

11.0 Appendix. Single-Lap-Joint Fabrication Check List

Sample ID's: 20150468, 20150469, 20150470, 20150471, 20150472Date: 6/25/15 @ 1630 Temperature: 74.1°F Humidity 52.9%Testing facility and operator: MJSAdhesive, type, and form: SciGrip SC7805Lot 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, 3M scotch brite
(048011-05530, A VFN, Lot #: MDMP0205-4304), grit blast (60 grit Al₂O₃), N₂ blow off7400° IDH: 599060 ~~LOT: 141~~ Lot: PB44475371 use before 8-14-20155%, 2 min dip, 30 sec DI rinse, N₂ blow off

Adhesive preparation, application, and bonding conditions:

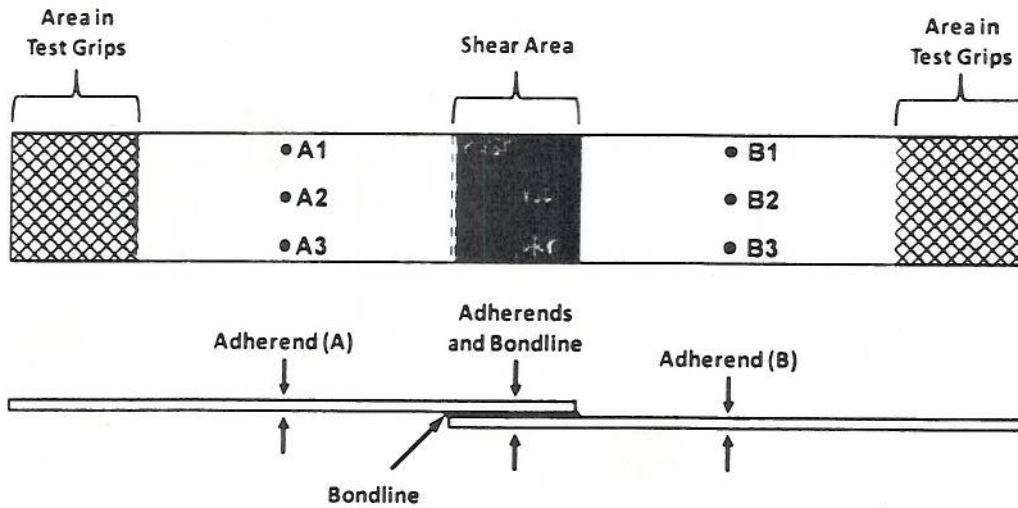
Two-component, 490 mL cartridge 10:1 mix ratio dispensed using
MixPac type DP 400-100 No. 2008-07153Tooling fixture and bonding pressure notes: aluminum fixture w/ 3 steel weightsAdhesive mixing to applied pressure time: <5 minsCure cycle: 91.5 hrs @ RT

Oven used (model and serial number): _____

Conditioning procedure: _____

Comments: 1010 mild steelBonderite 7400RT

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)
20150 468	.0623	.0624	.0623	.06233
Comments	Adherend (B1)	Adherend (B2)	Adherend (B3)	Average (B)
	.0613	.0615	.0612	.06133
	Adherends and Bondline (C1)	Adherends and Bondline (C2)	Adherends and Bondline (C3)	Average (C)
	.1520	.1521	.1522	.1521
				C – (A + B)
	Average bondline thickness			.02844

Sample ID	Adherend (A1)	Adherend (A2)	Adherend (A3)	Average (A)
20150469	.0625	.0624	.0623	.0624
Comments	Adherend (B1)	Adherend (B2)	Adherend (B3)	Average (B)
	.0616	.0615	.0610	.06137
	Adherends and Bondline (C1)	Adherends and Bondline (C2)	Adherends and Bondline (C3)	Average (C)
	.1529	.1527	.1521	.15257
				C - (A + B)
	Average bondline thickness			.02880

Sample ID	Adherend (A1)	Adherend (A2)	Adherend (A3)	Average (A)
20150470	.0623	.0623	.0622	.06227
Comments	Adherend (B1)	Adherend (B2)	Adherend (B3)	Average (B)
	.0612	.0611	.0610	.0611
	Adherends and Bondline (C1)	Adherends and Bondline (C2)	Adherends and Bondline (C3)	Average (C)
	.1527	.1520	.1518	.15217
				C - (A + B)
	Average bondline thickness			.02880

Sample ID	Adherend (A1)	Adherend (A2)	Adherend (A3)	Average (A)
20150471	.0623	.0623	.0623	.0623
Comments	Adherend (B1)	Adherend (B2)	Adherend (B3)	Average (B)
	.0610	.0610	.0611	.06103
	Adherends and Bondline (C1)	Adherends and Bondline (C2)	Adherends and Bondline (C3)	Average (C)
	.1532	.1523	.1519	.15247
				C - (A + B)
	Average bondline thickness			.02914

.06167

.06177

Sample ID	Adherend (A1)	Adherend (A2)	Adherend (A3)	Average (A)
20150472	.0623	.0623	.0622	.06227
Comments	Adherend (B1)	Adherend (B2)	Adherend (B3)	Average (B)
	.0615	.0615	.0608	.06127
	Adherends and Bondline (C1)	Adherends and Bondline (C2)	Adherends and Bondline (C3)	Average (C)
	.1539	.1532	.1519	.1530
				C - (A + B)
	Average bondline thickness			.02946