

11.0 Appendix. Single-Lap-Joint Fabrication Check List

Sample ID's: 20150458, 20150459, 20150460, 20150461, 20150462Date: 6/25/15 @ 1630 Temperature: 74.1°F Humidity 52.9%Testing facility and operator: msdAdhesive, type, and form: SciGrip SC7805Lot ID, manufacturer's code, expiration date: EX805A Lot: NC14H-007EX805B BLOK Lot: NC14H-008 Date of Mfg: 8/27/2014Method of cleaning and preparing bonding surface: acetone wipe, 3M scotch brite
(048D11-05530, A VAV, Lot #: MDMD0205-4304), grit + blast (60 grit + Al2O3), N2 blow offS700 IDH: 595996 Lot: PB44576588 use before 10-20-17dip 2 mins, 30 sec DI rinse, N2 blow off

Adhesive preparation, application, and bonding conditions:

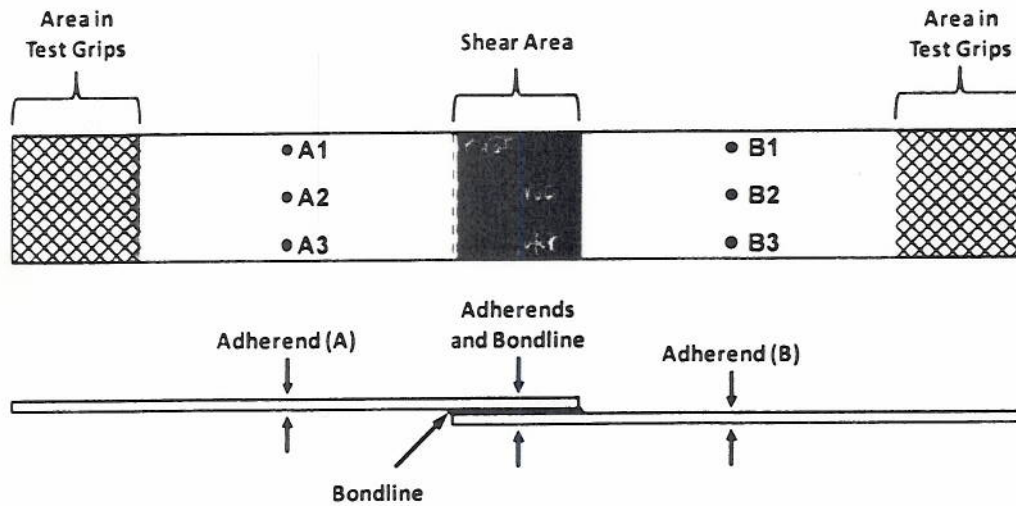
Two-component, 490 mL cartridge 10:1 mix ratio dispensed using
MIXPAC type DP 400-100 No. 2008-07153Tooling fixture and bonding pressure notes: aluminum fixture w/ 3 steel weightsAdhesive mixing to applied pressure time: < 5 minsCure cycle: 91.5 hrs @ RT

Oven used (model and serial number): _____

Conditioning procedure: _____

Comments: 1010 mild steelBonderite S700RT

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)
20150458	.0620	.0618	.0617	.06183
Comments	Adherend (B1)	Adherend (B2)	Adherend (B3)	Average (B)
	.0620	.0621	.0620	.06203
	Adherends and Bondline (C1)	Adherends and Bondline (C2)	Adherends and Bondline (C3)	Average (C)
	.1573	.1593	.1630	.15987
				C – (A + B)
	Average bondline thickness			.03601

.06193

Sample ID	Adherend (A1)	Adherend (A2)	Adherend (A3)	Average (A)
20150459	.0621	.0617	.0617	.06183
Comments	Adherend (B1)	Adherend (B2)	Adherend (B3)	Average (B)
	.0619	.0619	.0619	.0619
	Adherends and Bondline (C1)	Adherends and Bondline (C2)	Adherends and Bondline (C3)	Average (C)
	.1581	.1587	.1598	.15887
				C - (A + B)
	Average bondline thickness			.03514

Sample ID	Adherend (A1)	Adherend (A2)	Adherend (A3)	Average (A)
20150460	.0620	.0618	.0619	.0619
Comments	Adherend (B1)	Adherend (B2)	Adherend (B3)	Average (B)
	.0620	.0619	.0620	.06197
	Adherends and Bondline (C1)	Adherends and Bondline (C2)	Adherends and Bondline (C3)	Average (C)
	.1612	.1600	.1606	.1606
				C - (A + B)
	Average bondline thickness			.03673

Sample ID	Adherend (A1)	Adherend (A2)	Adherend (A3)	Average (A)
201504618	.0619	.0618	.0619	.06187
Comments	Adherend (B1)	Adherend (B2)	Adherend (B3)	Average (B)
	.0620	.0619	.0619	.06193
	Adherends and Bondline (C1)	Adherends and Bondline (C2)	Adherends and Bondline (C3)	Average (C)
	.1612	.1592	.1579	.15943
				C – (A + B)
	Average bondline thickness			.03563

.0619

Sample ID	Adherend (A1)	Adherend (A2)	Adherend (A3)	Average (A)
201504622	.0618	.0619	.0623	.0620
Comments	Adherend (B1)	Adherend (B2)	Adherend (B3)	Average (B)
	.0621	.0620	.0619	.0620
	Adherends and Bondline (C1)	Adherends and Bondline (C2)	Adherends and Bondline (C3)	Average (C)
	.1595	.1595	.1601	.1597
				C - (A + B)
	Average bondline thickness			.03570

.0620