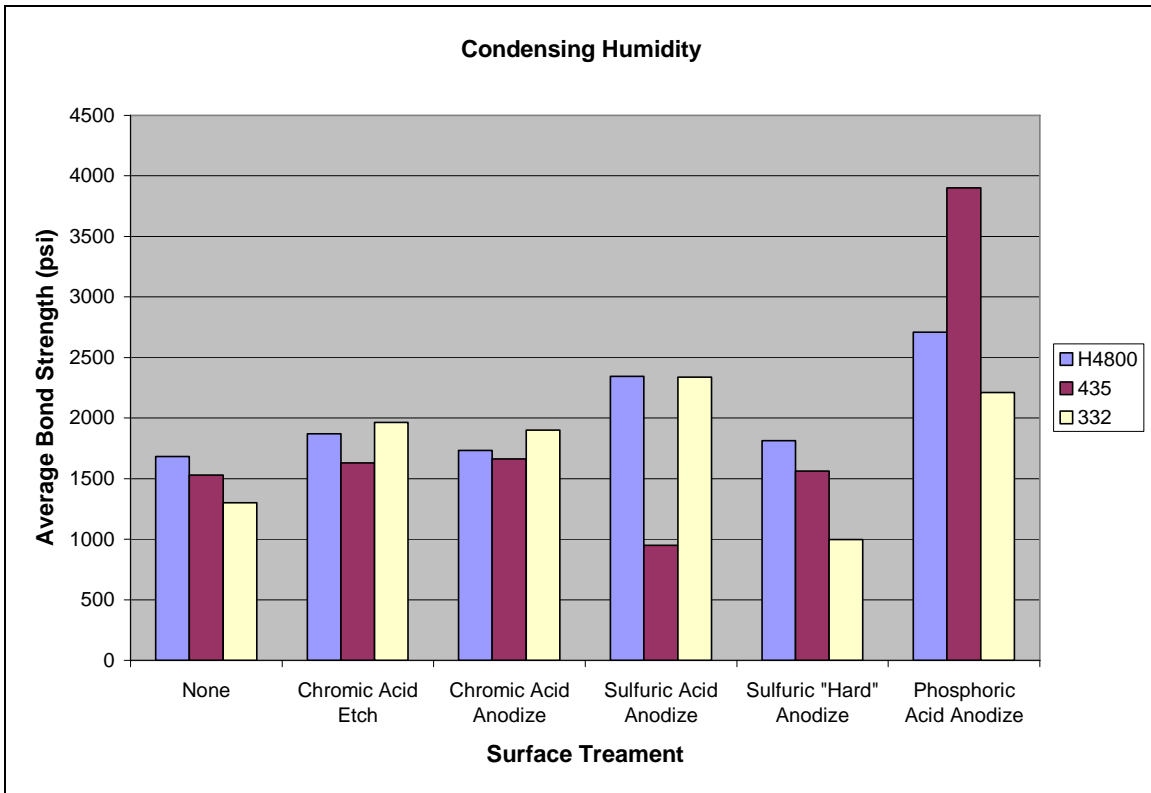


Figure 47: Bond Strength vs. Surface Treatment (Condensing Humidity)

As shown in **Figure 47**, bond strength varied greatly by not only treatment method, but also by adhesive type. To organize this data, each adhesive type was analyzed separately using Minitab.

2.6.2.1.3.1 Loctite® H4800™

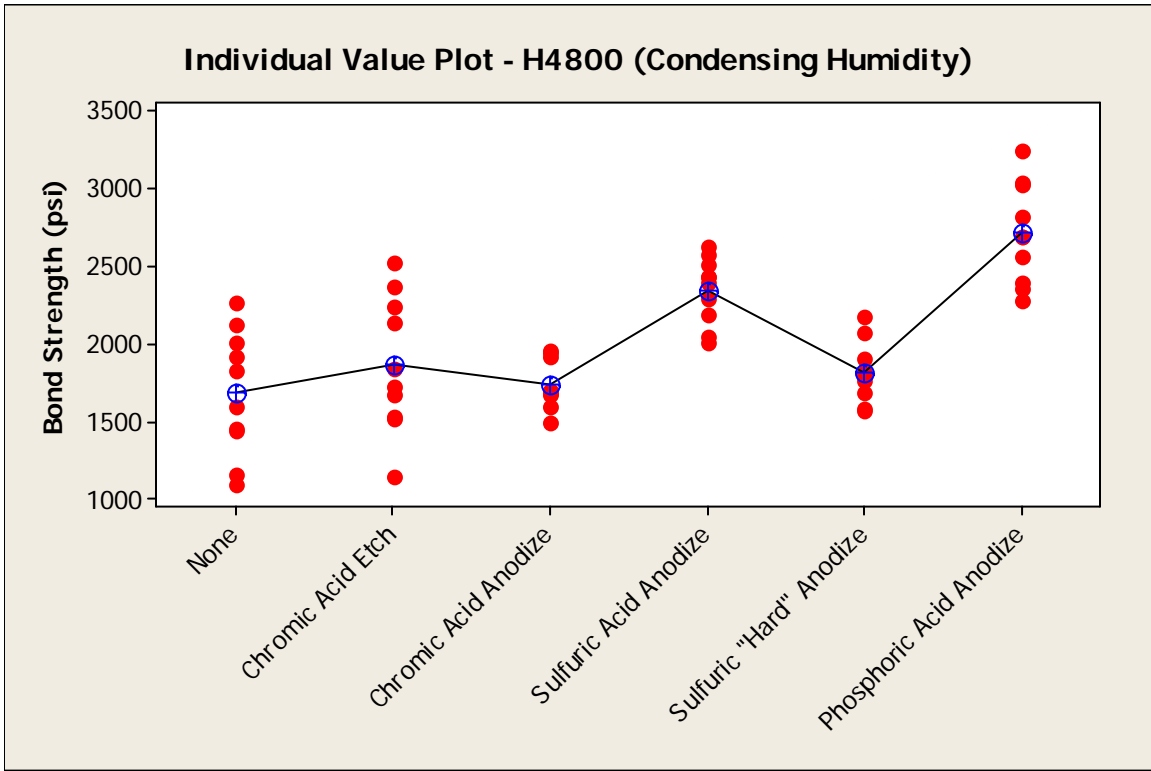


Figure 48: Individual Value Plot - H4800 (Condensing Humidity)

The previous individual value plot presents the difference in the data for all surface treatments evaluated while also identifying the scatter.

Ranked Average Bond Strengths (psi) – H4800 (Condensing Humidity):

1. Phosphoric Acid Anodize (2710)*
2. Sulfuric Anodize (2347)*
3. Chromic Acid Etch (1867)
4. Sulfuric “Hard” Anodize (1813)
5. Chromic Acid Anodize (1732)
6. None (1684)

According to the Tukey analysis [See Figure 49], phosphoric acid anodize & sulfuric anodize both had greater average bond strengths that proved to be statistically significantly different from the control (None) at a 95% confidence interval.

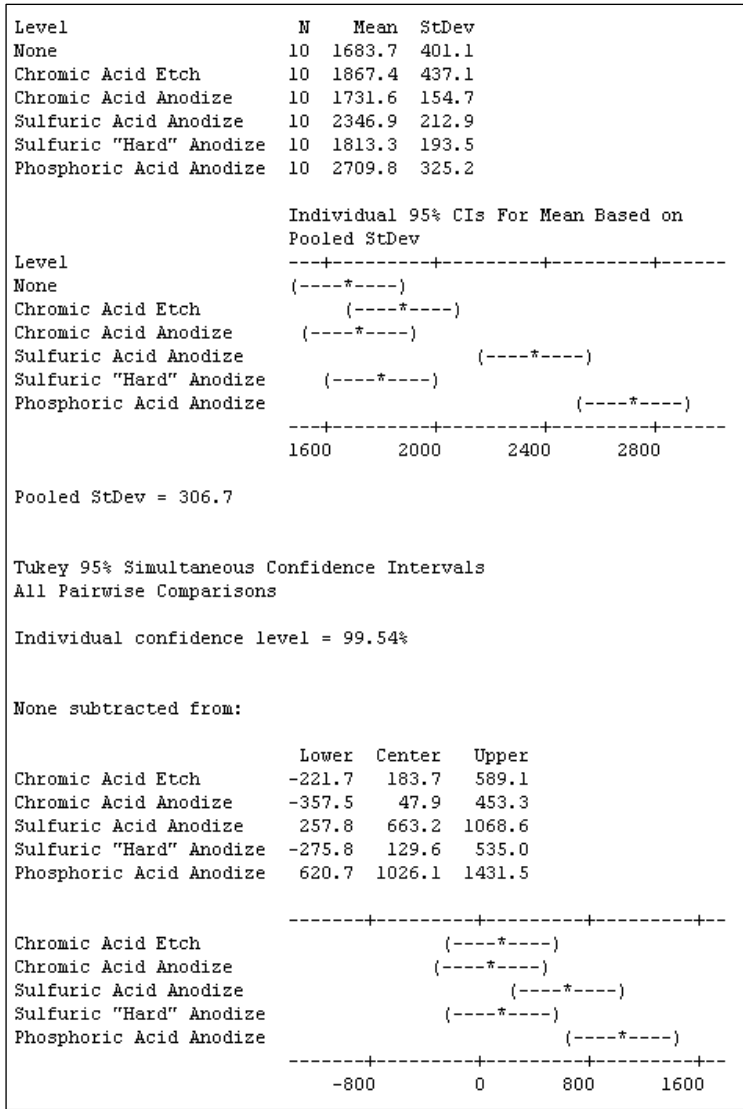


Figure 49: Tukey's Analysis - H4800 (Condensing Humidity)

2.6.2.1.3.2 Loctite® 435™

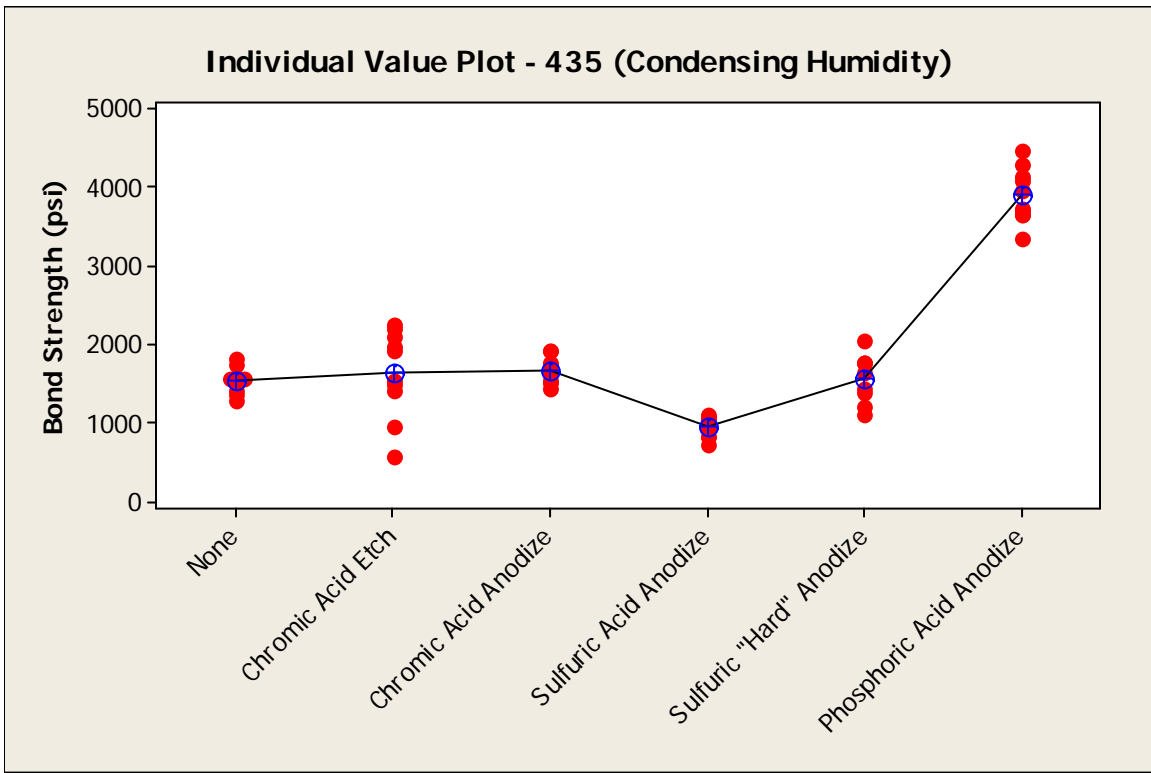


Figure 50: Individual Value Plot - 435 (Condensing Humidity)

The previous individual value plot presents the difference in the data for all surface treatments evaluated while also identifying the scatter.

Ranked Average Bond Strengths (psi) – 435 (Condensing Humidity):

1. Phosphoric Acid Anodize (3902)*
2. Chromic Acid Anodize (1664)
3. Chromic Acid Etch (1629)
4. Sulfuric “Hard” Anodize (1561)
5. None (1531)
6. Sulfuric Anodize (950)

According to the Tukey analysis [Figure 51], only phosphoric acid anodize had a greater average bond strength that proved to be statistically significantly different from the control (None) at a 95% confidence interval.

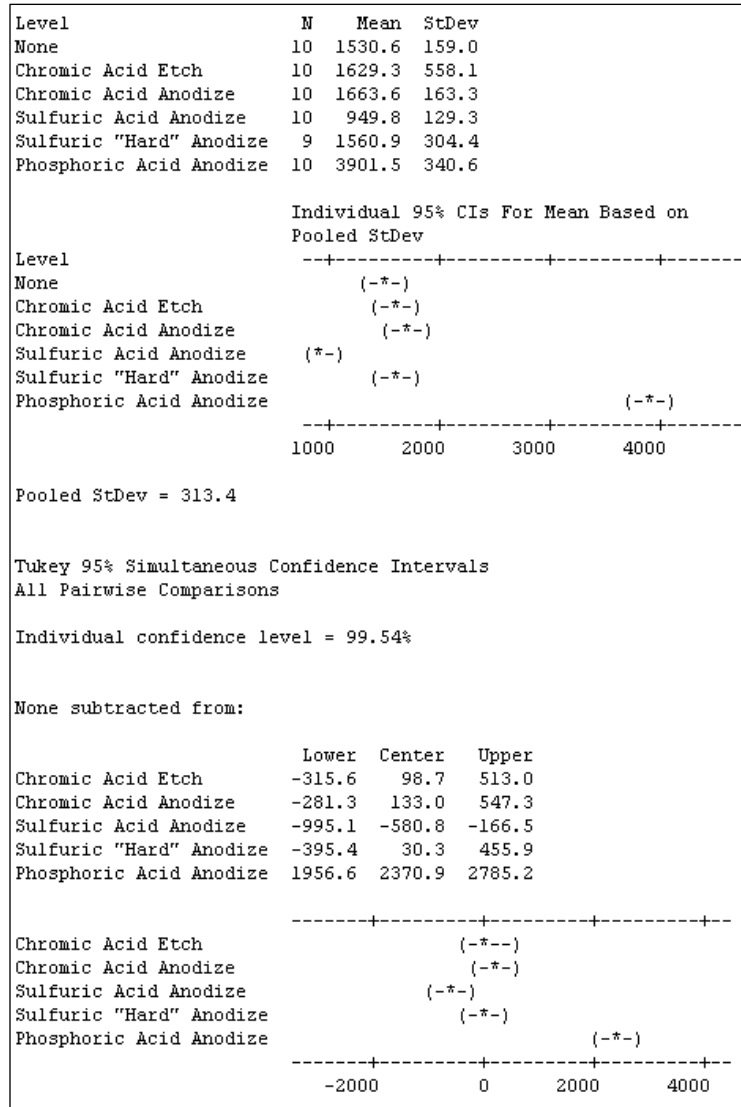


Figure 51: Tukey's Analysis - 435 (Condensing Humidity)

2.6.2.1.3.3 Loctite® 332™

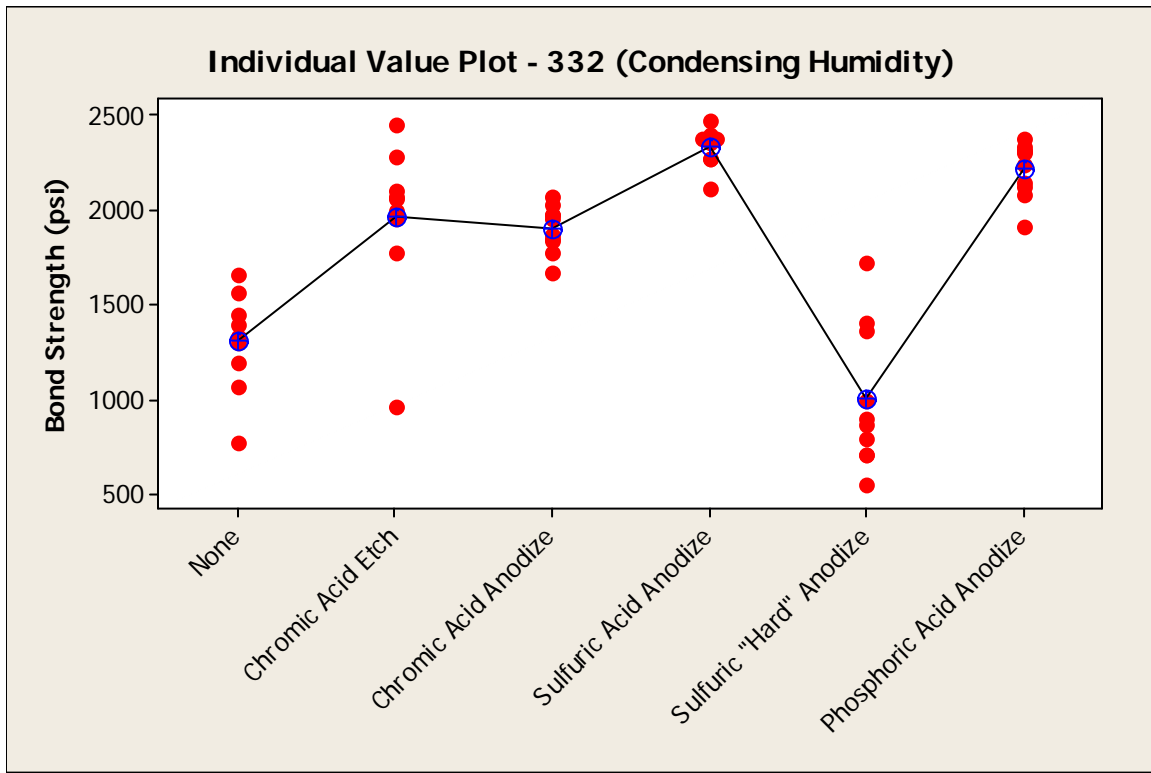


Figure 52: Individual Value Plot - 332 (Condensing Humidity)

The previous individual value plot presents the difference in the data for all surface treatments evaluated while also identifying the scatter.

Ranked Average Bond Strengths (psi) – 332 (Condensing Humidity):

1. Sulfuric Anodize (2337)*
2. Phosphoric Acid Anodize (2213)*
3. Chromic Acid Etch (1963)*
4. Chromic Acid Anodize (1899)*
5. None (1303)
6. Sulfuric “Hard” Anodize (997)

According to the Tukey analysis [See Figure 53], sulfuric anodize, phosphoric acid anodize, chromic acid etch & chromic acid anodize all had greater average bond strengths that proved to be statistically significantly different from the control (None) at a 95% confidence interval.

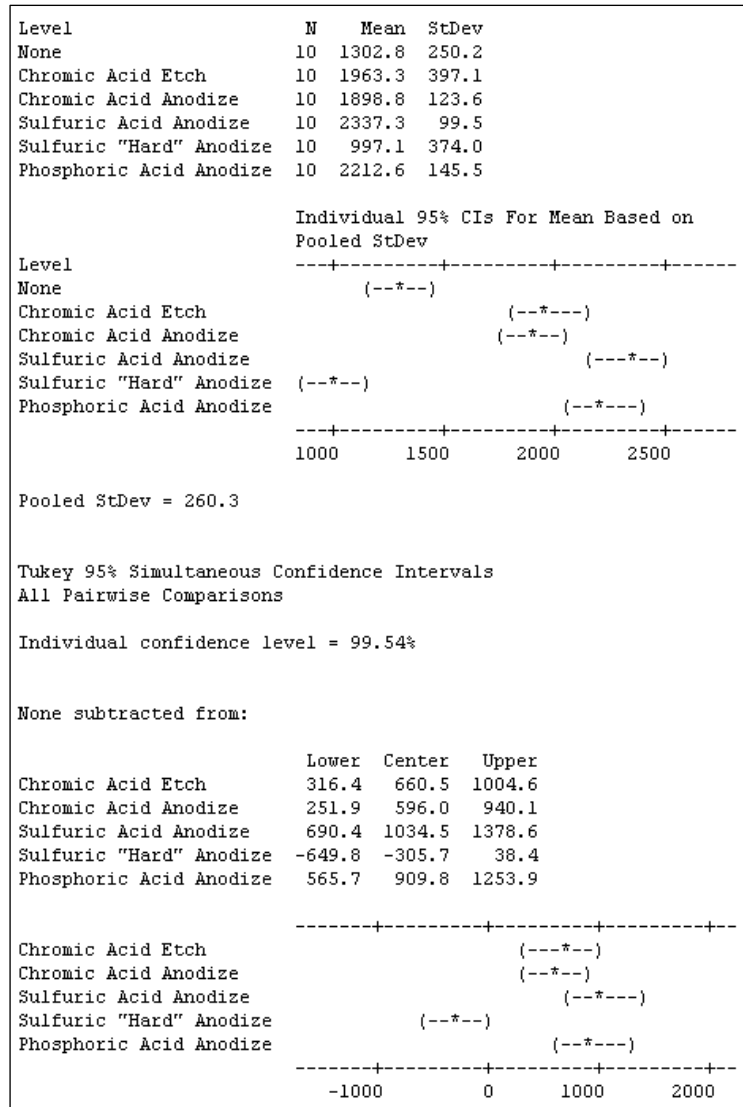


Figure 53: Tukey's Analysis - 332 (Condensing Humidity)

2.6.2.1.4 Heat 1 Assemblies (100°C for 435, 125°C for H4800 & 332)

Table 21 presents a summary of the results obtained for the heat 1 assemblies.

Table 21: Heat 1 Conditioning Results							
Adhesive		Aluminum Surface Treatment					
		None	Chromic Acid Etch	Chromic Acid Anodize	Sulfuric Anodize	Sulfuric "Hard" Anodize	Phosphoric Acid Anodize
H4800	Average Strength (psi)	3800	3988	3316	2320	1907	3491
	Stand. Dev.	386	512	386	243	300	432
	COV	0.102	0.128	0.116	0.105	0.157	0.124
	Minimum	3191	3043	2759	1974	1360	2781
435	Average Strength (psi)	1081	1300	1861	813	968	2381
	Stand. Dev.	111	142	168	154	120	375
	COV	0.103	0.109	0.090	0.190	0.124	0.157
	Minimum	854	1004	1642	550	776	1892
332	Average Strength (psi)	1981	2538	2036	1729	736	2061
	Stand. Dev.	114	281	152	193	352	66
	COV	0.057	0.111	0.075	0.111	0.479	0.032
	Minimum	1837	2028	1848	1419	307	1979

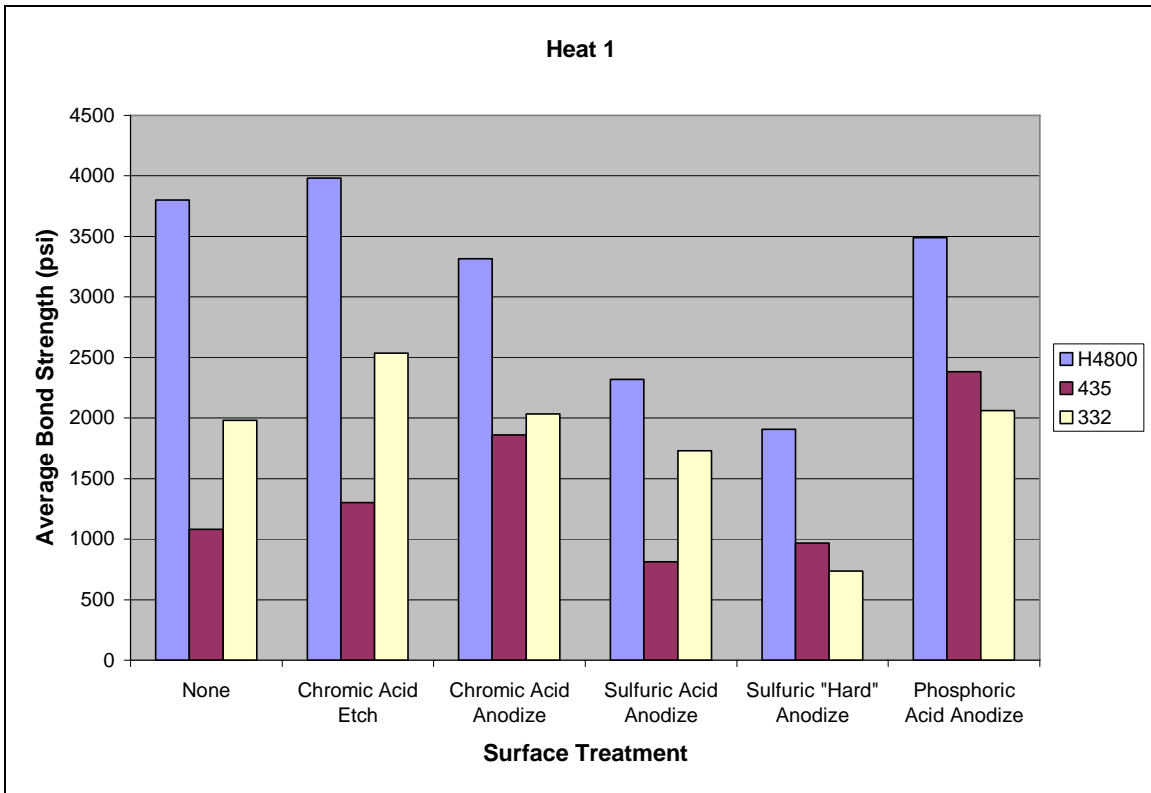


Figure 54: Bond Strength vs. Surface Treatment (Heat 1)

As shown in **Figure 54**, bond strength varied greatly by not only treatment method, but also by adhesive type. To organize this data, each adhesive type was analyzed separately using Minitab.

2.6.2.1.4.1 Loctite® H4800™

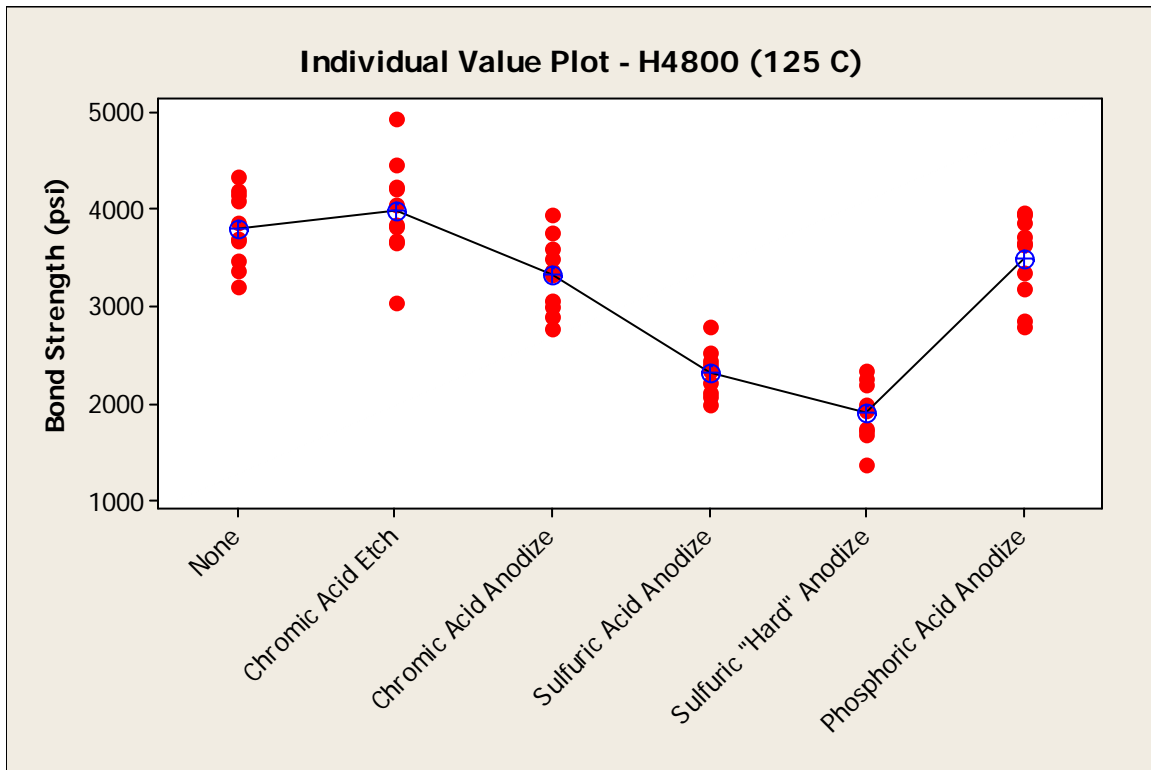


Figure 55: Individual Value Plot - H4800 (125°C)

The previous individual value plot presents the difference in the data for all surface treatments evaluated while also identifying the scatter.

Ranked Average Bond Strengths (psi) – H4800 (125°C):

1. Chromic Acid Etch (3988)
2. None (3800)
3. Phosphoric Acid Anodize (3491)
4. Chromic Acid Anodize (3316)
5. Sulfuric Anodize (2320)
6. Sulfuric “Hard” Anodize (1907)

According to the Tukey analysis [See Figure 56], none of the previous surface preparation techniques had a greater average bond strength that proved to be statistically significantly different from the control (None) at a 95% confidence interval.

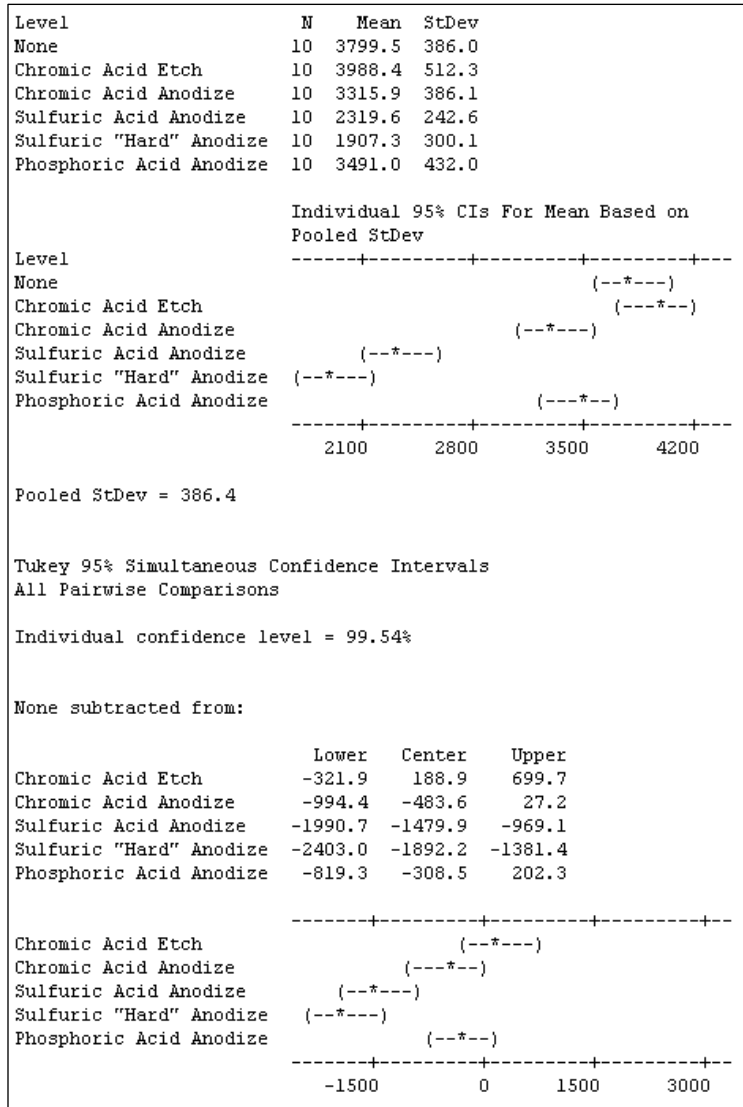


Figure 56: Tukey's Analysis - H4800 (125°C)

2.6.2.1.4.2 Loctite® 435™

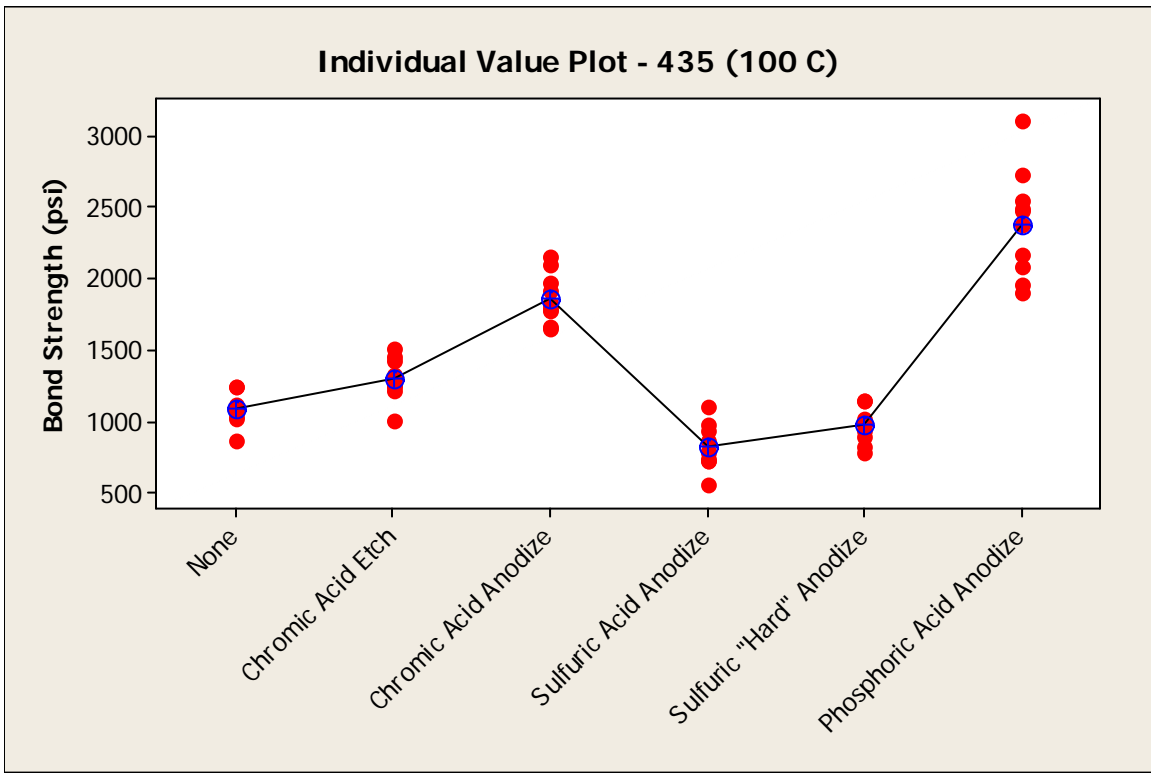


Figure 57: Individual Value Plot - 435 (100°C)

The previous individual value plot presents the difference in the data for all surface treatments evaluated while also identifying the scatter.

Ranked Average Bond Strengths (psi) – 435 (100°C):

1. Phosphoric Acid Anodize (2381)*
2. Chromic Acid Anodize (1861)*
3. Chromic Acid Etch (1300)
4. None (1081)
5. Sulfuric "Hard" Anodize (968)
6. Sulfuric Anodize (813)

According to the Tukey analysis [See Figure 58], phosphoric acid anodize & chromic acid anodize both had greater average bond strengths that proved to be statistically significantly different from the control (None) at a 95% confidence interval.

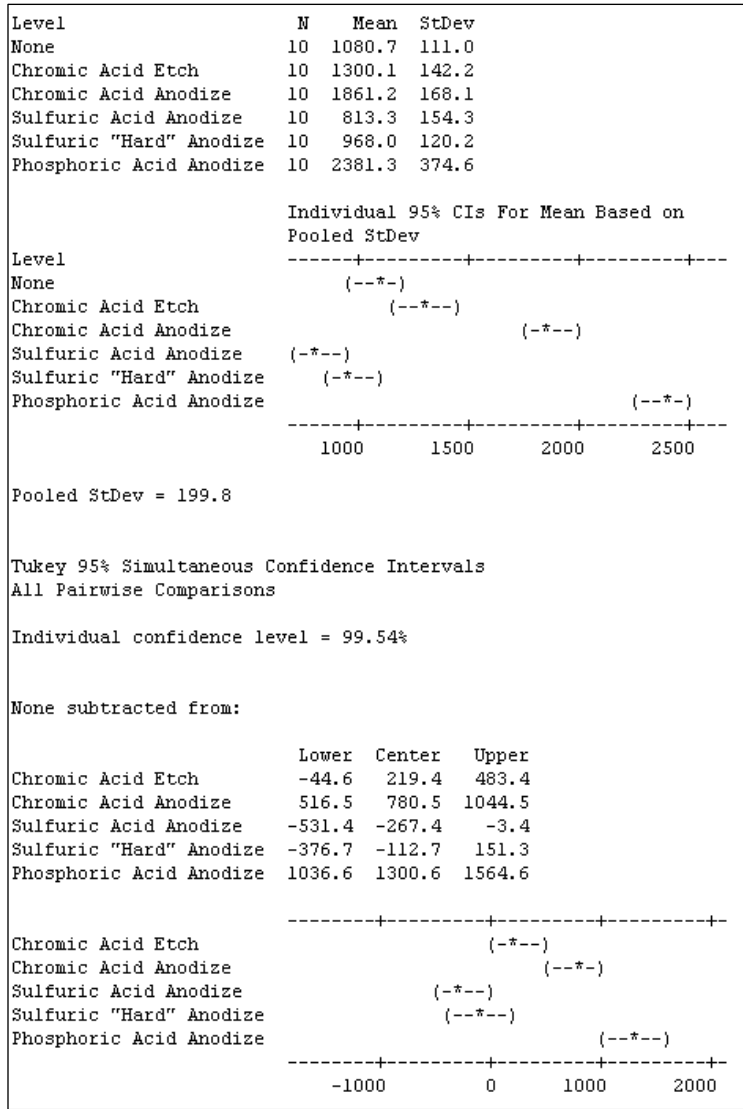


Figure 58: Tukey's Analysis - 435 (100°C)

2.6.2.1.4.3 Loctite® 332™

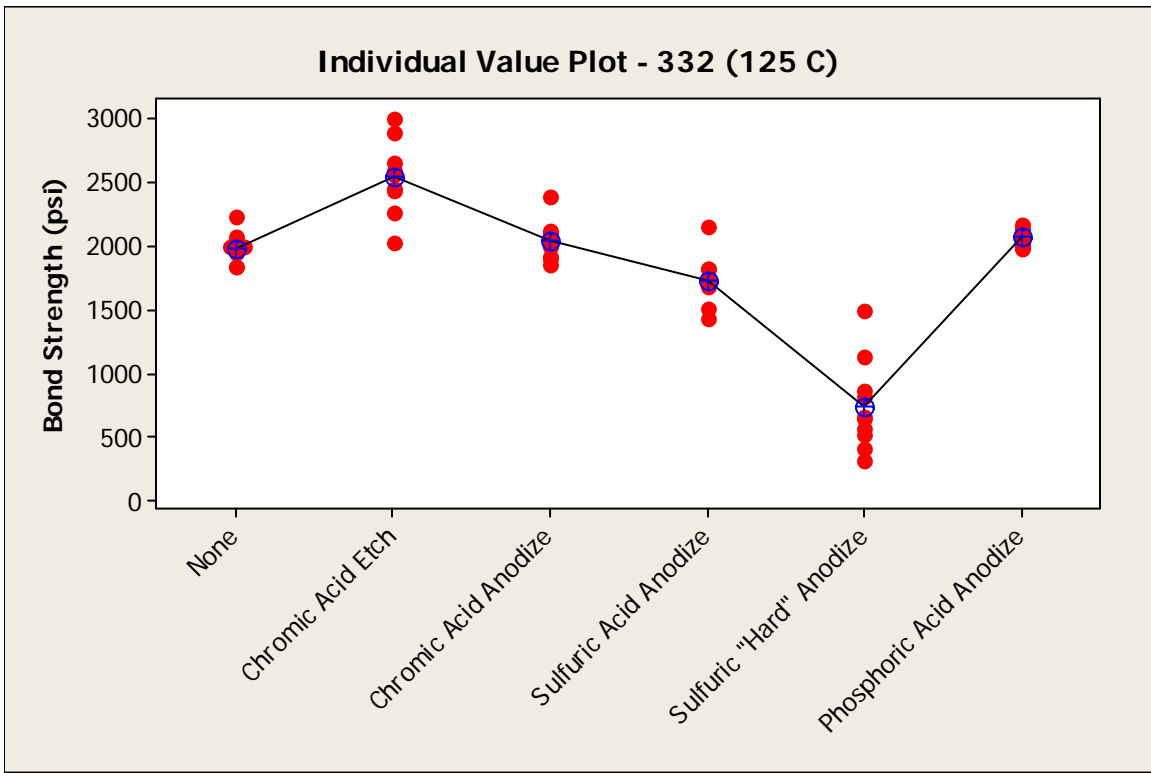


Figure 59: Individual Value Plot - 332 (125°C)

The previous individual value plot presents the difference in the data for all surface treatments evaluated while also identifying the scatter.

Ranked Average Bond Strengths (psi) – 332 (125°C):

1. Chromic Acid Etch (2538)*
2. Phosphoric Acid Anodize (2061)
3. Chromic Acid Anodize (2036)
4. None (1981)
5. Sulfuric Anodize (1729)
6. Sulfuric “Hard” Anodize (736)

According to the Tukey analysis [See Figure 60], only chromic acid etch had a greater average bond strength that proved to be statistically significantly different from the control (None) at a 95% confidence interval.

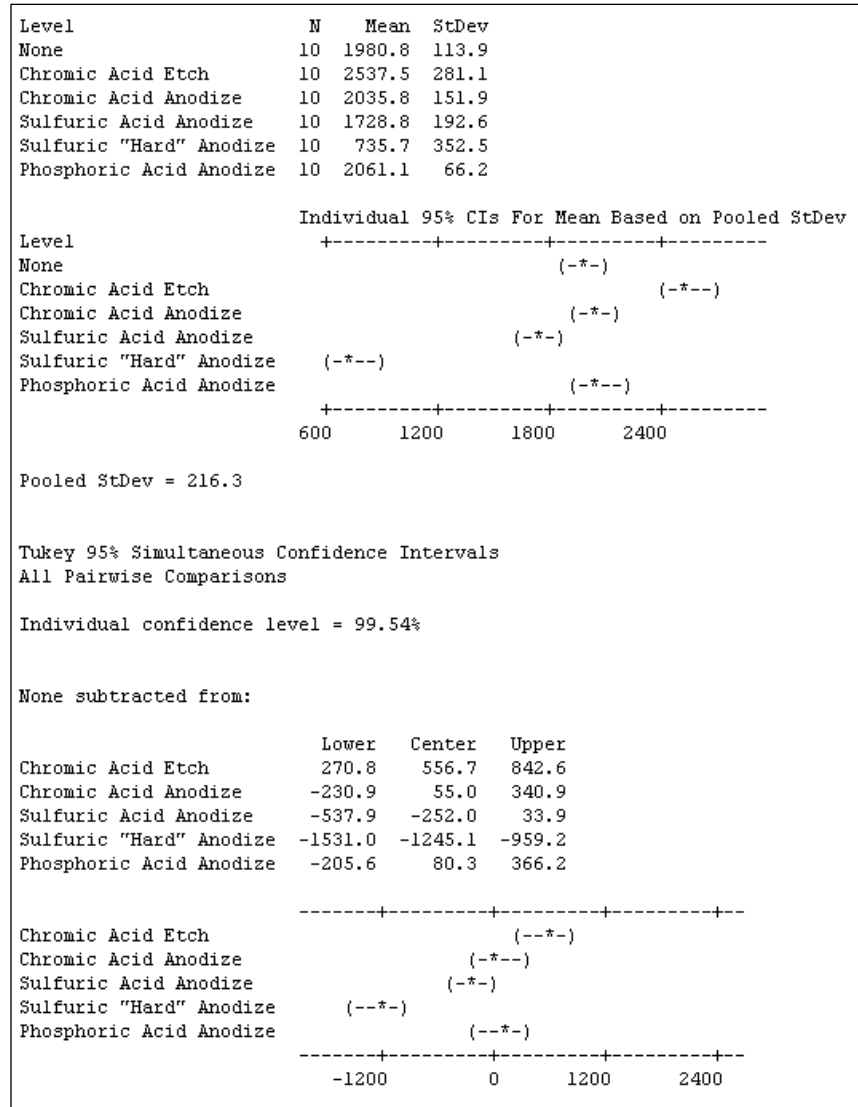


Figure 60: Tukey's Analysis - 332 (125°C)

2.6.2.1.5 Heat 2 Assemblies (125°C for 435, 175°C for H4800 & 332)

Table 22 presents a summary of the results obtained for the heat 2 assemblies.

Table 22: Heat 2 Conditionings Results							
Adhesive		Aluminum Surface Treatment					
		None	Chromic Acid Etch	Chromic Acid Anodize	Sulfuric Anodize	Sulfuric “Hard” Anodize	Phosphoric Acid Anodize
H4800	Average Strength (psi)	1564	1857	1813	1539	805	2049
	Stand. Dev.	390	778	124	138	152	127
	COV	0.249	0.419	0.069	0.089	0.188	0.062
	Minimum	982	685	1649	1361	578	1835
435	Average Strength (psi)	20	252	264	41	1	0
	Stand. Dev.	42	111	133	61	2	0
	COV	2.052	0.441	0.506	1.479	1.563	1.610
	Minimum	0	0	0	0	0	0
332	Average Strength (psi)	2315	2992	2294	1671	946	2241
	Stand. Dev.	105	196	134	152	430	115
	COV	0.045	0.065	0.058	0.091	0.455	0.051
	Minimum	2140	2741	2081	1425	402	2045

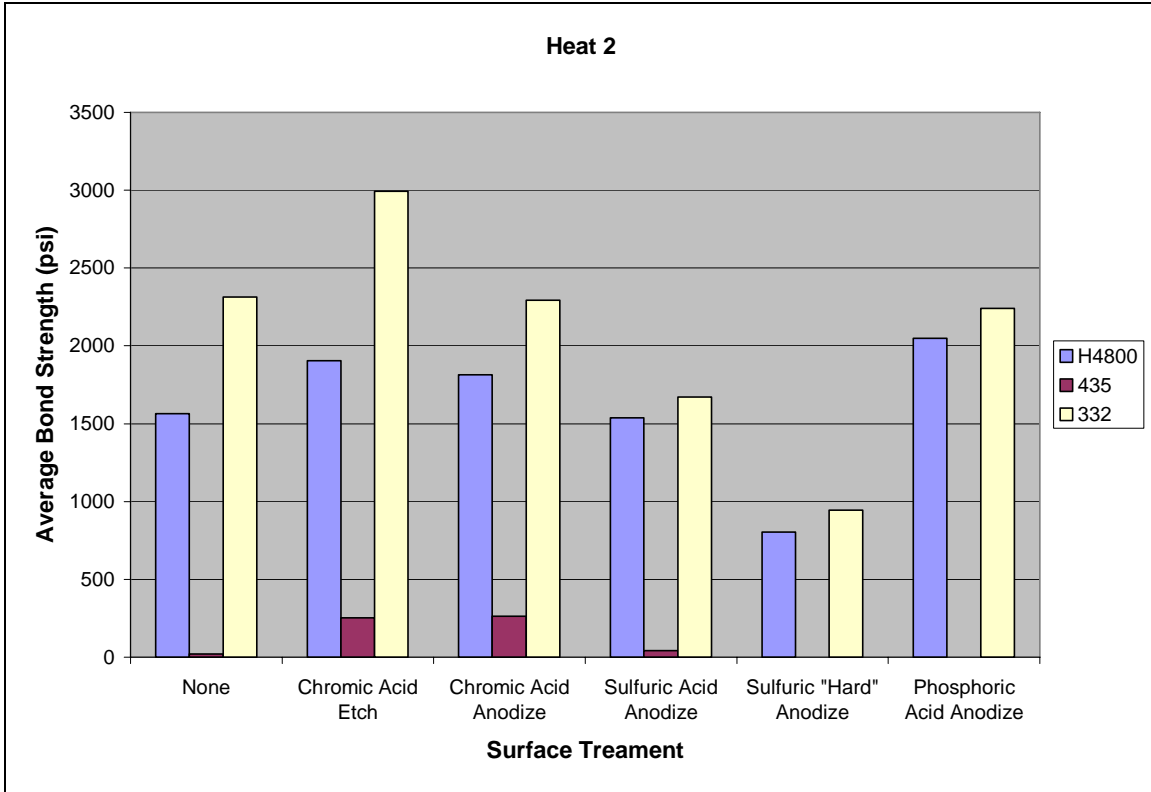


Figure 61: Bond Strength vs. Surface Treatment (Heat 2)

As shown in **Figure 61**, bond strength varied greatly by not only treatment method, but also by adhesive type. To organize this data, each adhesive type was analyzed separately using Minitab.

2.6.2.1.5.1 Loctite® H4800™

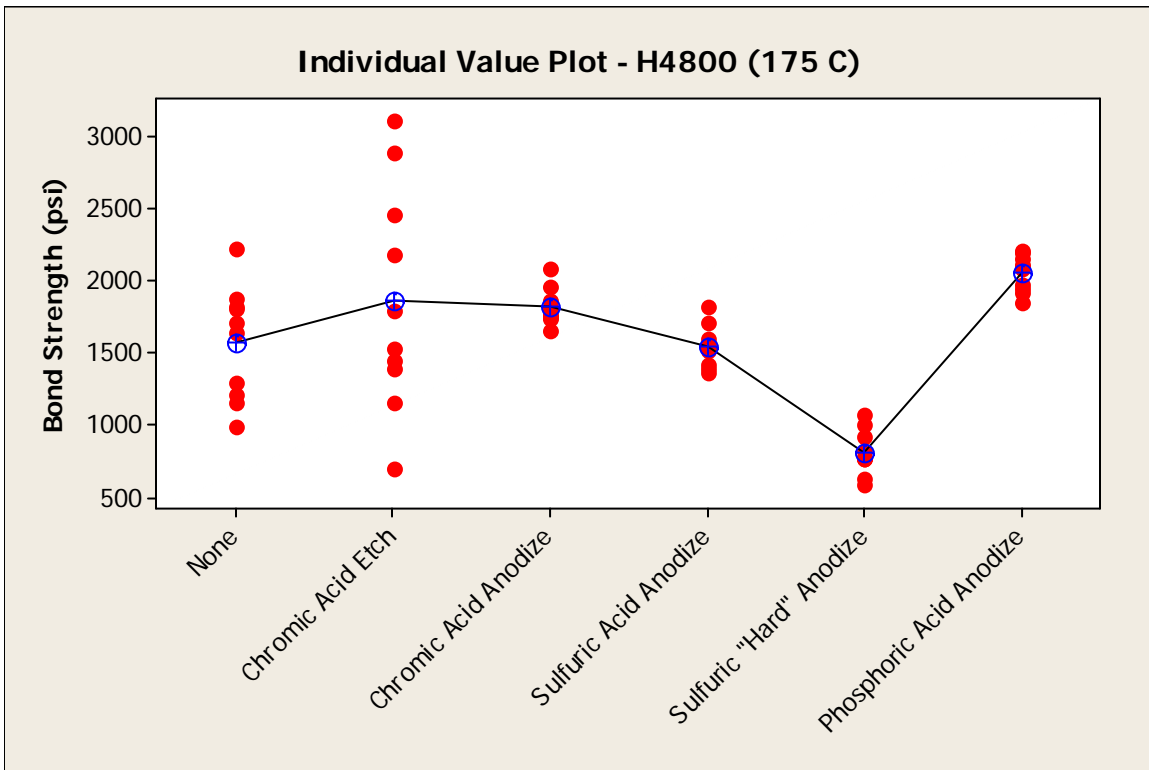


Figure 62: Individual Value Plot - H4800 (175°C)

The previous individual value plot presents the difference in the data for all surface treatments evaluated while also identifying the scatter.

Ranked Average Bond Strengths (psi) – H4800 (175°C):

1. Phosphoric Acid Etch (2049)
2. Chromic Acid Etch (1857)
3. Chromic Acid Anodize (1813)
4. None (1564)
5. Sulfuric Anodize (1539)
6. Sulfuric Hard Anodize (805)

According to the Tukey analysis [See Figure 63], none of the previous surface preparation techniques had a greater average bond strength that proved to be statistically significantly different from the control (None) at a 95% confidence interval.

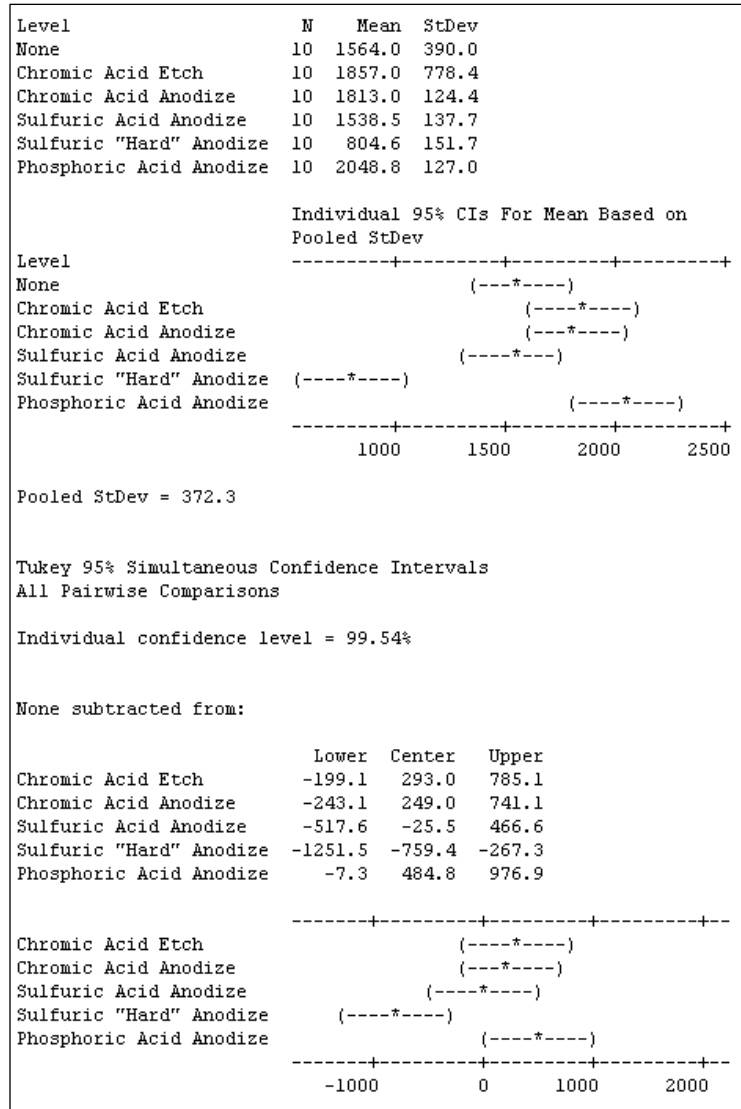


Figure 63: Tukey's Analysis - H4800 (175°C)

2.6.2.1.5.2 Loctite® 435™

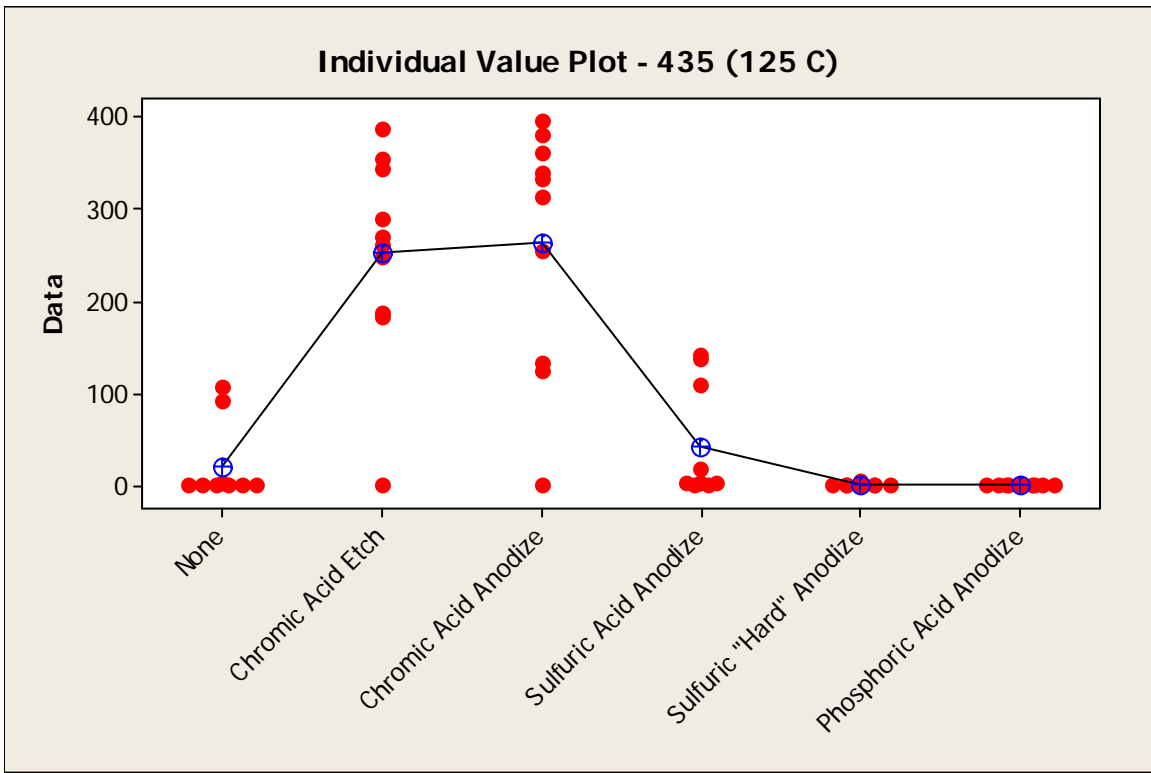


Figure 64: Individual Value Plot - 435 (125°C)

The previous individual value plot presents the difference in the data for all surface treatments evaluated while also identifying the scatter.

Ranked Average Bond Strengths (psi) – 435 (125°C):

1. Chromic Acid Anodize (264)*
2. Chromic Acid Etch (252)*
3. Sulfuric Anodize (41)
4. None (20)
5. Sulfuric Hard Anodize (1)
6. Phosphoric Acid Anodize (0)

According to the Tukey analysis [See Figure 65], chromic acid anodize & chromic acid etch both had greater average bond strengths that proved to be statistically significantly different from the control (None) at a 95% confidence interval.

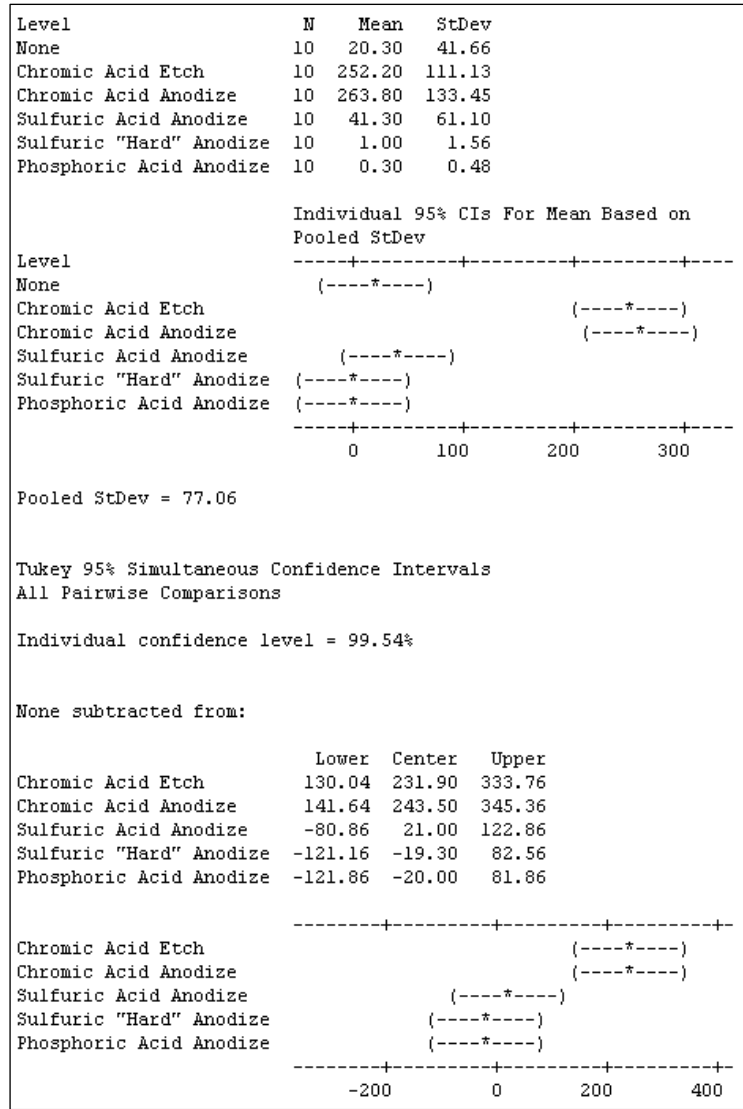


Figure 65: Tukey's Analysis - 435 (125°C)

2.6.2.1.5.3 Loctite® 332™

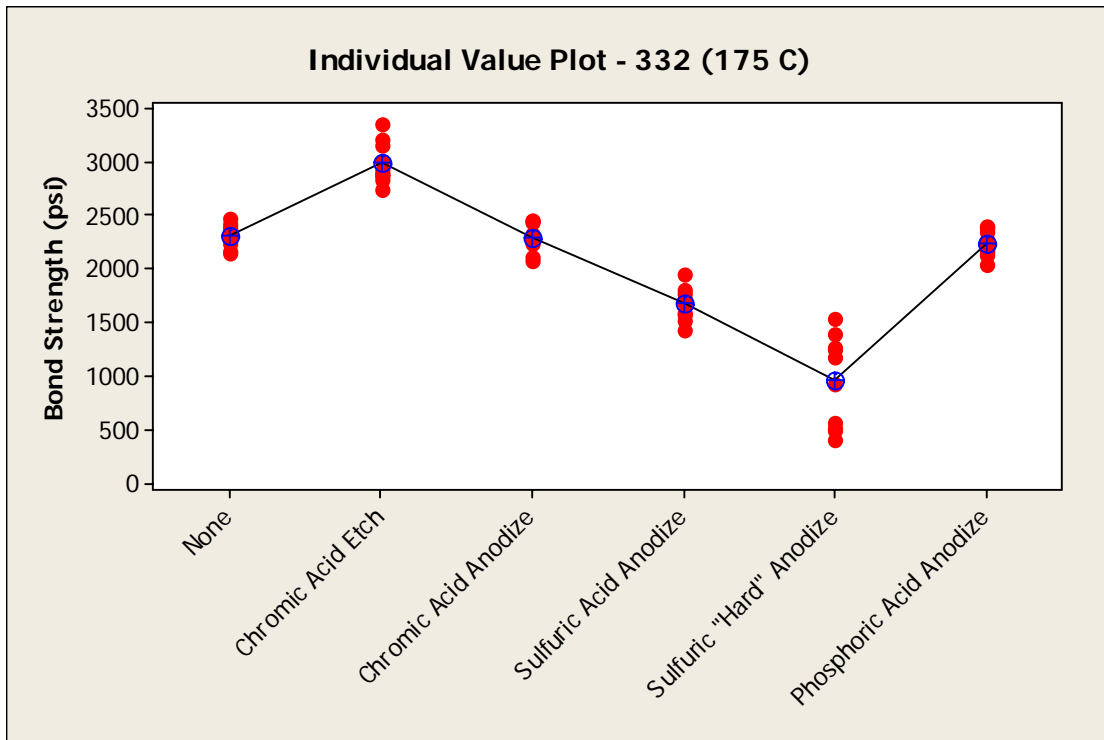


Figure 66: Individual Value Plot - 332 (175°C)

The previous individual value plot presents the difference in the data for all surface treatments evaluated while also identifying the scatter.

Ranked Average Bond Strengths (psi) – 332 (175°C):

1. Chromic Acid Etch (2992)*
2. None (2315)
3. Chromic Acid Anodize (2294)
4. Phosphoric Acid Anodize (2241)
5. Sulfuric Anodize (1671)
6. Sulfuric "Hard" Anodize (946)

According to the Tukey analysis [See Figure 67], only chromic acid etch had a greater average bond strength that proved to be statistically significantly different from the control (None) at a 95% confidence interval.

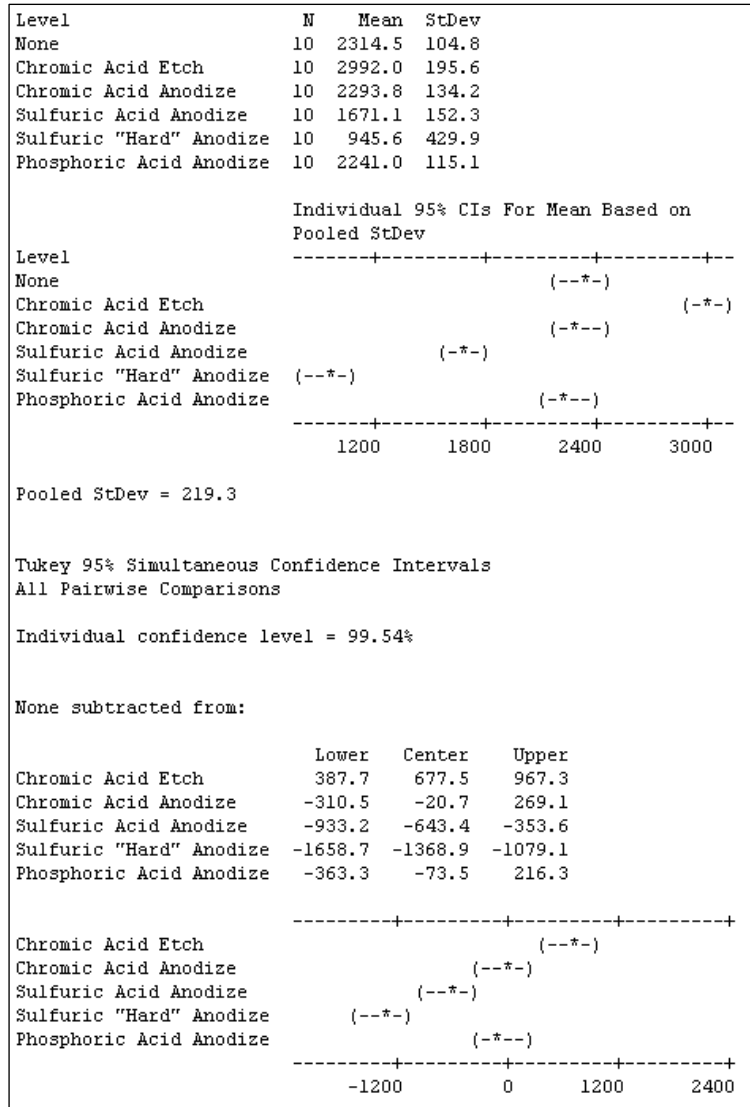


Figure 67: Tukey's Analysis - 332 (175°C)

2.6.2.2 Results by Surface Treatment

In order for a given surface treatment to be considered successful it must be able to maintain its strength with the bonded adhesive in adverse conditions. Previously we compared the performance of the six surface treatments within the respective conditions that they were exposed to. Now we will investigate how each specific surface treatment reacted to adverse conditions (heat/humidity aging) compared to its unconditioned control.

In the **Table 23** below, within each surface treatment, the unconditioned control was compared to its conditioned counterparts. It was then determined, using Minitab, whether or not the conditioned counterpart was statistically significantly weaker than the unconditioned control at a 95% confidence interval. If so, that particular condition was considered to be a failure. The number in the parentheses is “[average bond strength of the unconditioned control]-[the average bond strength of the respective condition]”

Table 23: Pass/Fail Test for Conditioned Assemblies					
Treatment	Adhesive	Conditioning			
		Salt Fog	Condensing Humidity	Heat 1	Heat 2
Chromic Acid Etch	H4800	Fail (1511)	Fail (977)	Pass (-1144)	Fail (988)
	435	Fail (2458)	Fail (892)	Fail (1222)	Fail (2270)
	332	Fail (1458)	Fail (1035)	Pass (461)	Pass (6)
Chromic Acid Anodize	H4800	Pass (212)	Fail (831)	Pass (-753)	Fail (750)
	435	Pass (-33)	Fail (600)	Fail (403)	Fail (2000)
	332	Fail (208)	Fail (230)	Pass (93)	Pass (-165)
Sulfuric Acid Anodize	H4800	Pass (147)	Fail (362)	Fail (389)	Fail (1170)
	435	Fail (408)	Fail (737)	Fail (873)	Fail (1645)
	332	Pass (75)	Pass (173)	Fail (782)	Fail (840)
Sulfuric Hard Anodize	H4800	Fail (713)	Fail (800)	Fail (706)	Fail (1809)
	435	Pass (191)	Fail (833)	Fail (1426)	Fail (2393)
	332	Pass (285)	Pass (-163)	Pass (98)	Pass (-112)
Phosphoric Acid Anodize	H4800	Pass (-95)	Pass (200)	Pass (-581)	Fail (861)
	435	Pass (140)	Pass (-293)	Fail (1227)	Fail (3608)
	332	Pass (79)	Pass (-39)	Pass (113)	Pass (-67)
Untreated	H4800	Pass (159)	Fail (534)	Pass (-1582)	Fail (653)
	435	Fail (2104)	Fail (574)	Fail (1024)	Fail (2084)
	332	Fail (624)	Fail (568)	Pass (-110)	Pass (-444)

As was previously mentioned, in order for any one of these surface treatments to be considered successful, regardless of the initial bond strengths that it may achieve, it needs to maintain its strength in adverse conditions. According to the Minitab analyses performed to complete **Table 23**, it was noticed that every single surface treatment failed at the following adhesive and conditioning combination; H4800 at 175°C, 435 at 100°C & 435 at 125°C. Therefore, those three combinations must be excluded from consideration. After excluding those three combinations, there is only one surface treatment that stands out above the rest when it comes to maintaining strength in adverse conditions. That particular surface treatment is phosphoric acid anodizing, passing the 9 remaining adhesive and conditioning combinations. Sulfuric “hard” anodizing and chromic acid anodizing tied for second place, passing 5 of 9 the remaining adhesive and conditioning combinations.

Not only did phosphoric acid anodizing outperform every other surface treatment by maintaining its strength through adverse conditions, it also showed much less variance compared to the current surface treatment that Henkel uses, chromic acid etching. More specifically it did as good, or better, than chromic acid etching for every single adhesive/conditioning combination. For 5 of the 9 adhesive/conditioning combinations it proved to have a statistically significantly lower variance than chromic acid etching at a 95% confidence interval.

2.6.2.2.1 Visual Observations

As the testing progressed, it became visually apparent which substrates provided better resistance against humid environments. Below are images [See Figure 68] which display each substrate after exposure to 2 weeks of conditioning, in both salt fog and condensing humidity chambers.

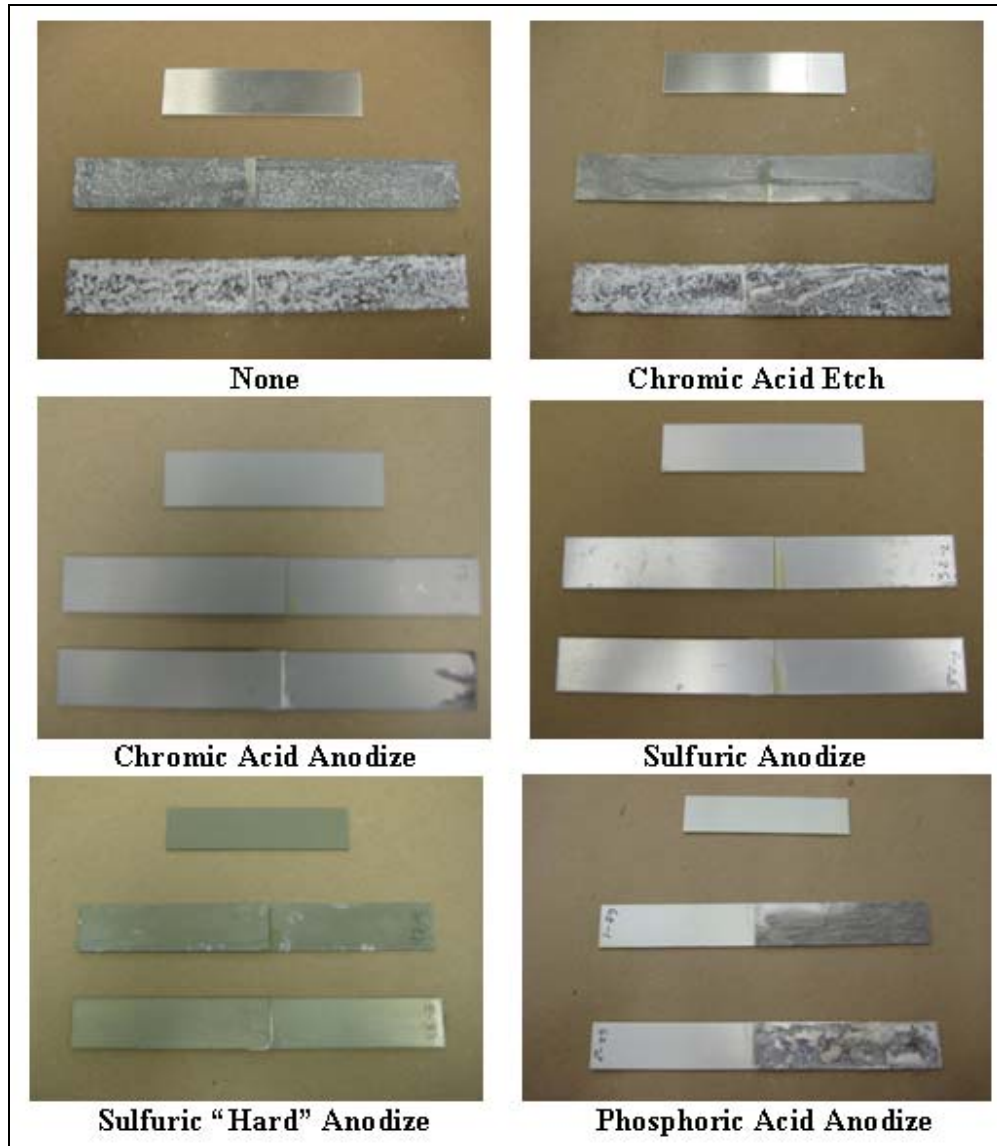


Figure 68: Surface Treatment's Resistance to Humid Environments

*Note: Only the left side of the phosphoric acid anodized specimen is representative of how it reacts to humid environments. This is due to the fact that only one side of the treated lap shears was primed with BR-127.

Visual inspection of the treated aluminum assemblies revealed little change in appearance after exposure to the humid environments.

As stated before, only one side of the phosphoric acid anodized specimen was treated with the BR-127 primer. The primed surface, visually, seemed to provide better corrosion resistance than the un-primed side. Also, it was observed that the chromic acid etched specimen had a very similar resistance to the humid environments to untreated specimens. This may very well be because only a small portion of each lap shear was chromic acid etched. Only the bond area of each aluminum lap shear was etched, leaving the rest of the surface area susceptible to corrosion. In turn, the corrosion on the untreated portion may have affected the treated portion of the lap shear, thus, not properly representing it's resistance in humid environments.

3.0 Conclusions

During the 8 weeks spent here at Henkel, many conclusions were made based on the results obtained during experimental procedures. In this section of the report, these conclusions are presented.

3.1 Chromic Acid Etching Process

Throughout all the experimental procedures completed here at Henkel, using the current chromic acid etching system, some conclusions were made that improved the overall performance of the treated specimens. These conclusions are discussed below.

3.1.1 Design and Assembly of System

The previous chromic acid etching system at Henkel Loctite had several flaws and it was important to correct them by designing and building an entirely new system. A beaker filled with the chromic acid was used and test specimens were hand placed into the beaker then taken out manually. This beaker was heated with a hot plate and the temperature was monitored with a glass thermometer. In order to maintain the required temperature of 70 degrees Celsius, the hot plate had to be hand adjusted, resulting in temperatures greater than or less than the required operating temperature.

The new system used a water bath with an automatic temperature controller and a stand was built surrounding the bath to hold 20 lap shears, thus allowing 20 specimens to be treated at once in uniform. This resulted in more accurate and consisted results from the previous method. Also, it was a much safer method than using a hot plate because the acid bath was secured in the water bath instead of sitting freely. The freshly treated lap shears were able to be cleaned with water before any manual removal from the system, ensuring further safety and more accurate results.

3.1.2 Degradation

It was important for our sponsor to understand whether or not the chromic acid bath degraded after treating a certain amount of test specimen. This could potentially cause a drop in bond strength of the treated specimen, affecting the consistency of data. The chromic acid bath, contrary to what was initially thought, did not degrade after simulating treatment of 1000 aluminum lap shears. After the addition of 0.16 grams of aluminum powder (1000 lap shears), there was no significant difference in bond strength between lap shears treated with the “fresh” bath and those treated with the “degraded” bath. This is an important result, ensuring that bath degradation will not be a concern for all future projects that involve chromic acid etching.

3.1.3 Cleaning Method

It was also important for our sponsor to ensure that the current process in which specimen are treated, obtained the best results possible. One possible area for improvement involved the cleaning after treatment and prior to bonding. The investigation as to whether or not cleaning the treated aluminum surface with isopropyl alcohol prior to bonding had any effect on bond strength proved to be negative. Both the average bond strength and standard deviation between cleaned and non-cleaned samples did not prove to be statistically significantly different. However, wiping the samples with Kimwipes directly after being removed from the chromic acid bath did prove to have a statistically significantly better bond strength compared to drying them in an oven. This too proved to be a very significant result. By modifying the previous process used here at Henkel, we were able to improve bond strength while minimizing variance, which is a result that is always desired.

3.2 Comparative Surface Treatment Analysis

When evaluating a specific surface treatment, there are many important factors one must consider. The most obvious factor is performance; however, there are others that must also be analyzed in order to determine if a specific treatment method is a viable one.

3.2.1 Performance

Below is a list of the three most important factors when evaluating the *performance* of a surface treatment method on aluminum:

1. Achieving high bond strength.
2. Maintaining that bond strength through adverse conditions
3. Minimizing scatter in the bond strength data.

The only surface treatment method that successfully addressed those three performance factors was phosphoric acid anodizing. Therefore, it has been concluded that it is the best *performing* surface treatment method.

3.2.2 Cost

Cost is very important when evaluating which surface treatment that should be incorporated into Henkel's future testing. For example, if a particular surface treatment had superior performing qualities, but was very expensive, it may not be profitable to take for the company to pursue. On the other hand, if a particular surface treatment was rather inexpensive, but performed rather poorly, then it wouldn't be plausible for the company to pursue. So the ideal candidate falls somewhere in the middle of those two scenarios.

Now, further analyzing our particular cases, we can determine a ranked system for all the surface treatments previously evaluated. Chromic Acid Etching has been neglected from the following assessment since it would be rather difficult to determine just how much it costs to treat a given amount of specimen. This is simply because there are too many variables to take into consideration such as, supply cost, laboratory cost (technician’s time), and waste disposal. Also, it is the companies desire to eventually steer away from the use of chromic acid etching due to the safety and environmental concerns associated with it. Sulfuric acid anodized specimens were also neglected, since they are a standard test specimen that Henkel currently stocks in their laboratories.

Table 24 below presents the cost of each all surface treatments previously evaluated.

Table 24: Cost of Surface Treatments	
Surface Treatment	Cost Per 1 Lap Shear (USD)
Chromic Acid Anodize	1.30\$
Sulfuric “Hard” Anodize	2.62\$
Phosphoric Acid Anodize	3.00\$

Since it isn’t our decision on how much money Henkel would be willing to spend for future testing, all we can do is provide the cost. It is of the discretion of our liaison to decide if the performance to price ratio is worth pursuing in the future.

3.2.3 Ease of Use – Safety

It is also very important that the certain surface treatment that Henkel uses in future testing be very safe and relatively easy to use. Since the only surface treatment method that was done “in house” was chromic acid etching, it is the only candidate that is

considered to have any safety issues whatsoever. All the other specimens were sent out for treatment, resulting in virtually no concerns.

3.2.4 Use in Industry

A given surface treatment's use in industry is also of importance to Henkel. Since Henkel is a client driven company, they will benefit if they can provide testing on a surface treatment that is widely used in industry. From the previous research done, it was established that the most widely used surface preparation technique on aluminum in industry, is phosphoric acid anodizing. It is the preferred treatment of the aerospace industry because the oxide layer formed is thicker than chromic acid etching, and the "whiskers" (which increase surface area) are much longer in phosphoric acid anodizing process.

4.0 Recommendations

Results obtained from this project reflect short time periods of treating aluminum specimens, bonding them, and testing their bond strengths. It is recommended that additional testing take place with unused treated lap shears to ensure that the data portrayed in this project is completely accurate. A larger water bath was ordered to conduct future chromic acid etching for the sponsor. Because the water bath used in all experiments in this project was rather small, a limited number of aluminum lap shears could be treated at once. A larger water bath will allow more specimens to be treated in one batch, possibly producing more accurate results and requiring less time. After testing was completed, certain conclusions were drawn due to the success of our designed system. A larger water bath was purchased to accommodate various test specimens and can be seen below in **Figure 69**.

It is also recommended that the environmental conditions be changed slightly to fully ensure that a certain type of surface treatment method performs

better in some conditions and worse in others. For this project, the lap shears were placed in salt fog chambers, regular fog chambers, and heated ovens for exactly two weeks. Placing assemblies in these chambers for longer periods of time and at different temperatures would give a very wide and descriptive range of results.



Figure 69: Large Water Bath

Also, shear strength was the only variable tested in these experiments. To get a better idea of how strong the bond really is, it would be beneficial to perform other test methods, such as peel strength, in which the entire lap shear is bonded then peeled off using the Instron machine. Looking at the bond strength from multiple angles will give Loctite more detailed information on each surface treatment with a particular adhesive.

Appendix A: STM 700



Standard Test Method

Shear Strength of Adhesives Using Lap-Shear Specimens		STM NO.	700
TITLE		1-18-08	
		ISSUE DATE	
STM-700	06-Dec-05	1	12
SUPERSEDES	DATED	PAGE NO.	OF PAGES
Ron Jones /Fergal Gordon	Rocky Hill / Dublin		
TECHNICAL CONTACT	LOCATION		

1. SCOPE

1.1 This test method covers the determination of the comparative strengths of adhesives using lap-shear specimens.

1.2 Procedures for adhesive application, specimen assembly, and testing are included for non-UV/visible light curing adhesives and UV/visible light curing adhesives.

2. SIGNIFICANCE

2.1 The results obtained using this method are useful for comparative and quality control purposes, but can not be used for joint design.

3. PRINCIPLE

3.1 Adhesive bond strength is determined by stressing a single adhesive overlap joint with the application of a tensile force parallel to the bond area and to the major axis of the test specimen.

4. DEFINITIONS

4.1 For purposes of this Standard Test Method, the following definition applies:

4.1.1 *Load at failure* - The maximum load recorded during the test.

5. APPLICABLE DOCUMENTS

5.1 This test method is based on the following standards:

5.1.1 ASTM D1002 –05 (10/1/2005) *Strength Properties of Adhesives in Shear by Tension Loading (Metal-to-Metal)*

5.1.2 ASTM D3163 *Strength Properties of Adhesively Bonded Rigid Plastic Lap-Shear Joints in Shear by Tension Loading*

5.1.3 ISO 4587 *Adhesives - Determination of Tensile Lap-Shear Strength of High Strength Adhesive Bonds*

5.1.4 DIN EN 1465 *Adhesives - Determination of Tensile Lap-Shear Strength of Rigid-to-rigid Bonded Assemblies*

6. REFERENCED DOCUMENTS

6.1 Loctite SP 1 *Preparation of Surfaces Prior to Adhesive Application*

6.2 ASTM E177 *Use of the Terms Precision and Bias in ASTM Methods*

6.3 ASTM E691 *Conducting an Interlaboratory Study to Determine the Precision of a Test Method*

7. APPARATUS

7.1 *Tension testing machine*, equipped with a suitable load cell. The recorded force must not differ from the true applied force by more than 1%. The machine must be capable of maintaining a constant displacement rate and be equipped with a suitable pair of self-aligning grips to hold the specimens.

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Standard Test Method

Shear Strength of Adhesives Using Lap-Shear Specimens		STM NO.	700
TITLE		1-18-08	
		ISSUE DATE	
STM-700	06-Dec-05	2	12
SUPERSEDES	DATED	PAGE NO.	OF PAGES
Ron Jones /Fergal Gordon	Rocky Hill / Dublin		
TECHNICAL CONTACT	LOCATION		

7.2 *Temperature Chamber*, designed for use with the tension testing machine for testing at low and elevated temperatures.

7.3 *Measuring device*, suitable for measuring out an overlap area.

7.4 *Clamps*, capable of applying a clamp load of 45 to 90 N (10 to 20 lbs.) such as Hargrave No. 1 spring clamps.

7.5 *Weight blocks*, weighing approximately 170 g. each and having approximate dimensions of 44.5 by 24.5 by 19.1 mm (1.75 by 1 by 0.75 in.) such as the lower half of an impact block set.

7.6 *Timing device*, appropriate for measuring specified times.

7.7 *Light source*, for UV/visible light curing, capable of producing the required intensity at the appropriate wave length as specified in the quality specification, product profile, or test program.

7.8 *Light meter and probe*, for UV/visible light curing, capable of accurately measuring the specified irradiance at the appropriate wave length.

7.9 *Assembly/cure fixture*, as shown in Figure 6, or equivalent, for use in assembling and curing specimens with UV/visible light curing adhesives .

8. TEST SPECIMENS

8.1 *Lap-shear specimens*, as specified in the quality specification, product profile, or test program. Use Loctite Standard Practice 1 for preparing the surface of the lap-shear specimens as specified in the quality specification, product profile, or test program.

8.2 *Gap spacers*, having the appropriate thickness suitable for inducing gaps in the lap-shear assemblies as specified in the quality specification, product profile, or test program. All gap spacers used must be listed on the approved test specimen list.

9. ASSEMBLY PROCEDURE FOR NON-UV/VISIBLE LIGHT CURING ADHESIVES

9.1 Assemble and test five test specimens for each test point unless additional specimens are specified in the quality specification, product profile, or test program.

9.2 If an activator or primer is specified in the quality specification, product profile, or test program, refer to Loctite Standard Practice 1 for application and proper handling of activators and primers.

9.3 Isopropyl alcohol wipe all specimens in accordance with Loctite Standard Practice 1.

9.4 The assembly procedures that follow are recommended for non-UV/visible light curing adhesives, and have been shown to give reasonably consistent results. However, it is recognized that there may be procedures that may yield equivalent results. Comparable procedures may be used if the procedures ensure that the test specimens are properly aligned, and the results are not influenced by the introduction of additional variables associated with the procedures.

9.4.1 While the assembly procedures may be varied if the criteria detailed in 9.4 is met, deviations from the techniques described for the application of the adhesive are not permitted. It is also not permissible to "swirl" or rub mating lap-shear specimens together.

9.5 Assemble **non-induced gap** specimens as follows:

9.5.1 Position lap-shear specimens as shown in Figure 1 with the prepared surfaces up.

9.5.2 For cyanoacrylate adhesive cures of ≤ 5 minutes, apply a small drop of adhesive to the prepared surface of one lap-shear specimen.

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Standard Test Method

Shear Strength of Adhesives Using Lap-Shear Specimens		STM NO.	700
TITLE		1-18-08	
		ISSUE DATE	
STM-700	06-Dec-05	3	12
SUPERSEDES	DATED	PAGE NO.	OF PAGES
Ron Jones /Fergal Gordon	Rocky Hill / Dublin		
TECHNICAL CONTACT	LOCATION		

9.5.3 For two-part adhesive systems that are not mixed prior to application, apply as follows:

9.5.3.1 *Bead-on-bead* - Apply a bead of Part A to the prepared surface of one lap-shear specimen and a bead of Part B to the prepared surface of the mating lap-shear specimen such that when the lap-shear specimens are mated the two beads contact each other fully. Apply sufficient quantities of each part so as to ensure complete coverage of a 322.6 mm² (0.5 in.²) area.

9.5.3.2 *Bead-by-bead* - Apply a bead of Part A to the prepared surface of one lap-shear specimen and a bead of Part B next to the bead of Part A on the same lap-shear specimen. Apply sufficient quantities of each part so as to ensure complete coverage of a 322.6 mm² (0.5 in.²) area.

9.5.4 For all other adhesives apply a bead of adhesive to the prepared surface of one lap-shear specimen of sufficient quantity such that when the lap-shear specimens are mated a 322.6 mm² (0.5 in.²) area will be completely covered. If necessary, spread the adhesive using an appropriate utensil (applicator stick, tongue depressor, etc.) so as to ensure complete coverage of the bond area.

Note 1 - Excess cyanoacrylate adhesive in the bond area may have an adverse effect on cured performance.

9.5.5 Taking care so as not to lift the lap-shear specimens off the work surface, turn both lap-shear specimens at once onto their inside edges such that a 12.7 mm (0.5 in.) overlap will result when the bonding surfaces are mated.

Note 2 - When plastic lap-shear specimens are used, it is permissible to decrease the overlap length in order to ensure that failure occurs in the adhesive joint rather than in the substrate.

9.5.6 Press the mating surfaces together using the thumb and index finger and clamp the assembly on each side of the bond area approximately 6.4 mm (0.25 in.) from each edge making sure that proper alignment of the lap-shear specimens is achieved.

Note 3 - When using cyanoacrylate adhesives or if a two-side primed assembly is specified, failure to assemble the bond within the minimum time period may result in inconsistent results due to premature curing of the adhesive.

9.6 Assemble **induced gap** specimens using the clamp method described in 9.6.1. If after testing, cured material is evident only in the area around the gap spacers, repeat the test following the block method described in 9.6.2.

9.6.1 Clamp Method

9.6.1.1 Apply a sufficient quantity of adhesive to the prepared surface of one lap-shear specimen such that when the mating lap-shear specimen is placed on top of the adhesive a 322.6 mm² (0.5 in.²) area will be completely covered.

9.6.1.2 Place two appropriate gap spacers into the adhesive approximately 6.4 mm (0.25 in.) in from each edge such that they extend through the bond area as shown in Figure 2.

9.6.1.3 Place the mating lap-shear specimen onto the adhesive and clamp the assembly on each side of the bond area approximately 6.4 mm (0.25 in.) from each edge making sure that proper alignment of the lap-shear specimens is achieved.

9.6.2 Block Method

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Standard Test Method

Shear Strength of Adhesives Using Lap-Shear Specimens		STM NO.	700
TITLE		1-18-08	
		ISSUE DATE	
STM-700	06-Dec-05	4	12
SUPERSEDES	DATED	PAGE NO.	OF PAGES
Ron Jones /Fergal Gordon	Rocky Hill / Dublin		
TECHNICAL CONTACT	LOCATION		

9.6.2.1 Bend an appropriate gap spacer into a "V" shape and place it onto the prepared surface of one lap-shear specimen such that the two ends of the "V" shaped gap spacer protrude approximately 1.6 mm (.0625 in.) into the 322.6 mm² (0.5 in.²) bond area. Place an additional gap spacer onto a spacer lap-shear specimen as shown in Figure 3 (spacer lap-shear specimen must be the same thickness as the lap-shear test specimen).

9.6.2.2 Apply a sufficient quantity of adhesive such that when the mating lap-shear specimen is placed on top of the adhesive, a 322.6 mm² (0.5 in.²) area will be completely covered (See Figure 4).

9.6.2.3 Place one end of the prepared surface side of the mating lap-shear specimen onto the adhesive, with the other end resting on the gap spacer on the spacer lap-shear specimen and press the mating lap-shear specimen gently until resistance from the gap spacer in the adhesive is felt.

9.6.2.4 If the gap spacer in the adhesive begins slipping out of the bond area, push it back into the bond area to the required distance using a stability stick and hold it there until resistance is felt.

9.6.2.5 Place a weight block on top of the mating lap-shear specimen over the bond area to achieve a final assembly as shown in Figure 5 taking care to ensure proper alignment of the lap-shear specimens.

9.7 Cure the adhesive assemblies as specified in accordance with the quality specification, product profile, or test program. Use an appropriate timing device to ensure that the cure time is not less than the time specified, nor greater than 110% of the time specified.

9.8 Remove all clamps or weight blocks after the specified cure time unless otherwise specified in the quality specification, product profile, or test program.

10. ASSEMBLY PROCEDURE FOR UV/VISIBLE LIGHT CURING ADHESIVES

10.1 Assemble and test five test specimens for each test point unless additional specimens are specified in the quality specification, product profile, or test program.

10.2 If an activator or primer is specified in the quality specification, product profile, or test program, refer to Loctite Standard Practice 1 for application and proper handling of activators and primers.

10.3 Isopropyl alcohol wipe all specimens in accordance with Loctite Standard Practice 1.

10.4 The assembly procedures that follow are recommended for UV/visible light curing adhesives, and have been shown to give reasonably consistent results. However, it is recognized that there may be procedures that may yield equivalent results. Comparable procedures may be used if the procedures ensure that the test specimens are properly aligned, and the results are not influenced by the introduction of additional variables associated with the procedures.

10.4.1 While the assembly procedures may be varied if the criteria detailed in 10.4 is met, deviations from the techniques described for the application of the adhesive are not permitted. It is also not permissible to "swirl" or rub mating lap-shear specimens together.

10.5 Set the light for the proper intensity at the proper wave length and map out the area where the irradiance at the bond line (through the specimen) is +10% -0% of that specified. This area is referred to as the exposure area.

Note 4 - For lights without an automatic shutter and for fixture times under 15 seconds it is strongly suggested that a sheet of non-light transmitting material is placed over the assemblies and fixture to block the light as it is positioned under the light source. The non-light transmitting sheet is then used as a shutter allowing accurate exposure times to be achieved.

10.6 Assemble **non-induced gap** specimens on an assembly/cure fixture as follows:

10.6.1 Apply a bead of adhesive to the prepared surface of one lap-shear specimen of sufficient quantity such that when the lap-shear specimens are mated a 322.6 mm² (0.5 in.²) area will be completely covered.

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Standard Test Method

Shear Strength of Adhesives Using Lap-Shear Specimens		STM NO.	700
TITLE		1-18-08	
		ISSUE DATE	
STM-700	06-Dec-05	5	12
SUPERSEDES	DATED	PAGE NO.	OF PAGES
Ron Jones /Fergal Gordon	Rocky Hill / Dublin		
TECHNICAL CONTACT	LOCATION		

10.6.2 Place one end of the prepared surface side of the mating lap-shear specimen onto the adhesive with the other end resting on the spacer lap-shear specimen (see Fig 6), and press the mating lap-shear specimen gently until resistance from the lap-shears coming together is felt.

10.6.3 Place a weight block on top of the mating lap-shear specimen to achieve a final assembly as shown in Figure 6 taking care to ensure proper alignment of the lap-shear specimens. Make sure the block is behind the bond area so as not to block any of the light during exposure.

10.6.4 Cure the lap-shear specimen(s) on the fixture under the light in the exposure area for the required exposure time specified in the quality specification, product profile, or test program.

10.7 Assemble **induced gap specimens** on an assembly/cure fixture as follows:

10.7.1 Bend an appropriate gap spacer into a "V" shape and place it onto the prepared surface of the lap-shear specimen such that the two ends of the "V" shaped spacer protrude approximately 2 mm (.0625 in.) into the 322.6 mm² (0.5in.²) bond area. Place an additional gap spacer onto a spacer lap-shear specimen as shown in Figure 7 (spacer lap-shear specimen must be the same thickness as the lap-shear test specimen).

10.7.2 Apply a sufficient quantity of adhesive to the prepared surface of the lap-shear specimen such that when the mating lap-shear specimen is placed on top of the adhesive, a 323 mm² (0.5 in.²) area will be completely covered.

10.7.3 Place one end of the prepared surface side of the mating lap-shear specimen onto the adhesive with the other end resting on the gap spacer on the spacer lap-shear specimen, and press the mating lap-shear specimen gently until resistance from the gap spacer in the adhesive is felt.

10.7.4 If the gap spacer in the adhesive begins slipping out of the bond area, push it back into the bond area to the required distance using a stability stick and hold it there until resistance is felt.

10.7.5 Place a weight block on top of the mating lap-shear specimen behind the bond area to achieve a final assembly as shown in Figure 8 taking care to ensure proper alignment of the lap-shear specimens. Make sure the block is behind the bond area so as not to block any of the light during cure.

10.7.6 Cure the lap-shear specimen(s) on the fixture under the light in the exposure area for the required exposure time specified in the quality specification, product profile, or test program.

11. TEST PROCEDURE

11.1 If adhesive assemblies are cured or aged under conditions other than ambient, allow the assemblies to return to room temperature for a period of one hr. ± 5 min. prior to testing unless otherwise specified in the quality specification, product profile, or test program.

11.2 Carry out hot and cold strength testing at the temperature specified in the quality specification, product profile, or test program in a chamber designed for use with the tension testing machine. If this type of chamber is not available, use a standard oven/chamber for the temperature soaking of the assemblies and the jaws of the testing machine, and test the assemblies within 30 seconds of removal from the oven/chamber.

11.3 After allowing for cure, and any environmental conditioning (heat aging, salt fog, etc.), as specified in the quality specification, product profile, or test program, determine the shear strength as follows:

11.3.1 Place the test specimen in the grips of the testing machine so that the outer 25.4 mm (1 in.) of each end are grasped by the jaws and so that the long axis of the test specimen coincides with the direction of applied tensile force through the center line of the grip assembly.

11.3.2 Test the assembly at a crosshead speed of 2.0 mm/min or 0.05 in./min., unless otherwise specified in the quality specification, product profile, or test program, until the assembly can no longer support a load.

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Standard Test Method

Shear Strength of Adhesives Using Lap-Shear Specimens		STM NO.	700
<small>TITLE</small>		<small>ISSUE DATE</small>	
		1-18-08	
STM-700	06-Dec-05	6	12
<small>SUPERSEDES</small>	<small>DATED</small>	<small>PAGE NO.</small>	<small>OF PAGES</small>
Ron Jones /Fergal Gordon	Rocky Hill / Dublin		
<small>TECHNICAL CONTACT</small>	<small>LOCATION</small>		

Note 5 - When testing plastic substrates, if the tension testing machine is capable of testing using a rate of loading, the assemblies may be tested at a rate of 8.3 to 9.7 MPa (1200 to 1400 psi) of shear area per minute.

11.3.3 Record the load at failure.

11.3.4 Record the failure mode when required by the quality specification, product profile, or test program.

12. CALCULATIONS

12.1 Determine the bond area as follows:

12.1.1 For a rectangular shaped bond area;

$$A = lw$$

Where A = bond area in mm² (in²)
 l = length of the bond in mm (in)
 w = width of the bond in mm (in)

12.1.2 For a circular or oval/elliptical shaped bond area;

$$\text{circle } A = \pi R^2$$

$$\text{oval/ellipse } A = \pi ab$$

where A = bond area in mm² (in²)
 $\pi = 3.1416$
 R = radius of the circle in mm (in)

where A = bond area in mm² (in²)
 $\pi = 3.1416$
 a = ½ length of major axis in mm (in)
 b = ½ length of minor axis in mm (in)

12.2 Calculate the lap-shear strength as follows:

$$S = L / A$$

Where S = lap-shear strength in N/mm² (psi)
 L = load at failure in N (lbs)
 A = bond area in mm² (in²)

13. RECORDS

13.1 Record the following information:

13.1.1 Identification of the adhesive including name or number, and lot number,

13.1.2 Identification of the lap-shear specimen used including substrate and dimensions,

13.1.3 Surface preparation used to prepare the lap-shear specimens,

13.1.4 Induced gaps, if any,

13.1.5 Cure conditions,

13.1.6 Test conditions,

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Standard Test Method

Shear Strength of Adhesives Using Lap-Shear Specimens		STM NO.	700
TITLE		1-18-08	
		ISSUE DATE	
STM-700	06-Dec-05	7	12
SUPERSEDES	DATED	PAGE NO.	OF PAGES
Ron Jones /Fergal Gordon	Rocky Hill / Dublin		
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- 13.1.7 Environmental conditioning, if any,
- 13.1.8 Number of specimens tested, if other than 5,
- 13.1.9 Results for each specimen,
- 13.1.10 Average lap-shear strength for all replicates,
- 13.1.11 Exceptions to the use of clamps, when testing non-UV/visible light curing adhesives,
- 13.1.12 Overlap length used, if other than 12.7 mm (0.5 in.),
- 13.1.13 Failure mode for each specimen when required by the quality specification, product profile, or test program,
- 13.1.14 Any deviation from this method.

14. PRECISION

14.1 An interlaboratory study was conducted, in accordance with ASTM E691, using 1 inch by 4 inch by 0.063 inch gritblasted steel lap-shear specimens. Six laboratories tested three adhesives using five replicates per adhesive. All specimens were cured for 24 hours @ 70 to 74° F and 45 to 50% relative humidity. Specimens were tested using a calibrated tensile testing machine with a 10,000 pound load cell. Values are in psi, unless otherwise noted. The following precision parameters, as defined in ASTM E177 were generated as a result of the study:

Summary of Precision Parameters

Matl	Avg	S _r	CV% _r	S _R	CV% _R	r	R
A	2663	236	8.9	399	15.0	662	1118
B	2003	200	10.0	299	14.9	561	838
C	2538	161	6.3	249	9.8	450	696

Where

- Avg = Average for the Six Laboratories
- S_r = Repeatability Standard Deviation
- CV%_r = Repeatability Coefficient of Variation
- S_R = Reproducibility Standard Deviation
- CV%_R = Reproducibility Coefficient of Variation
- r = 95% Repeatability Limit
- R = 95% Reproducibility Limit

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Standard Test Method

Shear Strength of Adhesives Using Lap-Shear Specimens		STM NO.	700
TITLE		ISSUE DATE	1-18-08
STM-700	06-Dec-05	PAGE NO.	8
SUPERSEDES	DATED	OF	12
Ron Jones /Fergal Gordon	Rocky Hill / Dublin	TECHNICAL CONTACT LOCATION	

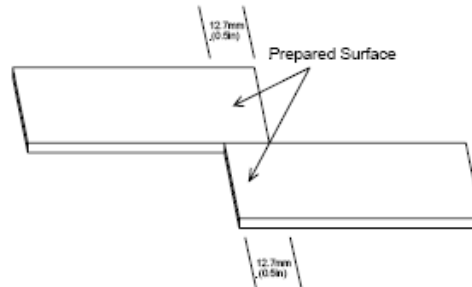


Figure 1
Position of Lap-Shear Specimens
Non-induced Gap

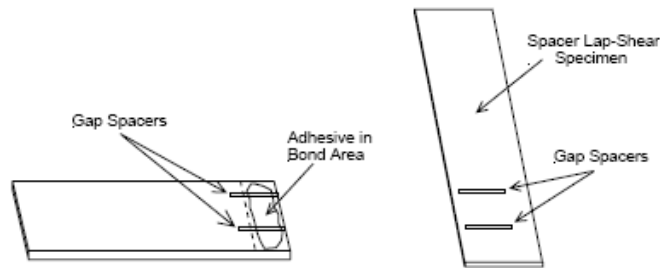


Figure 2
Gap Spacer Position
Clamp Method

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Standard Test Method

Shear Strength of Adhesives Using Lap-Shear Specimens		STM NO.	700
TITLE		ISSUE DATE	1-18-08
STM-700	06-Dec-05	PAGE NO.	9
SUPERSEDES	DATED	OF	12 PAGES
Ron Jones /Fergal Gordon	Rocky Hill / Dublin		
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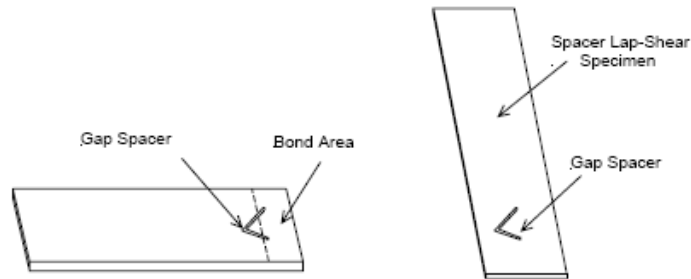


Figure 3
Gap Spacer Position
Block Method

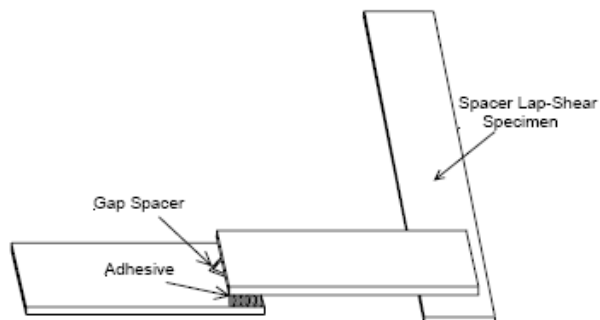


Figure 4
Mated - Gap Induced
Block Method

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Standard Test Method

Shear Strength of Adhesives Using Lap-Shear Specimens		STM NO.	700
<small>TITLE</small>		<small>ISSUE DATE</small>	
STM-700		1-18-08	
<small>SUPERSEDES</small>		<small>ISSUE DATE</small>	
06-Dec-05		10	12
<small>DATED</small>		<small>PAGE NO.</small>	<small>OF</small>
<small>TECHNICAL CONTACT</small>		<small>PAGES</small>	
Ron Jones /Fergal Gordon		Rocky Hill / Dublin	
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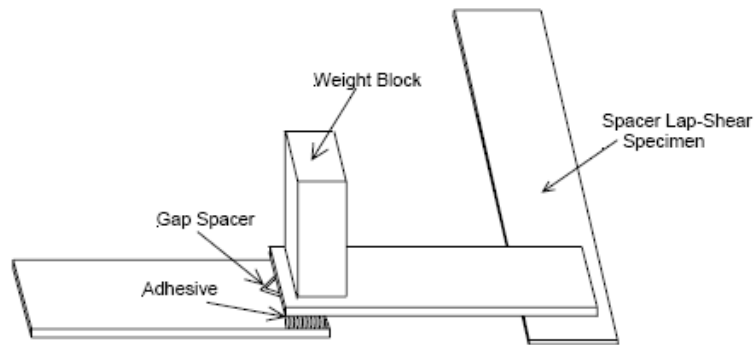


Figure 5
Gap Induced - Final Assembly
Block Method

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Standard Test Method

Shear Strength of Adhesives Using Lap-Shear Specimens		STM NO.	700
TITLE		ISSUE DATE	1-18-08
STM-700	06-Dec-05	11	12
SUPERSEDES	DATED	PAGE NO.	OF PAGES
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TECHNICAL CONTACT	LOCATION		

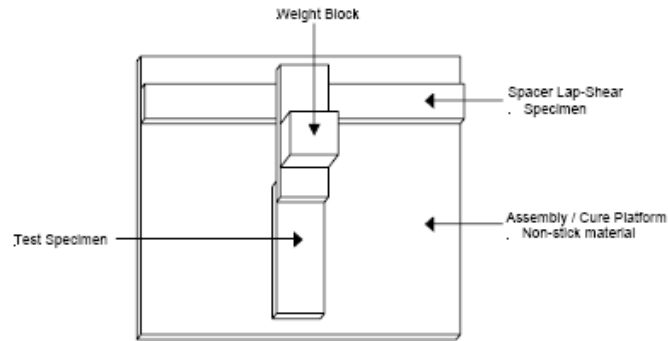


Figure 6
Assembly / Cure Fixture

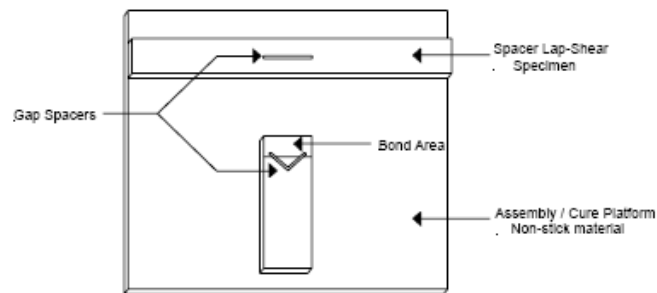


Figure 7
Gap Spacer Position

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Standard Test Method

Shear Strength of Adhesives Using Lap-Shear Specimens		STM NO.	700
<small>TITLE</small>		<small>ISSUE DATE</small>	
		1-18-08	
STM-700	06-Dec-05	12	12
<small>SUPERSEDES</small>	<small>DATED</small>	<small>PAGE NO.</small>	<small>OF</small> <small>PAGES</small>
Ron Jones /Fergal Gordon	Rocky Hill / Dublin		
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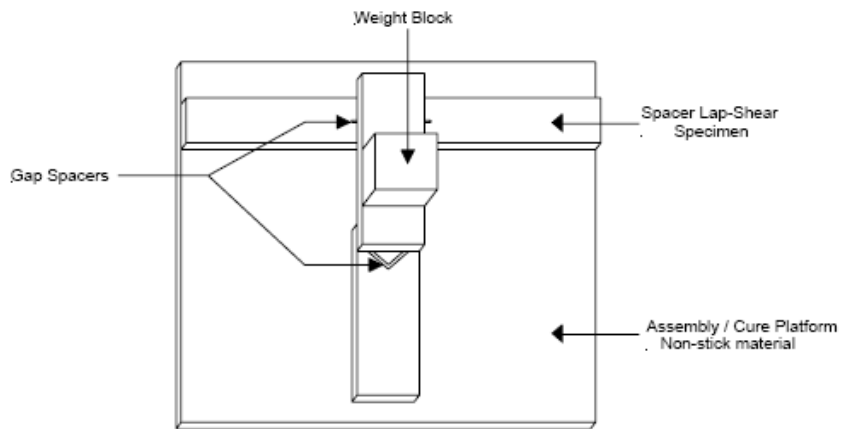


Figure 8
Gap Induced - Final Assembly

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Appendix B: Chromic Acid Bath Calculations

Composition of Chromic Acid Bath:

10 parts by weight sulfuric acid (H₂SO₄)
1 part by weight sodium dichromate (Na₂Cr₂O₇)
30 parts by weight water (H₂O)

Molecular Mass of Bath:

H₂SO₄: 98 g/mol
Na₂Cr₂O₇: 298 g/mol
H₂O: 18 g/mol

Density of Bath:

H₂SO₄: 1.84 g/mL
Na₂Cr₂O₇: 2.52 g/mL
H₂O: 1 g/mL

Assuming 10 g H₂SO₄, 1 g Na₂Cr₂O₇, and 30 g H₂O, total volume can be calculated

$$10\text{ g} \cdot 1.84 \frac{\text{g}}{\text{mL}} = 5.43\text{mL}$$

$$1\text{ g} \cdot 2.52 \frac{\text{g}}{\text{mL}} = 0.40\text{mL}$$

$$30\text{ g} \cdot 1 \frac{\text{g}}{\text{mL}} = 30\text{mL}$$

5.43 mL H₂SO₄: 15.2 % by volume
0.40 mL Na₂Cr₂O₇: 1.12 % by volume
30 mL H₂O: 83.7 % by volume

$$540\text{mL} \cdot .152 = 82.08\text{mL}$$

$$540\text{mL} \cdot .0112 = 6.05\text{mL}$$

$$540\text{mL} \cdot .837 = 451.98\text{mL}$$

$$6.05\text{mL} \cdot 2.52 \frac{\text{g}}{\text{mL}} = 15.25\text{g}$$

Chromic Acid Bath Contains:

82.08 mL H₂SO₄
15.25 g Na₂Cr₂O₇
451.98 mL H₂O

Appendix C: Adhesive Selection Testing – Raw Data

E-60HP		E-30UT		H8010		E-407L		H-4800		H8000		480		435		331		332	
Strength [psi]	Failure Mode	Strength [psi]	Failure Mode	Strength [psi]	Failure Mode	Strength [psi]	Failure Mode	Strength [psi]	Failure Mode	Strength [psi]	Failure Mode	Strength [psi]	Failure Mode	Strength [psi]	Failure Mode	Strength [psi]	Failure Mode	Strength [psi]	Failure Mode
2447	Adh/Coh	2582	Adh/Coh	2629	Cohesive	736	Adhesive	1863	Adh/Coh	2939	Cohesive	2189	Adh/Coh	1786	Adh/Coh	2431	Cohesive	1607	Cohesive
2193	Adh/Coh	2330	Adh/Coh	2545	Cohesive	552	Adhesive	2461	Adh/Coh	2954	Cohesive	2260	Adh/Coh	847	Adhesive	2409	Cohesive	1743	Cohesive
2476	Adh/Coh	2061	Adh/Coh	2922	Cohesive	568	Adhesive	2214	Adh/Coh	2918	Cohesive	2031	Adh/Coh	543	Adhesive	2160	Adh/Coh	1743	Cohesive
2139	Adh/Coh	1656	Adh/Coh	2588	Cohesive	489	Adhesive	2382	Adh/Coh	2755	Cohesive	1829	Adh/Coh	882	Adh/Coh	2170	Adh/Coh	1656	Cohesive
2022	Adh/Coh	1622	Adh/Coh	3053	Cohesive	437	Adhesive	2222	Adh/Coh	2852	Cohesive	2407	Adh/Coh	848	Adh/Coh	174	Adh/Coh	1518	Cohesive
2109	Adh/Coh	2462	Adh/Coh	2587	Cohesive	442	Adhesive	2110	Adh/Coh	2880	Cohesive	2077	Adh/Coh	1233	Adh/Coh	2237	Adh/Coh	1433	Cohesive
		2188	Adh/Coh	2504	Cohesive	394	Adhesive	2385	Adh/Coh	2826	Cohesive	2172	Adh/Coh	1745	Adh/Coh	2105	Adh/Coh	1481	Cohesive
		2074	Adh/Coh	2604	Cohesive	390	Adhesive	2445	Adh/Coh	2764	Cohesive	2331	Adh/Coh	1119	Adh/Coh	1985	Adh/Coh	1605	Cohesive
		1873	Adh/Coh	3164	Cohesive	465	Adhesive	1667	Adh/Coh	2603	Cohesive	2256	Adh/Coh	1290	Adh/Coh	1440	Adh/Coh	1680	Cohesive
		1821	Adh/Coh	2382	Cohesive	462	Adhesive	2330	Adh/Coh	2667	Cohesive	2407	Adh/Coh	913	Adh/Coh	1272	Adh/Coh	1725	Cohesive
2231		2088		2698		494		2186		2916		2207		1107		1931		1619	
187		316		257		103		266		118		159		415		438		111	
0.084		0.151		0.095		0.209		0.122		0.042		0.072		0.375		0.227		0.069	
2022		1622		2362		390		1367		2603		1929		543		1272		1433	
1060	Adhesive	2328	Cohesive	3163	Cohesive	184	Adhesive	3103	Adh/Coh	3051	Adh/Coh	866	Adhesive	1036	Adh/Coh	2305	Adh/Coh	2264	Adh/Coh
2502	Adhesive	1623	Adh/Coh	2400	Adh/Coh	592	Adhesive	3377	Adh/Coh	3123	Adh/Coh	1329	Adh/Coh	1619	Adh/Coh	1966	Adh/Coh	2023	Adh/Coh
1989	Adhesive	1578	Adh/Coh	2531	Adh/Coh	698	Adhesive	2933	Adh/Coh	2649	Adh/Coh	1873	Adh/Coh	2751	Adh/Coh	1226	Adhesive	1631	Adh/Coh
964	Adh/Coh	528	Adhesive	3160	Cohesive	541	Adhesive	3431	Adh/Coh	2184	Adh/Coh	2386	Adh/Coh	948	Adhesive	1437	Adh/Coh	1101	Adh/Coh
1976	Adh/Coh	838	Adhesive	2178	Adh/Coh	687	Adhesive	3542	Adh/Coh	2178	Adh/Coh	2267	Adh/Coh	1023	Adh/Coh	1263	Adh/Coh	1829	Adh/Coh
2032	Adh/Coh	348	Adh/Coh	2108	Adh/Coh	681	Adhesive	2966	Adh/Coh	2728	Cohesive	2244	Adh/Coh	1236	Adh/Coh	1724	Adhesive	1678	Adh/Coh
789	Adhesive	590	Adhesive	2335	Adh/Coh	526	Adhesive	3447	Adh/Coh	2886	Adh/Coh	2312	Adh/Coh	1139	Adh/Coh	1386	Adh/Coh	1531	Adh/Coh
1265	Adh/Coh	634	Adhesive	2802	Adh/Coh	731	Adhesive	3573	Cohesive	2849	Cohesive	1408	Adhesive	2738	Adh/Coh	1631	Adh/Coh	2523	Adh/Coh
468	Adhesive	1508	Adh/Coh	3163	Cohesive	285	Adhesive	3711	Cohesive	2616	Cohesive	2577	Adh/Coh	1674	Adh/Coh	981	Adhesive	2071	Adh/Coh
1903	Adh/Coh	3507	Cohesive	2977	Adh/Coh	702	Adhesive	3085	Adh/Coh	2348	Adh/Coh	1361	Adh/Coh	2054	Adh/Coh	2109	Adh/Coh	3125	Adh/Coh
1375		1623		2680		563		3320		2661		1862		1672		1604		1978	
617		1067		419		188		271		348		580		640		423		568	
0.449		0.655		0.156		0.334		0.082		0.131		0.312		0.383		0.264		0.287	
468		528		2108		184		2933		2178		866		948		981		1101	
2465	Adh/Coh																		
2723	Adh/Coh																		
1694	Adh/Coh																		
2381	Adh/Coh																		
2607	Adh/Coh																		
1659	Adhesive																		
2377	Adh/Coh																		
2603	Adh/Coh																		
2630	Cohesive																		
1512	Adh/Coh																		
2273																			
495																			
0.218																			
1512																			

Appendix D: DOE Full Minitab Results

Factorial Fit: Avg versus Treatment, Cleaning

Estimated Effects and Coefficients for Avg (coded units)

Term	Effect	Coef	SE Coef	T	P
Constant		2262.63	92.65	24.42	0.000
Treatment	831.25	415.62	92.65	4.49	0.011
Cleaning	119.75	59.87	92.65	0.65	0.553
Treatment*Cleaning	61.75	30.88	92.65	0.33	0.756

S = 262.060 PRESS = 1098810
R-Sq = 83.77% R-Sq(pred) = 35.10% R-Sq(adj) = 71.60%

The following Minitab analysis proves that, at a 95% confidence interval, the difference in bond strengths from treated to untreated assemblies is statistically significantly different.

Factorial Fit: Std Dev versus Treatment, Cleaning

Estimated Effects and Coefficients for Std Dev (coded units)

Term	Effect	Coef	SE Coef	T	P
Constant		333.63	74.75	4.46	0.011
Treatment	379.75	189.87	74.75	2.54	0.064
Cleaning	-173.75	-86.87	74.75	-1.16	0.310
Treatment*Cleaning	-132.25	-66.13	74.75	-0.88	0.426

S = 211.428 PRESS = 715230
R-Sq = 68.22% R-Sq(pred) = 0.00% R-Sq(adj) = 44.38%

The following Minitab analysis proves that, at a 93.6% confidence interval, the difference in standard deviations from treated to untreated assemblies is statistically significantly different.

Appendix E: Aluminum Powder Addition Calculations

Depth of Aluminum Oxide Layer for Chromic Acid Etching:

$$4.5 \times 10^{-6} \text{ cm}$$

Density of Aluminum:

$$2.7 \frac{\text{g}}{\text{cm}^3}$$

Average Radius of Aluminum Powder Particle:

$$0.0006 \text{ cm}$$

Surface Area of Aluminum Powder Particle:

$$4 \cdot \pi \cdot r^2 = 4 \cdot \pi \cdot 0.0006^2 = 3.7 \times 10^{-6} \text{ cm}^2$$

Volume of Aluminum Powder Particle:

$$\frac{4}{3} \cdot \pi \cdot r^3 = \frac{4}{3} \cdot \pi \cdot 0.0006^3 = 9.05 \times 10^{-10} \text{ cm}^3$$

Grams per Particle:

$$9.05 \times 10^{-10} \text{ cm}^3 \cdot \frac{2.7 \text{ g}}{\text{cm}^3} = 2.44 \times 10^{-9} \frac{\text{g}}{\text{particle}}$$

Centimeters Cubed per Particle:

$$\frac{9.05 \times 10^{-10} \text{ cm}^3}{\text{particle}} \cdot \frac{\text{particle}}{2.44 \times 10^{-9} \text{ g}} = 0.371 \frac{\text{cm}^3}{\text{g}}$$

Dimensions of Treated Surface on Aluminum Lap Shear:

$$2.54 \text{ cm} \times 2.54 \text{ cm} \times .16 \text{ cm}$$

Surface Area of Treated Surface on Aluminum Lap Shear:

$$13.38 \text{ cm}^2$$

Mass of Aluminum Powder Equivalent to Treating 1000 Lap Shears:

$$4.5 \times 10^{-6} \text{ cm} \cdot 13.38 \text{ cm}^2 = 0.00006 \text{ cm}^3 \cdot 1000 \text{ laps} = 0.06 \text{ cm}^3$$

$$0.12042 \text{ cm}^3 \cdot \frac{1 \text{ g}}{0.371 \text{ cm}^3} = 0.162 \text{ g}$$

Appendix G: STM 40



Standard Test Method

Determination of Trace Levels of Metals by Atomic Absorption or Plasma Emission		STM NO.	40
Spectroscopy		ISSUE DATE	21-Feb-06
STM-40	All Previous Issues	1	13
SUPERSEDES	DATED	PAGE NO.	OF PAGES
Martin C. Brennan	Dublin		
TECHNICAL CONTACT	LOCATION		

1. SCOPE

1.1 This test method provides procedures for determining trace levels of metals using Atomic Absorption Spectroscopy (AAS) or Plasma Emission Spectroscopy ICP-AES.

2. SIGNIFICANCE

2.1 This method is applicable to the determination of trace metal concentrations in most oil soluble/water insoluble and water-soluble materials.

3. PRINCIPLE

3.1 Preparation of oil soluble and aqueous soluble materials for metal analysis may involve neat solution/dissolution, extraction, microwave thermal ashing, micro-wave acid digestion, oxygen bomb digestion or acid leaching depending on the nature of sample and its state. Neat dissolution or extraction is carried out using methyl isobutyl ketone (MIBK), de-ionised water, 0.1M HCl solution for Atomic Absorption measurements. Similarly for Plasma Emission, neat dissolution is carried out in glacial acetic acid solution and extraction is carried out using water or dilute solution of HCl. Samples prepared by micro-wave ashing, micro-wave acid digestion, oxygen bomb digestion or acid leaching are analysed under aqueous conditions using either AAS or Plasma Emission. The absorbance or emission of the prepared solution is measured versus a series of similarly prepared metal standards prepared appropriately for non-aqueous or aqueous analysis. For acrylic accelerators, dissolution in 20% ethanol in MIBK (AAS) or 10% MIBK in acetic acid (PES) is the desired approach.

Sample preparation is as responsible for accuracy and precision as is the instrumental analysis. Many of the problems related to sample preparations are specific to individual sample matrices, analytes and instrumental methods. Although panaceas are rare, the applicability of the techniques is carefully selected based on the ease, speed of use and accuracy/reliability of results. The sensitivity of atomic spectroscopy methods is such that many metals can be determined in trace quantities in the presence of other major constituents. Nevertheless it is sometimes necessary to include a specific sample preparation technique because some major constituents are not compatible with the instrument and true signal response is different to standards without the sample. Other factors such as loss of metal and effect of nebulisation efficiency are some of the reasons for specific preparation techniques as outlined for certain samples.

4. APPARATUS - GENERAL

- 4.1 Atomic absorption spectrophotometer complete with drain vessel and loop for atomizer
- 4.2 Hollow cathode AAS lamps – single element for copper, iron, cobalt, sodium etc., as required
- 4.3 Plasma emission spectrometer, ICP-AES type
- 4.4 Computer and printer suitable for ICP-AES operation
- 4.5 Parr 1108 Oxygen Bomb with suitable water cooling system (e.g Parr 1351 Calorimeter)
- 4.6 Class A Volumetric flasks, 10 ml, 50 ml, 100 ml.
- 4.7 Class A Volumetric Pipettes
- 4.8 Analytical balance, weighing to 4 decimal places
- 4.9 Ventilation system, suitable, efficient
- 4.10 250 ml separating funnel
- 4.11 Glass vial – 20 ml
- 4.12 Micro-wave digestion apparatus completed with digestion vessels and suitable ventilation
- 4.13 Micro-wave or thermal furnace for ashing of samples
- 4.14 Platinum or other suitable dishes for ashing

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Determination of Trace Levels of Metals by Atomic Absorption or Plasma Emission		STM NO.	40
Spectroscopy		ISSUE DATE	21-Feb-06
STM-40	All Previous Issues	PAGE NO.	2 OF 13
Martin C. Brennan	Dublin		
TECHNICAL CONTACT	LOCATION		

- 4.15 250 μ L variable micropipette
- 4.16 Variable dispensers suitable for attachment to Winchester bottles
- 4.17 Sample vapour extraction unit fitted directly over the sample tray
- 4.18 Hot-plate
- 4.19 Teflon Block at least 20 x 30 cm

5. REAGENTS AND MATERIALS - GENERAL

- 5.1 Certified Ferric nitrate standard solution (1.0 ml = 1.00 mg Fe), EG BDH Cat. No. 14140.
- 5.2 Certified Cupric nitrate standard solution (1.0 ml = 1.00 mg Cu), EG BDH Cat. No. 14139.
- 5.3 Certified Cobaltous nitrate standard solution (1.0 mg Co), EG BDH Cat No. 14138.
- 5.4 Certified Zinc nitrate standard solution (1.0 mg Zn).
- 5.5 Certified Aluminum standard solution (1.0 mg Al).
- 5.6 Other single certified aqueous metal standards, solutions as required. (Na, K, Ca, Mg, etc.,)
- 5.7 Water, distilled/deionized, or Analar.
- 5.8 Chloroform, Analar grade, or equivalent.
- 5.9 Nitric acid, 10% solution, for cleaning nebulizer.
- 5.10 Hydrochloric acid, 1.0M AVS EG BDH Cat. No. 19068.
- 5.11 Conc. HCl
- 5.12 Conc. HNO₃
- 5.13 Conc. HF
- 5.14 Conc. H₂SO₄
- 5.15 Glacial Acetic Acid (GAC)
- 5.16 MIBK AnalaR grade
- 5.17 0.05 M NaOH
- 5.18 5.0 M HCl
- 5.19 PTSA (p-Toluene Sulphonic acid).
- 5.20 Ammonium pyrrolidine dithiocarbamate (APDC)
- 5.21 Ethanol or industrial methylated spirits.
- 5.22 Pure grade acetylene or equivalent, equipped with regulator and flashback safety device.
- 5.23 Pure grade compressed air supply, at least 30 psi.
- 5.24 Zero grade argon supply, at least 60 psi.

6. PROCEDURE FOR ATOMIC ABSORPTION AND INDUCTIVELY COUPLED PLASMA SPECTROSCOPY
6.1 Preparation of Metal Standards for Aqueous and Non-Aqueous Analysis
6.1.1 Preparation of Aqueous Acid Metal Standard Solutions.

Note 1- These metal standards are suitable for samples to be measured for metals content on samples as received or soluble in aqueous solutions [at 10% solution] and containing trace levels of 0.01 ppm metal or greater. Unknown samples must be prepared at a concentration known not to alter the efficiency of nebulisation from that of the prepared standards.

6.1.1.1 Prepare calibration standards stock solution by adding 10 ml aliquots of the 1000 ppm of certified standard solutions of the desired metal into a 100 ml volumetric flask and diluting to volume with 1.0M HCl [Concentration is 100 ppm [100 μ g/ml] for each metal]. This solution must be prepared weekly.

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Standard Test Method

Determination of Trace Levels of Metals by Atomic Absorption or Plasma Emission		STM NO.	40
Spectroscopy		ISSUE DATE	21-Feb-06
STM-40	All Previous Issues	PAGE NO.	3 OF 13 PAGES
Martin C. Brennan	Dublin		

6.1.1.2 Dilute the resulting stock solution mixture as prepared in 6.1.1.1 with water or 1.0M HCl as appropriate to yield working calibration standards corresponding to 0.0, 0.1, 0.25, 0.5, 1.0, 2.0, 5.0 and 10.0 µg/ml of the metals. The working standards must be prepared daily. Three of the working standards are only needed and are prepared to the appropriate level of metal in sample (e.g. samples after preparation suspected of containing ~0.05 ppm metal or less, the first three standards are prepared and those containing higher levels, the last three are prepared). Use the 0 µg/ml standard as blank. Samples containing greater than 10 ppm metal must be diluted accordingly to fit the calibration curve using the same aqueous solution as used to prepare standards.

6.1.2 Preparation of Non-Aqueous Metal Standard Solutions

6.1.2.1 Prepare a calibration standard stock solution by adding 10 ml aliquots of the 1000 ppm of certified standard solution of the desired metal into a 100 ml volumetric flask and dilute to volume with GAC. (Concentration is 100 ppm [100 µg/g] for each metal. This solution must be prepared weekly.

6.1.2.2 Dilute the resulting stock solutions prepared under 6.1.2.1 with MIBK or GAC solvent (used to prepare samples (by volume)) to yield working standard solutions corresponding to 0.0, 0.1, 0.25, 0.5, 1, 3, and 5 and 10 µg/ml of each metal in MIBK or GAC respectively. The working standards must be prepared fresh from stock solution every 24 hours. At least three working standards are required to span the range appropriate to the level of metal in the sample. Use the 0.0 ppm for the blank.

6.2 Instrument Operational Parameters and Metal Standards Calibration

6.2.1 Set up the appropriate instrument as per the manufacturer's instructions (including lamp selection, wavelength setting, slit adjustment, extraction hood switched on etc.). Allow the instrument to warm up for 15 minutes prior to use.

6.2.2 Generate standard calibration plots for each metal tested from standards prepared under 6.1.1 and 6.1.2 above as follows:

6.2.3 Read off absorbance or emission of each standard solution and construct calibration plots (µg/ml metal vs. absorbance/emission, etc.). Aspirate the blank solution between each standard for at least one minute to ensure that each reading commences from the same baseline. The calibration plot must be linear - if not, prepare a fresh set of standard calibration samples and/or check the performance of the instrument as detailed by the manufacturer.

6.3 Sample Preparation Techniques Employed in this Method:

- (a) Neat
- (b) Dilution method
- (c) Chemical separation and preconcentration
- (d) Micro-wave or Muffle furnace ashing
- (e) Micro-wave acid digestion
- (f) Oxygen bomb
- (g) Standard addition approach
- (h) Leachable metals.

6.3.1 (a) Neat

6.3.1.1 Neat analysis of sample can be carried out with ease providing sample behaves similarly to the standards (see note 3 above).

6.3.1.2 Read absorbance or emission and determine concentration from calibration curve prepared from the respective calibration standards prepared in water, MIBK or GAC where appropriate.

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Determination of Trace Levels of Metals by Atomic Absorption or Plasma Emission Spectroscopy		STM NO.	40
STM-40		ISSUE DATE	21-Feb-06
SUPersedes	DATED	PAGE NO.	OF PAGES
	All Previous Issues	4	13
Martin C. Brennan	Dublin		
TECHNICAL CONTACT	LOCATION		

6.3.2 (b) **Simple Dilution Method** (Trace metals in raw materials and finished products containing 0.01 ppm or greater at 10% dilution). *See note 3 above.

6.3.2.1 For water soluble solids or water miscible liquid samples, prepare an appropriate dilution [based on expected concentration of metal(s) of the material in water or 1.0 M hydrochloric acid (W/V)].

6.3.2.2 Similarly for aqueous insoluble solids or liquid samples, prepare appropriate dilution [based on the expected concentration of metal(s)] of the material in MIBK for AAS or GAC for ICP-AES.

6.3.2.3 Obtain absorbance or emission of the sample solution and read the conc. from the respective standard calibration plot.

6.3.3 **Assay of Acrylic Accelerators (Special Case).**

Note 2.- The level of copper, iron and cobalt used in Loctite accelerators are normally high i.e 20 - 40 ppm and 500 - 1000 ppm respectively and can be suitably diluted in a solvent without effecting the nebulisation efficiency providing the standards are prepared appropriately. (care must taken where high viscosity activators contain low levels of metals). New, unknown or competitors accelerators may require different weights/dilution in order to bring the concentration within the calibration range and such samples may need to be analysed under trial conditions before quantitative measurements can be used. See note 3 above.

6.3.3.1 **For Accelerators Containing 20-40 ppm Metal.**

6.3.3.1.1 Weigh between 2.0000 - 2.5000g of the accelerator into a 100 ml volumetric flask and dissolve in the 20% ethanol/MIBK mixture for AAS or GAC for ICP-AES measurement.

6.3.3.1.2 Obtain the absorbance or emission of the sample solution and read the concentration from the calibration plot.

6.3.3.2 **For Accelerators Containing 500-1000 ppm Metal.**

6.3.3.2.1 Weigh between 0.3000 - 0.4000g of the accelerator into a 100 ml volumetric flask and dissolve in the 20% ethanol/MIBK mixture for AAS or GAC for ICP-AES measurement.

6.3.3.2.2 Obtain the absorbance of the sample solution and read the concentration from the calibration plot.

6.3.4 (c). **Chemical Separation and Preconcentration.**

Note 3.- Aqueous samples containing less than 0.01 ppm metals cannot be accurately measured either directly or by dilution. The limit of quantification (10x S.D of background noise) is 0.01 ppm for copper and iron. Such samples need to be separated and preconcentrated by extraction into MIBK or Chloroform with a solubilising complexing agent (e.g. ammonium pyrrolidine thiocarbamate [APDC]) and measuring the concentrations of metals against standards prepared in the same solvent. The complexed metal(s) are only soluble in the MIBK or CHCl₃. These solvents can be used on the AAS, however for ICP-AES it necessary to evaporate the solvent and redissolving the metal complex(s) in GAC. This technique is applicable to aqueous raw materials that are used in metal sensitive adhesive products

Similarly aqueous insoluble liquid samples containing less than 0.01 ppm metals are dissolved in MIBK or CHCl₃ and metals are extracted into a reduced volume of weak aqueous acid solution. The extracted metals are measured against aqueous acid standards prepared in the same acid.

6.3.4.1 **Procedure for Extraction of Aqueous Samples into APDC/MIBK or APDC/CHCl₃**

6.3.4.1.1 Dissolve 1.0 gram of purified APDC in de-ionised water and dilute to 100 ml.

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Determination of Trace Levels of Metals by Atomic Absorption or Plasma Emission Spectroscopy		STM NO.	40
STM-40		ISSUE DATE	21-Feb-06
SUPersedes	DATED	PAGE NO.	OF PAGES
	All Previous Issues	5	13
Martin C. Brennan		Dublin	
TECHNICAL CONTACT		LOCATION	

6.3.4.1.2 To 25.0 ml of liquid aqueous sample solution (or 10g of solid dissolved in 50 ml of deionised water or AnalaR grade 1.0 M HCl) add 1.0 ml of APDC solution. Adjust the pH to ~5.0 with 1.0M NaOH. Transfer the solution to a 100 ml separating funnel, extract the metal complex(es) into 2 x 5.0 ml lots of MIBK /APDCor CHCl₃/APDC (may need to centrifuge to break emulsion and assist separation). Combine the extracts and aspirate into AAS. Measure the absorbance of metals in samples against standards prepared in the same solvent used to extract the metal(s). For ICP-AES measurement, evaporate 10 ml to dryness and redissolve the APDC-Metal complexes in GAC.

6.3.5.1 Procedure for Extraction of Non-Aqueous Sample into an Aqueous Solution of 0.1M HCl.

6.3.5.1.1 Twenty five grams of liquid sample is diluted in 50 ml of CHCl₃. The solution is then extracted with 2 x 10 ml of 0.1M HCl and combined (may need to centrifuge to break the emulsion and aid separation). The metal(s) content are measured against aqueous standards prepared in 0.1M HCl.

6.3.6 (d) Total Metal Content of Fillers, Thixotropes and Pigments by Muffle Furnace Preparation.

Note 4. - The dry ashing methods are preferred where possible, as the residues can be taken up in the simplest possible acid solvent. Many organic matrices are completely oxidised at 550-600 °C. It also allows large sample sizes to be 'burned off' and the ash dissolved in the minimum volume of acid solvent concentrating the metals present in the sample. Some suspect volatile elements can be ashed in the presence of p-TSA (forms metal sulphates) will be retained. Platinum dishes are used because it minimises risk of contamination from previous sample and can be readily cleaned by boiling in 1.0 M HCl and finally washing with pure distilled water and drying prior to use. The ash/salts are readily soluble in 0.1M HCl. Multiple ashing may be required for very low levels of metals (i.e repeated ashing of same sample in the same crucible over two or three times).

6.3.6.1 Prior to use, contact the platinum crucibles and lids with boiling 1.0M HCL for 10 minutes.

6.3.6.2 Rinse the crucibles with de-ionised water and carefully dry.

6.3.6.3 Mix ~5.0g of sample (maximum sample size per crucible for muffle capacity) with 0.2g of P-TSA.

6.3.6.4 Ash to 550 °C using the ramping control as follows:

- (i) 100 °C for 25 min, hold for 5 min.
- (ii) 250 " " 25 min, " " 5 "
- (iii) 450 " " 40 min, " " 5 "
- (iv) 550 " " 40 min, " " 60 "

6.3.6.5 Prepare a blank by ashing 0.2g of p-TSA.

6.3.6.6 Dissolve the residue in 10 ml of 0.1M HCl. (DO NOT USE HNO₃ WITH PLATINUM DISHES)

6.3.6.7 Read concentration against calibration curve prepared in 0.1M HCl.

6.3.7 (e) Sample Preparation Using Micro-Wave Acid Digestion.

Note 5. -This method of sample preparation is suitable for samples containing at least 0.2 ppm metal and is rapid, clean and reproducible. Maximum sample size for organics is approximately 0.5g which must be diluted to 10 ml (dilution = 5%) with a mixture of concentrated acids and water. The preferred method of quantification is carried out using standard addition approach prepared with the micro-wave digester. Duplicate sample, standards and blank can prepared in a single operation. Refer to the manufacturer's handbook for details of ramping time, pressure and temperatures for samples to be prepared by this procedure. Since this is a relatively new technique routine protocols have not been developed for this approach. Reference to manufacturers handbook may give some guide to samples that are most appropriate to this technique.

6.3.8 (f) Sample Preparation Using Oxygen Bombing Digestion.

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Standard Test Method

Determination of Trace Levels of Metals by Atomic Absorption or Plasma Emission Spectroscopy		STM NO.	40
		ISSUE DATE	21-Feb-06
STM-40	All Previous Issues	PAGE NO.	6 OF 13 PAGES
Martin C. Brennan		Dublin	
TECHNICAL CONTACT		LOCATION	

- 6.3.8.1 Contact a suitable 2.0 ml platinum dish with boiling 1.0M HCl for 10 minutes.
- 6.3.8.2 Wash with de-ionised water.
- 6.3.8.3 Charge the bomb with 0.5g of sample under test followed by 5.0 ml of 0.05M NaOH
- 6.3.8.4 Operate according to Method 205M detailed by manufacturers (Parr).
- 6.3.8.5 After firing allow to stand for 15 minutes after which it is opened slowly to allow the generated gases to escape slowly to avoid loss of sample and washed out with the minimum of deionised water to a maximum of 10 ml.
- 6.3.8.6 Read the concentration against aqueous standards prepared in 0.05M NaOH/water mixture.

6.3.9 (g) Measurement Using Standard Addition Approach.

Note 6. The principle of the method:

The sample is diluted in a solvent and aliquots of standards are added to overcome interference effects by matching standards with samples. The method corrects only for effects that modify the slope of the calibration curve, i.e. the elemental sensitivity, and not those interferences that affect the absorbance at zero concentration. This method can be applied to aqueous and non-aqueous samples.

The sample is divided into three aliquots and to each but one is added known increasing concentrations of the metal to be determined and the samples are then made up to the same volume/concentration. The curve generated is extrapolated and the concentration of metal is determined on the negative extension of the calibration line. Calibration standards containing the same concentrations but without the sample must be prepared and the curves must be parallel and passing through the origin. This method is applicable to the raw material, Matrimid 5292 A (Code 1-257).

6.3.9.1 Preparation of Aqueous and Non-Aqueous Samples for Analysis by Standard Addition Approach.

6.3.9.1.1 Three similar precise weight or volume of liquid sample or solid are transferred to volumetric flasks and known different volume of stock standard prepared under 6.3.1.1 are added to each except one. The solutions are then made up to mark with water, 1.0M HCl, MIBK or GAC where appropriate and signal response measured versus concentrations. A similar series of standards are prepared without the sample.

6.3.9.1.2 The standard addition graph is plotted and slope is extrapolated to determine the true concentration of metal in the sample.

6.3.9.1.3 A second series of standards of the same concentrations are prepared without the sample and the calibration curve must be parallel to slope and passing through the origin. If the slope is not parallel the interferences caused by the sample are too severe and recourse must be made to other forms of sample preparations eg. extraction, microwave acid digestion, ashing etc.,.

6.3.10(h) Leachable Trace Metal Contents of Fillers, Thixotropes and Pigments (Insoluble Type)

6.3.10.1 To 50 ml 1N HCl, add 5-10 g (to 4 decimal places) of material.

6.3.10.2 Stir mixture on magnetic stirrer for 60 minutes.

6.3.10.3 Filter off solid and determine the concentration against standards prepared in 1.0M HCl using either AAS or ICP-AES.

7. PROCEDURES FOR SPECIAL SAMPLE HANDLING

7.1 Metal Content of Code 3-65

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Standard Test Method

Determination of Trace Levels of Metals by Atomic Absorption or Plasma Emission Spectroscopy		STM NO.	40
STM-40		ISSUE DATE	21-Feb-06
All Previous Issues		PAGE NO.	7
Martin C. Brennan		OF	13
Dublin		PAGES	
TECHNICAL CONTACT		LOCATION	

Note 7. - This procedure is based on acid extraction of metals from Code 3-65. The Code 3-65 is heated in 1N HCl to dissolve the compound and allowed to cool to room temperature. The reprecipitated 3-65 is filtered off after cooling and the filtrate is analyzed by AAS or ICP-AES in the usual way.

- 7.1.1 Weigh accurately (to 4 decimal places) 10 grams of Code 3-65 into a 250 ml beaker. Break up any agglomerate with a clean glass rod prior to dissolution.
- 7.1.2 Add 100 ml 1N HCl (Analar grade) to this and heat to boiling to dissolve the Code 3-65. Maintain this temperature for 15-20 minutes and observe volume change and top up.
- 7.1.3 Allow to cool to room temperature and finally to 4 °C in a fridge for two hours (80-90% should reprecipitate).
- 7.1.4 Decant and Filter approximately 15-20 ml through a fast flowing filter paper.
- 7.1.5 Determine the level of copper and iron against standards prepared in the same acid on the filtrate and on the acid blank.

Note 8. - It may be necessary to evaporate to a more concentrated volume if low, inaccurate readings are obtained (N.B. evaporate the blank acid in the same way). All changes in volume must be taken into consideration in the final calculations.

72. Determination of Total Metals Content of Plastic Bottles, Beads & Powders.

Note 9. - This procedure involves ashing the sample slowly as per 6.2.4 above in the presence of p-toluene sulphonic acid. The ash residue, which should be white, is dissolved in 1M HCl and read directly against a known standard calibration curve.

- 7.2.1 Weigh accurately between 5 - 6 grams of cut fragments of plastic bottles, beads & powder into a platinum dish (previously cleaned with 1M HCl) followed by 0.1g of p-toluene sulphonic acid.
- 7.2.2 Place the sample and dish with lid into a muffle furnace at room temperature and allow to burn gradually until a temperature of 550°C is attained.
- 7.2.3 Remove the dish from the furnace and allow to cool to room temperature.
- 7.2.4 Add 5 ml of 1M HCl and heat on a hot plate for 30 - 60 seconds to dissolve the ash.
- 7.2.5 Centrifuge after cooling and read against a zinc calibration curve prepared in 1M HCl.
- 7.2.6 Ash a blank of 0.1g of p-toluene sulphonic acid and read against the same calibration curve.
- 7.2.7 Calculate metal content as follows:

$$\text{ppm metal} = \frac{\text{Reading in } \mu\text{g/ml (Ex Calibration Plot)}}{\text{weight of sample}} \times 5\text{ml}$$

7.4.3 Determination of 'Surface' Zinc Content of Aluminum Tubes

7.4.3.1 Surface Zinc Content

- 7.4.3.1.1 Fill aluminum tube with 1.0M HCl and allow to stand for 20 minutes at room temperature.
- 7.4.3.1.2 Transfer acid solution to a clean glass vial and measure absorbance against standards prepared in 1.0M HCl using AAS or ICP-AES.
- 7.4.3.1.3 Calculate 'total' or 'surface' zinc content as follows:

$$\text{ppm Surface Zn} = \frac{\text{Reading in } \mu\text{g/ml (Ex Calibration Plot)}}{\text{weight of tube used}} \times \text{ml 1 N HCl}$$

7.4 Total Metal Scan for Cyanacrylate Adhesive

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Determination of Trace Levels of Metals by Atomic Absorption or Plasma Emission Spectroscopy		STM NO.	40
STM-40		ISSUE DATE	21-Feb-06
All Previous Issues		PAGE NO.	8
		OF	13
Martin C. Brennan		DUBLIN	
TECHNICAL CONTACT		LOCATION	

Note 14. Cyanoacrylate monomers as produced in Manufacturing Plant using stainless steel reaction vessels contain very low levels of metals. In order to measure them sample preparation involves multi-ashing of the same sample in the same platinum dish.

7.4.1 Procedure

- 7.4.1.1 Spread 2.0g of TAD reagent (0.1% N-t-butyl-2-benzothiazole sulphanamide [3-147] in glycerol triacetate [4-105]) evenly over a flat Teflon block.
- 7.4.1.2 Spread 20g of CA evenly over the TAD reagent and mix with an applicator stick to aid polymerisation.
- 7.4.1.3 Collect the solid CA and break with Teflon spatula into reasonable small pieces
- 7.4.1.4 Weigh ~5.5g of solid CA into clean platinum dish and burn as per 6.3.6 above.
- 7.4.1.5 Repeat until all the sample is consumed using same dish.
- 7.4.1.6 Ash 2.0g of the TAD reagent as a blank.
- 7.4.1.7 Dissolve the residue in 1.0M HCl.
- 7.4.1.8 Scan for metals against a multi-element standards prepared 1.0M HCl

7.5 Metal Scan for Saccharin (3-2)

- 7.5.1 Three similar precise weights of saccharin (2.0g) were weight into clean 50.0 ml plastic volumetric flasks followed by ~25 ml of deionised water. Add 5.0 ml of Ammonia solution (+25% concⁿ, added in excess to maintain solubility during analysis) to the flask and shake by hand for 2-3 minutes to dissolve the saccharin. To the first flask add 0.1 ppm/ml of Cu, Fe to the flask, to the second add 0.2 ppm/ml Cu, Fe and to the third flask add 0.0 ppm/ml. Dilute to mark with de-ionised water and measure signal response versus concentrations. A similar series of samples were prepared without the sample.
- 7.5.2 Continue as for 6.3.9 above.

7.6 Metal Content of Chipbonder Products.

Note 11. *This product can be analysed using microwave acid digestion or microwave ashing method with equal reproducibility for ULTRA TRACE metals content. Extreme care in terms of accuracy, contamination and instrument calibration must be applied to ensure confidence in analysis. Extra care in handling strong acids, particularly HF must be applied. All sample preparations must be carried out in a suitable fumehood.*

7.6.1 Ashing Method Using Microwave Oven (Standard addition comparison)

- 7.5.1.1 Prior to use, contact the platinum crucibles and lids with 1.0M HCl with heat for ~5-10 minutes. Rinse with de-ionised water and dry in an oven @150 °C for 1.0 hour.
- 7.5.1.2 Prepare three samples for analysis in clean platinum dishes as follows:
 - 7.5.1.2.1 Add approximately 1.0g of chipbonder sample weighed accurately with 0.1g of p-toluene sulphonic acid.
 - 7.5.1.2.2 Add approximately 1.0g of chipbonder sample weighed accurately with 0.1g of p-toluene sulphonic acid and 0.5 ppm/g 'spike' of metals of interest from certified standard(s). (*where several elements are required 'spike' of 0.5 ppm/g of a suitable multi-element standard may be used*).
 - 7.5.1.2.3 Weigh 0.1g of p-toluene sulphonic acid to convert volatile elements to less volatile metal sulphates.

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Determination of Trace Levels of Metals by Atomic Absorption or Plasma Emission Spectroscopy		STM NO.	40
STM-40		ISSUE DATE	21-Feb-06
All Previous Issues		PAGE NO.	9
Martin C. Brennan		OF	13
Dublin		PAGES	

7.5.2 Ash slowly, using the ramping and temperature control of the microwave oven as follows:

- (i) 100 °C for 40.0 minutes, hold for 5.0 minutes
- (ii) 200 °C " " "
- (iii) 400 °C " " "
- (iv) 650 °C " " "

7.5.2.1 After cooling, add to ash (*which is mostly SiO₂*), 10.0 ml conc. HNO₃ + 2.0 ml conc. HCl. Transfer immediately to a teflon beaker with approximately 10.0 ml of deionised water washing traces of ash into the beaker. Heat gently on a hot plate to a maximum temperature of ~150 °C to reduce the volume to 25-30% of original volume. Cool add 5.0 ml conc HF and heat gently until the SiO₂ has dissolved. The volume may be further reduced to ~50%. Cool and transfer to a clean 25.0 ml plastic volumetric flask, wash and make up to mark with de-ionised water.

7.5.2.2 Analyse each sample against 0.0, 0.25, 0.5 and 1.0 ppm metal(s) standards prepared in 5.0 ml conc. HNO₃ + 5.0 ml conc. HCL + 5.0 ml conc. HF to 100.0 ml of de-ionised water in plastic volumetric flasks. A suitable internal standard (eg Sc, Y, Au etc..) is used with an ultra sonic nebuliser.

7.5.2.3 The result of subtraction of the 'spiked' metal(s) from the total should be within 90—110% of the unspiked sample.

7.5.3 **Microwave Acid Digestion Method** (*Standard addition comparison*).

7.5.3.1 Clean teflon vessels with 1.0M HCl followed by de-ionised water dry in oven @120 °C.

7.5.3.2 Prepare three samples for analysis in clean teflon vessels as follows:

7.5.3.3 Weigh accurately approximately 0.5g of chipbonder sample into a vessel ensuring that it is placed at bottom. Add 10.0 ml of conc. HNO₃ + 2.0 ml conc. HCl.

7.5.3.4 Weigh accurately approximately 0.5g of chipbonder sample into a vessel ensuring it is at the bottom and add 0.5 ppm metal(s)/g from a certified standard(s). Add 10.0 ml of conc. HNO₃ + 2.0 ml conc. HCl.

7.5.3.5 Add 10.0 ml conc. HNO₃ + 2.0 ml conc. HCl.

7.5.3.6 Allow samples to pre-digest for ~2.0 hours.

7.5.3.7 Assemble vessels suitable for microwave digestion according to manufacturer's instruction and digest as follows:

PART 1.

Stage	Watts	Power %	Ramp min.	Press. psi	Temp. °C	Hold min.
1	600	100	10.0	150	140	5.0
2	600	100	10.0	200	150	5.0
3	600	100	10.0	350	160	5.0
4	600	100	10.0	500	180	5.0
5	600	100	10.0	600	200	5.0

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Standard Test Method

Determination of Trace Levels of Metals by Atomic Absorption or Plasma Emission Spectroscopy		STM NO.	40
STM-40		ISSUE DATE	21-Feb-06
All Previous Issues		PAGE NO.	10
Martin C. Brennan		OF	13
Dublin		PAGES	

7.5.3.8 Allow the vessels to cool and open carefully in a fume hood. Add 5.0 ml of conc. HF and reassemble and digest as follows:

PART 2

Stage	Watts	Power %	Ramp min.	Press. psi	Temp. °C	Hold min.
1	600	100	30.0	150	200	15.0
2	600	100	30.0	400	210	15.0

7.5.3.9 After cooling, transfer the contents of each vessel to a 25.0 ml plastic volumetric flask and wash with deionised water up to mark.

7.5.3.10 Analyse each sample against 0.0, 0.25, 0.5, and 1.0 ppm metal(s) standards prepared in 5.0 ml conc. HNO₃ + 5.0 ml conc. HCl + 5.0 ml conc. HF in 100 ml plastic volumetric flasks. A suitable internal (Sc, Y, Au etc.,) is used with an ultra sonic nebuliser.

7.5.3.11 Similar to 7.5.2.3 above.

8. RECORDS

10.1 Record the following information:

10.1.1 Results (concentration of metals) in ppm to the nearest 0.1 ppm.

10.1.2 Any deviations from this method.

9. PRECISION

9.1 The precision of this test method is not known at this time because inter-laboratory data is not available.

ANNEX

Raw Matl.	Method	Raw Matl.	Method	Raw Matl.	Method
1-3	6.3.2.2	1-87	6.3.2.2	1-139	6.3.2.2
1-4	"	"	"	1-140	"
1-5	"	1-90	"	1-141	"
1-7	"	1-91	"	1-142	"
1-8	"	1-92	"	1-143	"
1-9	"	1-95	"	1-144	"
1-10	"	1-96	"	1-145	"
1-12	"	1-97	"	1-148	"
1-14	(50% in 0.1M HCl+ GAC)	1-98	"	1-151	"

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Standard Test Method

Determination of Trace Levels of Metals by Atomic Absorption or Plasma Emission Spectroscopy		STM NO.	40
STM-40		ISSUE DATE	21-Feb-06
All Previous Issues		PAGE NO.	11
Martin C. Brennan		OF	13
Dublin		PAGES	
TECHNICAL CONTACT		LOCATION	

1-15	(50% in 0.1M HCl+ GAC)	1-99	"	1-154	"
1-19	(C) 6.3.2.2	1-101	"	1-155	"
1-28	"	1-102	"	1-156	"
1-33	6.3.7	1-103	"	1-157	"
	6.3.2.2	1-107	"	1-158	"
1-40	"	1-111	"	1-162	"
1-41	"	1-112	"	1-163	"
1-42	6.3.7	1-116	"	1-164	"
1-43	6.3.2.2	1-117	"	1-169	"
1-44	"	1-118	"	1-170	"
1-47	"	1-119	6.3.7 (1-257)	1-172	"
1-60	"	1-120	6.3.2.2	1-173	"
1-61	"	1-121	"	1-175	"
1-63	"	1-123	"	1-176	"
1-64	"	1-125	"	1-180	"
1-65	"	1-126	"	1-181	"
1-66	"	1-129	"	1-182	"
1-69	"	1-132	"	1-183	"
1-77	"	1-134	"	1-186	"
1-79	"	1-135	"	1-205	"
			"	1-257	6.3.7
1-82	"	1-136	"	3-2	7.5
1-83	"	1-137	"	3-24	1.0N HCl See 6.3.2 (B) 10,000 fold dilution.
1-84	"	1-138	"	3-65	Aq. acid extract See 7.1

ANNEX (cont.)

Raw Matl.	Method	Raw Matl.	Method		
3-66	6.3.6	4-59	6.3.2.2		
3-76	6.3.6	4-60	6.3.7		
3-87	0.1g → 100 ml 1.0 ml → 100 ml 0.1M HCl	4-71	Ash " 6.3.7		
3-107	0.1g to 100ml MIBK 2 ml of this to 100ml with MIBK or GAC	4-75	6.3.2.2		
		4-89	6.3.7		
		4-92	6.3.2.2		
3-108	0.1g to 100ml MIBK 2 ml of this to 100ml with MIBK or GAC	4-96	6.3.7		
		4-109	6.3.7		
		4-117	Ash "		
3-131	Aq. acid extract See 7.1	4-127	See 6.3.4 (c) 6.3.2.2		
3-133	0.1g to 100ml MIBK 2 ml of this to 100ml with MIBK or GAC	4-160	Ash 6.3.7	4-55	6.3.10
		4-165	Ash "	9-75	See 6.3.9 (h) "
		4-199	6.3.2.2	9-78	"
3-135	0.1g to 100ml MIBK	5-24	6.3.10	9-80	0.2g in 5 ml Aqua regia

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Released By: Hank Temme

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Standard Test Method

Determination of Trace Levels of Metals by Atomic Absorption or Plasma Emission Spectroscopy		STM NO.	40
STM-40		ISSUE DATE	21-Feb-06
All Previous Issues		PAGE NO.	12
Martin C. Brennan		OF	13
Dublin			

TECHNICAL CONTACT	LOCATION				
	2 ml of this to 100ml with MIBK or GAC	5-35	"	9.81	0.5g → 100 water
		5-56	"	9-232	"
3-145	0.1g to 100ml MIBK	5-62	"	11-5	6.3.2.2 "
	2 ml of this to 100ml with MIBK or GAC	5-63	"	11-6	"
		5-67	"	11-7	"
3-146	0.1g → 100 ml 0.1M HCl	5-69	"	11-17	"
	2.0 ml → 100 ml 0.1M HCl				
4-1	6.3.2.2	5-70	Aq. acid extract "		
4-3	6.3.7	5-138	Aq. acid extract "		
4-4	"	7-31	6.3.7		
4-13	"	7-80	6.3.2.2		
4-14	"	9-1	0.1g → 100 ml 0.1M HCl 0.1 ml → 100 ml 0.1M HCl		
4-15	"	9-40	6.3.10		
4-20	6.3.2.2	9-51	"		
4-23	"	9-60	"		
4-24	"	9-62	"		
4-34	"	9-67	"		
4-44	6.3.7	9-70	"		

ANNEX (cont.)
Copper Analysis of Anaerobic Activators by AAS or ICP-OES

Product Number	Bulk Number	Conc. of Copper in Activator (ppm)	Dilution Factor (wt/vol)	Avg Results via AAS (ppm) as µg/ml
LID 3074	178074	3200	2.0g → 100ml MIBK 5 ml → 100ml MIBK or GAC	3.20
LID 3075	178075	3200	2.0g → 100ml MIBK 5 ml → 100ml MIBK or GAC	3.20
7649	178276	850	0.5g → 100ml MIBK or GAC	4.25
7639	178280	40000 (4.0%)	1.0g → 100ml MIBK 1 ml → 100ml MIBK or GAC	4.00
7641	178539	850	5.0g → 100ml MIBK	4.25
734	170034	360	5.0g → 100ml MIBK or GAC	3.60
7851	178006	7.5	5.0g → 100ml MIBK or GAC	0.75
LID 3013	178013	360	5.0g → 100ml MIBK or GAC	3.60
7342	178017	360	5.0g → 100ml MIBK or GAC	3.60
7386	178278	30	5.0g → 100ml MIBK or GAC	1.50
7407	178279	70	5.0g → 100ml MIBK or GAC	3.50
7406	178314	72	5.0g → 100ml MIBK or GAC	3.60
7388	178415	22.5	5.0g → 100ml MIBK or GAC	1.50
LID 3195	178195	4000	5.0g → 100ml MIBK	4.00

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Standard Test Method

Determination of Trace Levels of Metals by Atomic Absorption or Plasma Emission		STM NO.	40
Spectroscopy		ISSUE DATE	21-Feb-06
STM-40	All Previous Issues	PAGE NO.	13
Martin C. Brennan		OF	13
Dublin		PAGES	
5 ml →100ml MIBK or GAC			

NOTE: The above dilutions are designed to measure copper content against a calibration curve of linear range of 0.0 → 10.0 ppm copper. A second serial dilution by volume is required for the more concentrated activators. The average results listed in the table are at the lower end of the calibration curve to avoid over loading the sample in MIBK or GAC so that the sample/solvent effect will be minimum when compared with standards prepared in MIBK or GAC only. Consult the operator's manual to determine the recommended linear range of copper for the particular instrument and conditions used.

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Appendix K: Phosphoric Acid Anodizing Specifications

AEROSPACE DEFENSE COATINGS Of Georgia, Inc.		7700 N. E. Industrial Blvd. Macon, GA 31206	Ph: 912.784.8594 Fx: 912.784.9199	Order Number 264701	Load Code 1 69	
Henkel Corporation Rocky Hill CT 06067		Tar: Req: Via:	In: Thu 02/12/09 By:	Ph: 1-860-571-5100 Fx: PI: 02/11/09	COD	
					Page 1 of 5	
#	Qty	Part Number / Part Name / Part Description			Ea Wt.	Line Wt.
1	600	TS-201 ALUMINUM LAP SHEARS			0	0
	600	Order Qty: Order Net:	600 0	Load Qty: Load Net:	600 0	0
CONTAINERS	Number	Qty	Gross Wt.	Tare	Net	
Box	1	600	0	0	0	
Pr: Inspection		Mat: Specified Above		ID: GENERAL		
INSPECTION	Scale	Min	Max			
Other						
Process Steps						
1 Receiving						
MASTER RECEIVING - PLANNING						
Received in via <u>FED-EX</u>						
Freight Charges: <u>N/A</u>						
Receiving Inspection:						
Count parts and enter total here _____						
If count does not match customer shipper or damage is noted, call customer prior to releasing work.						
Enter the name of the person you notified <u>600</u> <i>Please call Dustin for credit</i>						
Date and time you notified them: <u>1/1</u> @ <u>12</u> : <u>00</u> am pm						
Comments: _____						
Did we receive a print with the parts? Yes / <input checked="" type="radio"/> No (circle one) <i>card info</i>						
Inspect parts for nicks, dings, and scratches:						
No damage <u>Henry Hester</u> sign <i>Ph. (860) (571) (5100) Ext. 3060</i>						
If parts are damaged refer them to Quality for disposition.						
Do parts require gages for processing? Yes / <input checked="" type="radio"/> No (circle one)						
CONTRACT REVIEW:						
The customer's purchase order has been compared to ADC's work order and complies with 3.3.1 of NADCAP document AC 7108 rev B. The order can be released to production.						
<u>Henry Hester</u> Contract Review Authorization						
INTERNAL PROCEDURES - CONTRACT REVIEW (ADC-003) & RECEIVING (ADC-REC-000)						
Finished: _____ Qty: <u>600</u>						

**AEROSPACE DEFENSE COATINGS
Of Georgia, Inc.**

7700 N. E. Industrial Blvd. Ph: 912.784.8594
Macon, GA 31206 Fx: 912.784.9199

Order Number Load Code
264701 1 69

Henkel Corporation
Rocky Hill CT 06067
Po:

Tar:
Req:
Via:

In: Thu 02/12/09
By:

Ph: 1-860-571-5100
Fx:
Pl: 02/11/09

COD

Page 2 of 5

Process Steps

2 Clean

Alkaline Clean IAW ASTM D3933

Prior to beginning check rinse tanks for conductivity (must be < 350 micromhos/cm)

OK to proceed K.I Operator int.

(a) Soak in Isoprep 44 alkaline cleaner @ 140-160 deg F for 10-20 minutes using 2-3 flushes (up and down into solution).

Tank Temperature: 150 degrees F.

Total Immersion time: 10 mins.

Rinse 30 seconds minimum.

Spray rinse to remove excess cleaner.

Warm water rinse. (tank must have air agitation on with a temperature range of 130-150 deg. F) During this process, parts must be lowered and raised at least 3 times. Warm water rinse time shall be at least 3 minutes.

Tank Temperature: 140 degrees F.

Total Immersion Time: 4 min

Cold water rinse. (tank must have air agitation on) Tank temperature must not exceed 95 deg F.)

Tank Temperature: Amb degrees F.

Inspect for cleanliness and water break free surfaces OK.

If necessary, reprocess to complete cleaning. If parts are reprocessed record date and time below.

Time/Date: _____ (am/pm) ___/___/___

Inspection Complete _____

Parts Reprocessed from this operation: YES NO

Date and time reprocessing finished: _____

Reprocess operator: _____

Finished: _____

Qty: 26 ^{HT}

600 ^{HT}

220

**AEROSPACE DEFENSE COATINGS
Of Georgia, Inc.**

7700 N. E. Industrial Blvd. Ph: 912.784.8594
Macon, GA 31206 Fx: 912.784.9199

Order Number Load Code
264701 1 69

Henkel Corporation
Rocky Hill CT 06067
Po:

Tar:
Req:
Via:

In: Thu 02/12/09
By:

Ph: 1-860-571-5100
Fx:
Pl: 02/11/09

COD

Page 3 of 5

Process Steps

3 Phosphoric

CAUTION: PROCESS MUST BE CONTINUOUS. DO NOT ALLOW PARTS TO DRY BETWEEN PROCESSES.

Phosphoric Acid Deoxidation (PAD)

Immerse parts in the phosphoric acid solution for 8 to 12 minutes. Increase the potential of 7+-1 volts DC at a rate increase of 2 to 7 volts / minute.

Time in solution 10 minutes

DO NOT AGITATE SOLUTION WHILE PARTS ARE IMMersed.

Rinse for 5 minutes minimum. DO NOT ALLOW MORE THAN 1.5 MINUTES BETWEEN ANODIZE AND RINSE.

Rinse until parts are water break free K.I OK (Tech Initials)

PHOSPHORIC ANODIZE:

Immerse parts in phosphoric acid solution IAW ASTM D3933.

Raise voltage to a potential of 15+- 1 volts DC for 20 to 25 minutes. Begin with 5 volts maximum and increase 4 volts per minute.

Remove parts from solution and rinse for 5 to 15 minutes.

Rinse water shall not exceed 110 degrees Maximum.

Parts shall be water break free K.I tech initials

Dry parts using air no hotter than 160 degrees F.

Finished: _____ Qty: 220

4 Inspection

Inspect Phosphoric Acid Anodize

The anodic coating should be continuous, smooth, uniform in appearance, and free from discontinuities such as abrasion, breaks, burned areas, and areas that are not anodized when examined visually within the following limitations:

(a) On clad material, minor burns and pits that do not penetrate through the cladding to the base metal are acceptable

(b) On bare material, pits that have round bottoms and are clear of foreign material are acceptable. Maximum depth is 0.003 inch

(c) Unanodized surfaces under electrical contacts are acceptable

There shall be no Smut on the detail parts after anodize.

There shall be not stains which were a result of improper processing

Abrupt differences in color of local areas are unacceptable

VISUAL INSPECTION: PASS FAIL

VERIFICATION OF PRESENCE OF ANODIC COATING: PASS FAIL

Finished: _____ Qty: 220

AEROSPACE DEFENSE COATINGS 7700 N. E. Industrial Blvd. Ph: 912.784.8594
Of Georgia, Inc. Macon, GA 31206 Fx: 912.784.9199

Order Number Load Code
264701 1 69

Henkel Corporation Tar: In: Thu 02/12/09 Ph: 1-860-571-5100
Rocky Hill CT 06067 Req: By: Fx:
Po: Via: PI: 02/11/09

COD

Page 4 of 5

Process Steps

5 Paint

BR 127 per ASTM E866-96

***** WARNING! *****

The primer must be applied within 16 hours of FPL Etch cleaning performed above.
Handle parts with CLEAN lint free gloves ONLY.

***** WARNING! *****

Assure BR-127 has been allowed to come to room temperature prior to use.
BR-127 must be vigorously agitated for 15 minutes minimum immediately prior to use.
During application, BR-127 must be continuously agitated in the pot or cup.
Apply primer ONLY when temperature is 60-90 deg and RH <= 75%.

Record the following information:

Pressure used 30

Batch Number of BR-127: 7473

Expire Date: 10-1-09

Time & Date of application: 10:30 AM 2-13-09

Temperature & RH: 70 deg F 40 % RH

Paint Manufacturer: CYTEC

Apply BR-127 per ASTM E866-96 with constant vigorous agitation to surfaces to be primed in smooth cross pattern assuring uniform coverage. Thickness to be 0.0001" - 0.0003" only.

Allow to air dry for a minimum of 30 minutes until tack free.

Force cure 250 deg F for 1.0 - 1.5 hours.

Finished: _____ Qty: 220

6 Inspection

Inspect BR-127 primer:

Workmanship: PASS

Thickness:

Min: .0001

Max: .0002

Mean: .00019

Finished: _____ Qty: 220

AEROSPACE DEFENSE COATINGS
Of Georgia, Inc. 7700 N. E. Industrial Blvd. Ph: 912.784.8594
Macon, GA 31206 Fx: 912.784.9199

Order Number Load Code
264701 1 69

Henkel Corporation Tar: In: Thu 02/12/09 Ph: 1-860-571-5100
Rocky Hill CT 06067 Req: By: Fx:
Po: Via: Pl: 02/11/09

COD

Page 5 of 5

Process Steps

7 Inspection

FINAL INSPECTION *** FINAL INSPECTION *** FINAL INSPECTION

ADC INTERNAL PROCEDURE - ADC-010 INSPECTION AND TESTING

SAMPLE PLAN USED: (CHECK ONE) THIS IS THE NADCAP ORDER OF PRECEDENCE!!!

- A. PER CUSTOMER PURCHASE ORDER
- B. SPECIFICATION _____ (this is the location of sample plan)
- C. SAMPLING PLAN PER: ADC-SMPL-000 REV "A"

WORKMANSHIP: PASS / FAIL (circle one)

VISUAL INSPECTION OF QUALITY AND OVERALL COMPLIANCE TO CUSTOMER PURCHASE ORDER

STATUS: Lot Accepted Lot Rejected SAMPLE SIZE USED 10090

INSPECTOR STAMP _____ INITIALS KI Finished: _____ Qty: 220

8 Inspection

CERTIFICATE OF COMPLIANCE (C of C)

This document certifies that the items described above have been processed in accordance with the requirements specified in the drawings, specifications, contract(s), and purchase order referenced herein.

Sign: Henry Weste Title: Metal Test Date: 2-13-09 Finished: _____ Qty: 220

9 Shipping

Packaging in accordance with AC 7108 para 3.5.1(14) and ADC-015

This job has been packed by Henry Weste

Should you have any problems with the packing or should the parts arrive damaged please contact Quality Manager 478-784-8594 and give them my name and stamp number.

Thanks for allowing me to serve you.

Shipped Via: _____ Finished: _____ Qty: 220

Appendix L: Comparative Analysis Raw Data

Run	Strength	Failure Mode	Run	Strength	Failure Mode	Run	Strength	Failure Mode	Run	Strength	Failure Mode	Run	Strength	Failure Mode
1-1	3848	Cohesive	2-1	1872	Adh/Coh	3-1	1841	Adh/Coh	4-1	4043	Cohesive	5-1	1435	Adh/Coh
1-2	3303	Cohesive	2-2	2434	Adh/Coh	3-2	1520	Adh/Coh	4-2	4204	Cohesive	5-2	1387	Adh/Coh
1-3	3537	Cohesive	2-3	1014	Adh/Coh	3-3	1140	Adh/Coh	4-3	4457	Cohesive	5-3	685	Adh/Coh
1-4	3120	Cohesive	2-4	165	Adh/Coh	3-4	1519	Adh/Coh	4-4	4925	Cohesive	5-4	1149	Adh/Coh
1-5	2724	Adh/Coh	2-5	1803	Adh/Coh	3-5	2241	Adh/Coh	4-5	3660	Adh/Coh	5-5	1517	Adh/Coh
1-6	2343	Adh/Coh	2-6	748	Adh/Coh	3-6	1670	Adh/Coh	4-6	3672	Cohesive	5-6	1790	Adh/Coh
1-7	2473	Cohesive	2-7	1709	Adh/Coh	3-7	2528	Adh/Coh	4-7	4233	Cohesive	5-7	2452	Adh/Coh
1-8	2164	Cohesive	2-8	1486	Adh/Coh	3-8	2131	Cohesive	4-8	3043	Cohesive	5-8	3105	Adh/Coh
1-9	2518	Cohesive	2-9	1994	Adh/Coh	3-9	2360	Adh/Coh	4-9	3816	Cohesive	5-9	2882	Adh/Coh
1-10	2418	Cohesive	2-10	114	Adh/Coh	3-10	1724	Adh/Coh	4-10	3831	Cohesive	5-10	2168	Adh/Coh
6-1	2740	Cohesive	7-1	Broke	Cohesive	8-1	2188	Adh/Coh	9-1	1504	Adh/Coh	10-1	387	Adh/Coh
6-2	2401	Cohesive	7-2	Broke	Cohesive	8-2	1905	Adh/Coh	9-2	1298	Adh/Coh	10-2	182	Adh/Coh
6-3	2196	Cohesive	7-3	Broke	Cohesive	8-3	1527	Adh/Coh	9-3	1004	Adh/Coh	10-3	269	Adh/Coh
6-4	2611	Adh/Coh	7-4	Broke	Cohesive	8-4	1391	Adh/Coh	9-4	1249	Adh/Coh	10-4	289	Adh/Coh
6-5	2598	Cohesive	7-5	Broke	Cohesive	8-5	2251	Cohesive	9-5	1234	Adh/Coh	10-5	261	Adh/Coh
6-6	3039	Cohesive	7-6	Broke	Cohesive	8-6	2100	Adh/Coh	9-6	1417	Adh/Coh	10-6	249	Adh/Coh
6-7	2493	Cohesive	7-7	Broke	Cohesive	8-7	1958	Adh/Coh	9-7	1215	Adh/Coh	10-7	343	Adh/Coh
6-8	2292	Cohesive	7-8	Broke	Cohesive	8-8	571	Adh/Coh	9-8	1456	Adh/Coh	10-8	Broke	Adh/Coh
6-9	2457	Adh/Coh	7-9	Broke	Cohesive	8-9	1470	Adh/Coh	9-9	1325	Adh/Coh	10-9	188	Adh/Coh
6-10	2390	Cohesive	7-10	639	Cohesive	8-10	932	Adh/Coh	9-10	1299	Adh/Coh	10-10	354	Adh/Coh
11-1	2836	Adh/Coh	12-1	1637	Adh/Coh	13-1	1773	Adh/Coh	14-1	2564	Cohesive	15-1	2871	Adh/Coh
11-2	3192	Cohesive	12-2	1899	Adh/Coh	13-2	1977	Adh/Coh	14-2	2249	Cohesive	15-2	2886	Adh/Coh
11-3	3000	Cohesive	12-3	1399	Adh/Coh	13-3	2286	Adh/Coh	14-3	2552	Cohesive	15-3	2741	Adh/Coh
11-4	2917	Cohesive	12-4	1939	Adh/Coh	13-4	2061	Adh/Coh	14-4	2580	Cohesive	15-4	3365	Adh/Coh
11-5	3132	Cohesive	12-5	2502	Adh/Coh	13-5	1993	Adh/Coh	14-5	2892	Cohesive	15-5	3169	Adh/Coh
11-6	3138	Cohesive	12-6	Broke	Adh/Coh	13-6	2450	Adh/Coh	14-6	2445	Cohesive	15-6	3021	Adh/Coh
11-7	2580	Adh/Coh	12-7	1362	Adh/Coh	13-7	1958	Adh/Coh	14-7	2650	Cohesive	15-7	3209	Adh/Coh
11-8	2988	Adh/Coh	12-8	2026	Adh/Coh	13-8	963	Adh/Coh	14-8	2424	Cohesive	15-8	2919	Adh/Coh
11-9	3056	Cohesive	12-9	1122	Adh/Coh	13-9	2074	Adh/Coh	14-9	2028	Cohesive	15-9	2898	Adh/Coh
11-10	3134	Cohesive	12-10	1515	Adh/Coh	13-10	2098	Adh/Coh	14-10	2991	Cohesive	15-10	2841	Adh/Coh

16-1	2577	Cohesive	17-1	2859	Cohesive	18-1	1686	Cohesive	19-1	3587	Cohesive	20-1	1790	Cohesive
16-2	2816	Cohesive	17-2	2503	Cohesive	18-2	1492	Cohesive	19-2	3938	Cohesive	20-2	1734	Cohesive
16-3	2412	Cohesive	17-3	2365	Cohesive	18-3	1673	Cohesive	19-3	3754	Cohesive	20-3	2079	Cohesive
16-4	2457	Cohesive	17-4	2380	Cohesive	18-4	1690	Cohesive	19-4	2759	Cohesive	20-4	1858	Cohesive
16-5	2555	Cohesive	17-5	1706	Cohesive	18-5	1917	Cohesive	19-5	3319	Cohesive	20-5	1750	Cohesive
16-6	2478	Cohesive	17-6	2320	Cohesive	18-6	1594	Cohesive	19-6	3361	Cohesive	20-6	1746	Cohesive
16-7	2562	Cohesive	17-7	2299	Cohesive	18-7	1958	Cohesive	19-7	3061	Cohesive	20-7	1957	Cohesive
16-8	2495	Cohesive	17-8	2651	Cohesive	18-8	1689	Cohesive	19-8	2990	Cohesive	20-8	1753	Cohesive
16-9	2648	Cohesive	17-9	2127	Cohesive	18-9	1681	Cohesive	19-9	3492	Cohesive	20-9	1649	Cohesive
16-10	2630	Cohesive	17-10	2296	Cohesive	18-10	1936	Cohesive	19-10	2898	Cohesive	20-10	1814	Cohesive
21-1	2253	Cohesive	22-1	2533	Cohesive	23-1	1430	Cohesive	24-1	1656	Cohesive	25-1	132	Adh/Coh
21-2	2326	Cohesive	22-2	1842	Cohesive	23-2	1737	Cohesive	24-2	2145	Cohesive	25-2	340	Adh/Coh
21-3	2217	Cohesive	22-3	2485	Cohesive	23-3	1597	Adh/Coh	24-3	1918	Cohesive	25-3	314	Adh/Coh
21-4	2364	Cohesive	22-4	2011	Cohesive	23-4	1904	Cohesive	24-4	1642	Cohesive	25-4	396	Adh/Coh
21-5	2157	Cohesive	22-5	3001	Cohesive	23-5	1624	Cohesive	24-5	1827	Cohesive	25-5	255	Adh/Coh
21-6	2283	Cohesive	22-6	2172	Cohesive	23-6	1660	Cohesive	24-6	1776	Cohesive	25-6	333	Adh/Coh
21-7	2454	Cohesive	22-7	2596	Cohesive	23-7	1905	Cohesive	24-7	1968	Cohesive	25-7	362	Adh/Coh
21-8	1969	Adh/Coh	22-8	1920	Cohesive	23-8	1498	Cohesive	24-8	1812	Cohesive	25-8	Broke	Adh/Coh
21-9	2190	Cohesive	22-9	2225	Cohesive	23-9	1519	Cohesive	24-9	1780	Cohesive	25-9	125	Adh/Coh
21-10	2425	Cohesive	22-10	2179	Cohesive	23-10	1762	Cohesive	24-10	2088	Cohesive	25-10	381	Adh/Coh
26-1	2174	Cohesive	27-1	1561	Cohesive	28-1	2023	Cohesive	29-1	1892	Cohesive	30-1	2436	Cohesive
26-2	2069	Cohesive	27-2	1826	Cohesive	28-2	1866	Cohesive	29-2	2386	Cohesive	30-2	2337	Cohesive
26-3	2119	Cohesive	27-3	2179	Cohesive	28-3	1970	Cohesive	29-3	2077	Cohesive	30-3	2282	Cohesive
26-4	1982	Cohesive	27-4	1999	Cohesive	28-4	1846	Cohesive	29-4	2008	Cohesive	30-4	2275	Cohesive
26-5	2265	Cohesive	27-5	1938	Cohesive	28-5	1841	Cohesive	29-5	2108	Cohesive	30-5	2081	Cohesive
26-6	1997	Cohesive	27-6	1999	Cohesive	28-6	1666	Cohesive	29-6	2097	Cohesive	30-6	2268	Cohesive
26-7	2141	Cohesive	27-7	1920	Cohesive	28-7	2074	Cohesive	29-7	1848	Cohesive	30-7	2460	Cohesive
26-8	2143	Cohesive	27-8	1884	Cohesive	28-8	1773	Cohesive	29-8	1909	Cohesive	30-8	2459	Cohesive
26-9	2130	Cohesive	27-9	1837	Cohesive	28-9	1951	Cohesive	29-9	1995	Cohesive	30-9	2107	Cohesive
26-10	2271	Cohesive	27-10	2064	Cohesive	28-10	1978	Cohesive	29-10	2038	Cohesive	30-10	2233	Cohesive

31-1	2223	Cohesive	32-1	2558	Adh/Coh	33-1	2630	Adh/Coh	34-1	2361	Adh/Coh	35-1	1418	Adh/Coh
31-2	2663	Cohesive	32-2	2716	Cohesive	33-2	2567	Adh/Coh	34-2	2793	Adh/Coh	35-2	1807	Adh/Coh
31-3	2254	Cohesive	32-3	2813	Cohesive	33-3	2005	Adh/Coh	34-3	1974	Adh/Coh	35-3	1597	Adh/Coh
31-4	2884	Adh/Coh	32-4	2793	Cohesive	33-4	2181	Adh/Coh	34-4	2073	Adh/Coh	35-4	1555	Adh/Coh
31-5	2315	Cohesive	32-5	2793	Cohesive	33-5	2504	Cohesive	34-5	2398	Adh/Coh	35-5	1390	Adh/Coh
31-6	3018	Cohesive	32-6	2544	Cohesive	33-6	2427	Adh/Coh	34-6	2099	Adh/Coh	35-6	1698	Adh/Coh
31-7	2589	Cohesive	32-7	2215	Cohesive	33-7	2291	Cohesive	34-7	2519	Adh/Coh	35-7	1507	Adh/Coh
31-8	3133	Cohesive	32-8	2536	Cohesive	33-8	2396	Cohesive	34-8	2201	Adh/Coh	35-8	1523	Adh/Coh
31-9	3016	Cohesive	32-9	2557	Cohesive	33-9	2043	Cohesive	34-9	2440	Adh/Coh	35-9	1361	Adh/Coh
31-10	2990	Cohesive	32-10	2093	Cohesive	33-10	2425	Cohesive	34-10	2338	Adh/Coh	35-10	1529	Adh/Coh
36-1	1816	Adh/Coh	37-1	1369	Adh/Coh	38-1	1012	Adh/Coh	39-1	550	Cohesive	40-1	137	Cohesive
36-2	1699	Adh/Coh	37-2	1311	Adh/Coh	38-2	828	Adh/Coh	39-2	785	Cohesive	40-2	Broke	Cohesive
36-3	1195	Adh/Coh	37-3	1377	Adh/Coh	38-3	1022	Adh/Coh	39-3	724	Cohesive	40-3	Broke	Cohesive
36-4	1860	Adh/Coh	37-4	1269	Adh/Coh	38-4	952	Adh/Coh	39-4	859	Cohesive	40-4	2	Cohesive
36-5	1579	Adh/Coh	37-5	1323	Adh/Coh	38-5	1076	Adh/Coh	39-5	967	Cohesive	40-5	3	Cohesive
36-6	1888	Adh/Coh	37-6	1442	Adh/Coh	38-6	804	Adh/Coh	39-6	729	Cohesive	40-6	2	Cohesive
36-7	1642	Adh/Coh	37-7	1086	Adh/Coh	38-7	1103	Adh/Coh	39-7	725	Cohesive	40-7	18	Cohesive
36-8	1618	Adh/Coh	37-8	1329	Adh/Coh	38-8	725	Adh/Coh	39-8	928	Cohesive	40-8	141	Cohesive
36-9	1745	Adh/Coh	37-9	1027	Adh/Coh	38-9	1067	Adh/Coh	39-9	1097	Cohesive	40-9	2	Cohesive
36-10	1823	Adh/Coh	37-10	1248	Adh/Coh	38-10	909	Adh/Coh	39-10	769	Cohesive	40-10	108	Cohesive
41-1	2782	Cohesive	42-1	2572	Adh/Coh	43-1	2356	Adh/Coh	44-1	1679	Adh/Coh	45-1	1589	Adh/Coh
41-2	1971	Adh/Coh	42-2	2079	Cohesive	43-2	2372	Adh/Coh	44-2	1757	Adh/Coh	45-2	1710	Adh/Coh
41-3	2356	Cohesive	42-3	2597	Cohesive	43-3	2269	Adh/Coh	44-3	1722	Adh/Coh	45-3	1577	Adh/Coh
41-4	2598	Cohesive	42-4	2570	Adh/Coh	43-4	2272	Cohesive	44-4	2139	Adh/Coh	45-4	1802	Adh/Coh
41-5	2558	Cohesive	42-5	2429	Adh/Coh	43-5	2374	Adh/Coh	44-5	1419	Adh/Coh	45-5	1506	Adh/Coh
41-6	2444	Cohesive	42-6	2327	Adh/Coh	43-6	2472	Cohesive	44-6	1741	Adh/Coh	45-6	1679	Adh/Coh
41-7	2549	Cohesive	42-7	2374	Cohesive	43-7	2394	Cohesive	44-7	1686	Adh/Coh	45-7	1947	Adh/Coh
41-8	2646	Cohesive	42-8	2338	Adh/Coh	43-8	2384	Cohesive	44-8	1509	Adh/Coh	45-8	1765	Adh/Coh
41-9	2536	Cohesive	42-9	2622	Cohesive	43-9	2372	Cohesive	44-9	1813	Adh/Coh	45-9	1711	Adh/Coh
41-10	2666	Cohesive	42-10	2453	Cohesive	43-10	2108	Cohesive	44-10	1823	Adh/Coh	45-10	1425	Adh/Coh

46-1	2539	Adh/Coh	47-1	1979	Cohesive	48-1	1788	Adh/Coh	49-1	1718	Adh/Coh	50-1	811	Adh/Coh
46-2	2719	Adh/Coh	47-2	1766	Cohesive	48-2	2178	Adh/Coh	49-2	2243	Adh/Coh	50-2	626	Adh/Coh
46-3	2628	Adh/Coh	47-3	2006	Cohesive	48-3	1756	Adh/Coh	49-3	1662	Adh/Coh	50-3	754	Adh/Coh
46-4	3212	Adh/Coh	47-4	1820	Cohesive	48-4	1804	Adh/Coh	49-4	1734	Adh/Coh	50-4	766	Adh/Coh
46-5	2832	Adh/Coh	47-5	1950	Cohesive	48-5	1896	Adh/Coh	49-5	1360	Adh/Coh	50-5	771	Adh/Coh
46-6	2573	Adh/Coh	47-6	1897	Cohesive	48-6	2064	Adh/Coh	49-6	1979	Adh/Coh	50-6	1064	Adh/Coh
46-7	1767	Adh/Coh	47-7	2224	Cohesive	48-7	1815	Adh/Coh	49-7	1930	Adh/Coh	50-7	1001	Adh/Coh
46-8	2665	Adh/Coh	47-8	2033	Adh/Coh	48-8	1679	Adh/Coh	49-8	2187	Adh/Coh	50-8	578	Adh/Coh
46-9	2463	Adh/Coh	47-9	1642	Cohesive	48-9	1584	Adh/Coh	49-9	1919	Adh/Coh	50-9	910	Adh/Coh
46-10	2737	Adh/Coh	47-10	1686	Cohesive	48-10	1569	Adh/Coh	49-10	2341	Adh/Coh	50-10	765	Adh/Coh
51-1	2482	Adh/Coh	52-1	2096	Adh/Coh	53-1	1429	Cohesive	54-1	776	Cohesive	55-1	1	Cohesive
51-2	2271	Adh/Coh	52-2	2137	Adh/Coh	53-2	2036	Cohesive	54-2	1021	Cohesive	55-2	Broke	Cohesive
51-3	2660	Adh/Coh	52-3	2000	Adh/Coh	53-3	1749	Cohesive	54-3	1142	Cohesive	55-3	Broke	Cohesive
51-4	2332	Adh/Coh	52-4	2384	Adh/Coh	53-4	1755	Cohesive	54-4	991	Cohesive	55-4	2	Cohesive
51-5	2236	Adh/Coh	52-5	2373	Adh/Coh	53-5	1760	Cohesive	54-5	820	Cohesive	55-5	1	Cohesive
51-6	2215	Adh/Coh	52-6	2258	Adh/Coh	53-6	1639	Cohesive	54-6	932	Cohesive	55-6	1	Cohesive
51-7	2484	Adh/Coh	52-7	2157	Adh/Coh	53-7	1089	Cohesive	54-7	976	Cohesive	55-7	Broke	Cohesive
51-8	2452	Adh/Coh	52-8	2359	Adh/Coh	53-8	1385	Cohesive	54-8	1141	Cohesive	55-8	Broke	Cohesive
51-9	2361	Adh/Coh	52-9	2269	Adh/Coh	53-9	1206	Cohesive	54-9	990	Cohesive	55-9	Broke	Cohesive
51-10	2444	Adh/Coh	52-10	1997	Adh/Coh	53-10	Missing	Adh/Coh	54-10	891	Cohesive	55-10	5	Cohesive
56-1	636	Adhesive	57-1	418	Cohesive	58-1	966	Adh/Coh	59-1	641	Adh/Coh	60-1	1541	Adh/Sub
56-2	285	Adhesive	57-2	361	Adh/Coh	58-2	786	Adh/Coh	59-2	1484	Adh/Coh	60-2	499	Adh/Coh
56-3	436	Adhesive	57-3	1007	Adh/Coh	58-3	709	Adh/Coh	59-3	565	Adh/Coh	60-3	549	Adh/Coh
56-4	771	Adhesive	57-4	130	Cohesive	58-4	861	Adh/Coh	59-4	656	Adh/Coh	60-4	1264	Adh/Coh/Sub
56-5	1618	Adh/Coh	57-5	354	Adh/Coh	58-5	546	Adh/Coh	59-5	1121	Adh/Coh	60-5	1235	Adh/Coh/Sub
56-6	695	Adhesive	57-6	411	Adh/Coh	58-6	897	Adh/Coh	59-6	517	Adh/Coh	60-6	402	Cohesive
56-7	948	Adhesive	57-7	985	Adh/Coh	58-7	1364	Adh/Coh	59-7	399	Adh/Coh	60-7	920	Adh/Coh/Sub
56-8	1043	Adhesive	57-8	643	Adh/Coh	58-8	706	Adh/Coh	59-8	858	Adh/Coh	60-8	1169	Adh/Coh/Sub
56-9	591	Adhesive	57-9	546	Adh/Coh	58-9	1399	Adh/Coh	59-9	307	Adh/Coh	60-9	480	Adh/Coh
56-10	1315	Adhesive	57-10	636	Adh/Coh	58-10	1717	Adh/Coh	59-10	809	Adh/Coh	60-10	1397	Adh/Coh/Sub

61-1	3058	Cohesive	62-1	2758	Cohesive	63-1	2585	Cohesive	64-1	2851	65-1	1973	Cohesive
61-2	3056	Cohesive	62-2	3519	Cohesive	63-2	3250	Cohesive	64-2	3933	65-2	2086	Cohesive
61-3	2546	Cohesive	62-3	2560	Cohesive	63-3	2685	Cohesive	64-3	3183	65-3	2153	Cohesive
61-4	2964	Cohesive	62-4	3058	Cohesive	63-4	2355	Cohesive	64-4	3335	65-4	2073	Cohesive
61-5	2730	Cohesive	62-5	2472	Cohesive	63-5	2273	Cohesive	64-5	3955	65-5	1835	Cohesive
61-6	2639	Cohesive	62-6	2738	Cohesive	63-6	2398	Cohesive	64-6	3660	65-6	2111	Cohesive
61-7	2926	Cohesive	62-7	3964	Cohesive	63-7	3030	Cohesive	64-7	3638	65-7	1909	Cohesive
61-8	2701	Cohesive	62-8	3338	Cohesive	63-8	2817	Cohesive	64-8	3714	65-8	2195	Cohesive
61-9	3110	Cohesive	62-9	2493	Cohesive	63-9	3041	Cohesive	64-9	3860	65-9	1945	Cohesive
61-10	3170	Cohesive	62-10	3147	Cohesive	63-10	2684	Cohesive	64-10	2781	65-10	2208	Cohesive
66-1	3779	Cohesive	67-1	3937	Cohesive	68-1	4283	Cohesive	69-1	2731	70-1	Broke	Cohesive
66-2	3687	Cohesive	67-2	3696	Cohesive	68-2	4127	Cohesive	69-2	2378	70-2	1	Cohesive
66-3	3549	Cohesive	67-3	3738	Cohesive	68-3	3735	Cohesive	69-3	1892	70-3	1	Cohesive
66-4	3628	Cohesive	67-4	3649	Cohesive	68-4	3347	Cohesive	69-4	2076	70-4	Broke	Cohesive
66-5	3256	Cohesive	67-5	3037	Cohesive	68-5	4466	Cohesive	69-5	2549	70-5	Broke	Cohesive
66-6	3916	Cohesive	67-6	2899	Cohesive	68-6	3955	Cohesive	69-6	3106	70-6	Broke	Cohesive
66-7	3602	Cohesive	67-7	2750	Cohesive	68-7	3658	Cohesive	69-7	2158	70-7	1	Cohesive
66-8	3665	Cohesive	67-8	3997	Cohesive	68-8	3704	Cohesive	69-8	1953	70-8	Broke	Cohesive
66-9	3499	Cohesive	67-9	3306	Cohesive	68-9	4083	Cohesive	69-9	2480	70-9	Broke	Cohesive
66-10	3506	Cohesive	67-10	3674	Cohesive	68-10	3657	Cohesive	69-10	2490	70-10	Broke	Cohesive
71-1	2221	Adh/Coh	72-1	2040	Cohesive	73-1	2373	Cohesive	74-1	2159	75-1	2045	Cohesive
71-2	2187	Cohesive	72-2	2170	Cohesive	73-2	2083	Cohesive	74-2	2052	75-2	2240	Cohesive
71-3	2305	Cohesive	72-3	2035	Cohesive	73-3	2139	Cohesive	74-3	1998	75-3	2165	Cohesive
71-4	1988	Cohesive	72-4	2028	Cohesive	73-4	1910	Adh/Coh	74-4	2115	75-4	2193	Cohesive
71-5	2050	Cohesive	72-5	2216	Cohesive	73-5	2335	Cohesive	74-5	2025	75-5	2279	Cohesive
71-6	2388	Cohesive	72-6	2147	Cohesive	73-6	2298	Cohesive	74-6	1979	75-6	2223	Cohesive
71-7	2137	Cohesive	72-7	2076	Cohesive	73-7	2124	Cohesive	74-7	1988	75-7	2396	Cohesive
71-8	2305	Cohesive	72-8	1974	Cohesive	73-8	2237	Cohesive	74-8	2121	75-8	2389	Cohesive
71-9	2196	Cohesive	72-9	2144	Cohesive	73-9	2313	Cohesive	74-9	2135	75-9	2352	Cohesive
71-10	1959	Cohesive	72-10	2112	Cohesive	73-10	2314	Cohesive	74-10	2039	75-10	2128	Cohesive

76-1	3510	Cohesive	77-1	1981	Adth/Coh	78-1	1818	Cohesive	79-1	3363	Adth/Coh	80-1	1151	Adth/Coh
76-2	2654	Cohesive	77-2	2577	Adth/Coh	78-2	1157	Cohesive	79-2	3191	Adth/Coh	80-2	982	Adth/Coh
76-3	2802	Cohesive	77-3	2086	Adth/Coh	78-3	2002	Adth/Coh	79-3	3868	Adth/Coh	80-3	1202	Adth/Coh
76-4	2724	Cohesive	77-4	2234	Adth/Coh	78-4	2115	Adth/Coh	79-4	3694	Adth/Coh	80-4	1285	Adth/Coh
76-5	2918	Cohesive	77-5	1606	Adth/Coh	78-5	1454	Adth/Coh	79-5	4191	Adth/Coh	80-5	1697	Adth/Coh
76-6	2571	Cohesive	77-6	1192	Adth/Coh	78-6	2266	Adth/Coh	79-6	4140	Adth/Coh	80-6	1635	Adth/Coh
76-7	1278	Adth/Coh	77-7	2013	Adth/Coh	78-7	1091	Adth/Coh	79-7	4338	Cohesive	80-7	2213	Adth/Coh
76-8	682	Adth/Coh	77-8	2131	Adth/Coh	78-8	1909	Adth/Coh	79-8	4077	Cohesive	80-8	1804	Adth/Coh
76-9	1923	Cohesive	77-9	2307	Adth/Coh	78-9	1593	Adth/Coh	79-9	3468	Cohesive	80-9	1864	Adth/Coh
76-10	1110	Adth/Coh	77-10	2452	Adth/Coh	78-10	1432	Adth/Coh	79-10	3665	Cohesive	80-10	1807	Adth/Coh
81-1	2389	Adth/Coh	82-1	Broke	Adth/Coh	83-1	1360	Cohesive	84-1	1118	Adth/Coh	85-1	Broke	Adth/Coh
81-2	2014	Adth/Coh	82-2	Broke	Adth/Coh	83-2	1513	Cohesive	84-2	1058	Adth/Coh	85-2	Broke	Adth/Coh
81-3	2008	Adth/Coh	82-3	Broke	Adth/Coh	83-3	1593	Cohesive	84-3	854	Cohesive	85-3	3	Adth/Coh
81-4	2050	Adth/Coh	82-4	Broke	Adth/Coh	83-4	1807	Cohesive	84-4	1232	Cohesive	85-4	Broke	Adth/Coh
81-5	1998	Adth/Coh	82-5	Broke	Adth/Coh	83-5	1285	Cohesive	84-5	1084	Adth/Coh	85-5	2	Adth/Coh
81-6	2124	Adth/Coh	82-6	Broke	Adth/Coh	83-6	1551	Cohesive	84-6	1087	Cohesive	85-6	Broke	Cohesive
81-7	1870	Adth/Coh	82-7	Broke	Adth/Coh	83-7	1525	Cohesive	84-7	1243	Adth/Coh	85-7	Broke	Adth/Coh
81-8	2666	Cohesive	82-8	Broke	Adth/Coh	83-8	1395	Cohesive	84-8	1013	Cohesive	85-8	107	Adth/Coh
81-9	1898	Adth/Coh	82-9	Broke	Adth/Coh	83-9	1726	Cohesive	84-9	1022	Cohesive	85-9	Broke	Cohesive
81-10	2027	Adth/Coh	82-10	Broke	Adth/Coh	83-10	1551	Cohesive	84-10	1096	Cohesive	85-10	91	Cohesive
86-1	1812	Adth/Coh	87-1	951	Adth/Coh	88-1	774	Adth/Coh	89-1	1837	Cohesive	90-1	2343	Cohesive
86-2	1778	Adth/Coh	87-2	1181	Adth/Coh	88-2	1325	Adth/Coh	89-2	2066	Cohesive	90-2	2327	Cohesive
86-3	2008	Cohesive	87-3	1422	Adth/Coh	88-3	1068	Adth/Coh	89-3	2039	Cohesive	90-3	2239	Cohesive
86-4	1839	Adth/Coh	87-4	1183	Adth/Coh	88-4	1441	Adth/Coh	89-4	1955	Cohesive	90-4	2140	Cohesive
86-5	1967	Adth/Coh	87-5	1308	Adth/Coh	88-5	1297	Adth/Coh	89-5	1936	Cohesive	90-5	2364	Cohesive
86-6	1953	Adth/Coh	87-6	1656	Adth/Coh	88-6	1328	Adth/Coh	89-6	1988	Cohesive	90-6	2414	Cohesive
86-7	1962	Adth/Coh	87-7	1163	Adth/Coh	88-7	1653	Adth/Coh	89-7	2226	Cohesive	90-7	2472	Cohesive
86-8	1823	Adth/Coh	87-8	1215	Adth/Coh	88-8	1190	Adth/Coh	89-8	1838	Cohesive	90-8	2290	Cohesive
86-9	1695	Adth/Coh	87-9	936	Adth/Coh	88-9	1557	Adth/Coh	89-9	1935	Cohesive	90-9	2175	Cohesive
86-10	1871	Adth/Coh	87-10	1452	Adth/Coh	88-10	1395	Adth/Coh	89-10	1988	Cohesive	90-10	2381	Cohesive

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 - ⁷ Idem
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