

11.0 Appendix. Single-Lap-Joint Fabrication Check List

Sample ID's: 20150438, 20150439, 20150440, 20150441, 20150442Date: 01/25/15 @ 1630 Temperature: 74.1°F Humidity 52.9%Testing facility and operator: MJSAdhesive, type, and form: SciGrip SG805Lot ID, manufacturer's code, expiration date: EX805A Lot: NC14H-007EX805B BLOCK Lot: NC14H-008 Date of Mfg: 8/27/2014Method of cleaning and preparing bonding surface: acetone wipe, Scotchbrite 3M (048011-05530 A VFN), grit blast (aluminum oxide 60 grit), nitrogen blow-offAC-131 3M ID No.: 70-0052-0026-9 Lot #: 52033Mix for 30 mins (sit), wet out for 2 mins, nitrogen blow off

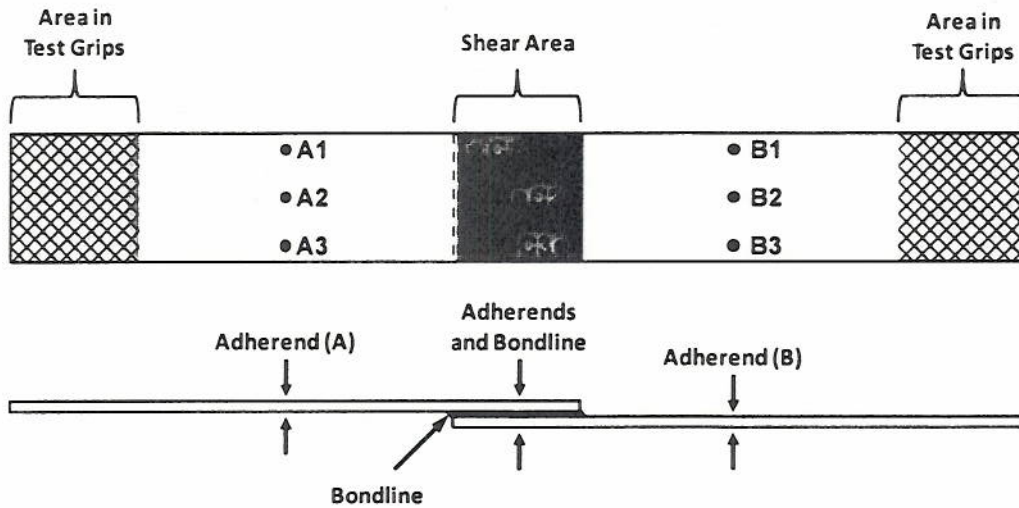
Adhesive preparation, application, and bonding conditions:

Two-component, 490 mL cartridge 10:1 mix ratio dispensed using mixpac type DP 400-100 No. 2008-67153Tooling fixture and bonding pressure notes: aluminum fixture w/ 3 steel weightsAdhesive mixing to applied pressure time: < 5 minsCure cycle: 91.5 hrs @ RTOven used (model and serial number): ~~70112 0001~~

Conditioning procedure: _____

Comments: 1010 mild steelAC-131 BB 501-gelRT

13.0 Appendix. Bondline Thickness Measurements



Aluminum grade: _____ Mfg. nominal thickness: _____ (mm – in)

Micrometer model, serial number, calibration date _____

Measurement units (circle) – mm or in

Sample ID	Adherend (A1)	Adherend (A2)	Adherend (A3)	Average (A)
20150438	.0621	.0619	.0618	.06193
Comments	Adherend (B1)	Adherend (B2)	Adherend (B3)	Average (B)
	.0622	.0618	.0618	.06193
	Adherends and Bondline (C1)	Adherends and Bondline (C2)	Adherends and Bondline (C3)	Average (C)
	.1516	.1513	.1517	.15153
				C – (A + B)
Average bondline thickness			.02767	

.06193

Sample ID	Adherend (A1)	Adherend (A2)	Adherend (A3)	Average (A)
20150439	.0622	.0619	.0620	.06203
Comments	Adherend (B1)	Adherend (B2)	Adherend (B3)	Average (B)
	.0618	.0617	.0616	.0617
	Adherends and Bondline (C1)	Adherends and Bondline (C2)	Adherends and Bondline (C3)	Average (C)
	.1572	.1577	.1573	.15773
				C - (A + B)
	Average bondline thickness			.02800

Sample ID	Adherend (A1)	Adherend (A2)	Adherend (A3)	Average (A)
20150440	.0623	.0620	.0621	.06213
Comments	Adherend (B1)	Adherend (B2)	Adherend (B3)	Average (B)
	.0619	.0618	.0620	.0619
	Adherends and Bondline (C1)	Adherends and Bondline (C2)	Adherends and Bondline (C3)	Average (C)
	.1529	.1529	.1528	.15287
				C - (A + B)
	Average bondline thickness			.02884

Sample ID	Adherend (A1)	Adherend (A2)	Adherend (A3)	Average (A)
20150441	.0622	.0619	.0619	.0620
Comments	Adherend (B1)	Adherend (B2)	Adherend (B3)	Average (B)
	.0619	.0619	.0622	.0620
	Adherends and Bondline (C1)	Adherends and Bondline (C2)	Adherends and Bondline (C3)	Average (C)
	.1514	.1512	.1513	.1513
				C – (A + B)
Average bondline thickness			.02730	

.0620

Sample ID	Adherend (A1)	Adherend (A2)	Adherend (A3)	Average (A)
20150442	.0618	.0618	.0620	.06187
Comments	Adherend (B1)	Adherend (B2)	Adherend (B3)	Average (B)
	.0618	.0619	.0620	.0619
	Adherends and Bondline (C1)	Adherends and Bondline (C2)	Adherends and Bondline (C3)	Average (C)
	.1523	.1522	.1516	.15203
				C – (A + B)
Average bondline thickness			.02826	

.06189