

11.0 Appendix. Single-Lap-Joint Fabrication Check List

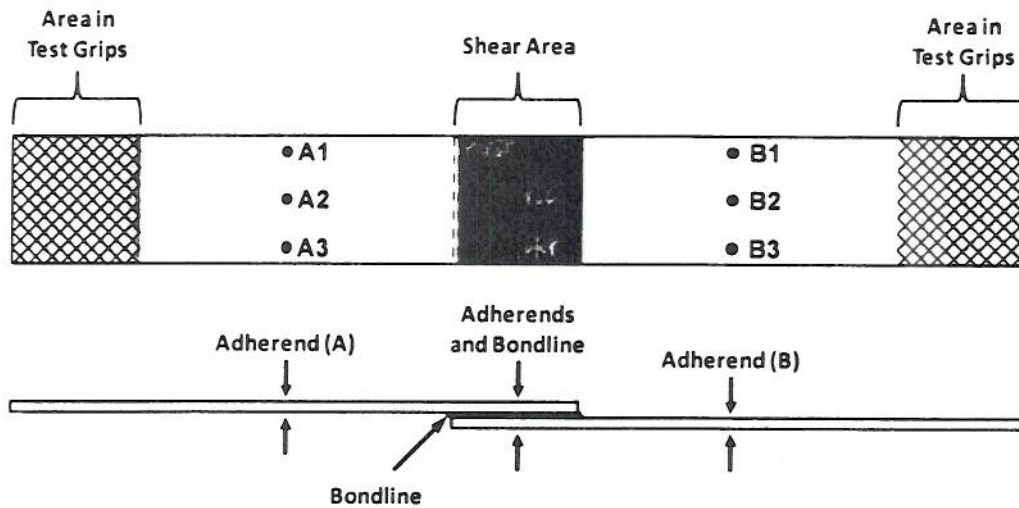
Sample ID's: 20150448, 20150449, 20150450, 20150451, 20150452Date: 6/25/15 @ 1630 Temperature: 74.1°F Humidity 52.9%Testing facility and operator: MSSAdhesive, type, and form: SciGrip SC7805Lot ID, manufacturer's code, expiration date: EX805A Lot: NC14H-007EX805B BLACK Lot: NC14H-008 Date of Mfg: 8/27/2014Method of cleaning and preparing bonding surface: acetone wipe, 3M scotchbrite
(048011-05530, A VFN, Lot #: MDM00205-4304), Grit blast (60 grit Al₂O₃), N₂ blow offSurTec 650: QCL#501094 (9-30-15)5% + titrated to pH 3.5, dip 2 mins, 30 sec DI rinse, nitrogen blow offAdhesive preparation, application, and bonding conditions: ^{mix 30 mins}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 steelSurTec 650RT

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)
20150448	.0619	.0620	.0616	.06183
Comments	Adherend (B1)	Adherend (B2)	Adherend (B3)	Average (B)
	.0617	.0618	.0616	.0617
	Adherends and Bondline (C1)	Adherends and Bondline (C2)	Adherends and Bondline (C3)	Average (C)
	.1511	.1502	.1511	.1508
				C – (A + B)
	Average bondline thickness			.62727

Sample ID	Adherend (A1)	Adherend (A2)	Adherend (A3)	Average (A)
20150449	.0619	.0619	.0618	.06187
Comments	Adherend (B1)	Adherend (B2)	Adherend (B3)	Average (B)
	.0621	.0619	.0616	.06187
	Adherends and Bondline (C1)	Adherends and Bondline (C2)	Adherends and Bondline (C3)	Average (C)
	.1504	.1504	.1514	.15073
				C - (A + B)
	Average bondline thickness			.02699

.06187

.0617

Sample ID	Adherend (A1)	Adherend (A2)	Adherend (A3)	Average (A)
20150450	.0619	.0619	.0618	.06187
Comments	Adherend (B1)	Adherend (B2)	Adherend (B3)	Average (B)
	.0614	.0616	.0616	.06153
	Adherends and Bondline (C1)	Adherends and Bondline (C2)	Adherends and Bondline (C3)	Average (C)
	.1492	.1474	.1471	.1479
				C - (A + B)
	Average bondline thickness			.02450

Sample ID	Adherend (A1)	Adherend (A2)	Adherend (A3)	Average (A)
2050451	.0619	.0620	.0619	.06193
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)
	.1484	.1482	.1491	.14857
				C - (A + B)
	Average bondline thickness			.02474

Sample ID	Adherend (A1)	Adherend (A2)	Adherend (A3)	Average (A)
20150452	.0621	.0622	.0619	.06207
Comments	Adherend (B1)	Adherend (B2)	Adherend (B3)	Average (B)
	.0617	.0617	.0616	.06167
	Adherends and Bondline (C1)	Adherends and Bondline (C2)	Adherends and Bondline (C3)	Average (C)
	.1509	.1501	.1507	.15057
				C - (A + B)
	Average bondline thickness			.02683