

## 11.0 Appendix. Single-Lap-Joint Fabrication Check List

Sample ID's: 20150478, 20150479, 20150480, 20150481, 20150482Date: 6/25/15 @1630 Temperature: 74.1°F Humidity 52.9%Testing facility and operator: MADAdhesive, 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#: MIMD0205-4304), gri+blast (60 gri+ Al<sub>2</sub>O<sub>3</sub>), N<sub>2</sub> blow off4000: 14-JLS-035 A (filled 11-13-14)dip 2 min, 30 sec DI rinse, N<sub>2</sub> blow off

Adhesive preparation, application, and bonding conditions:

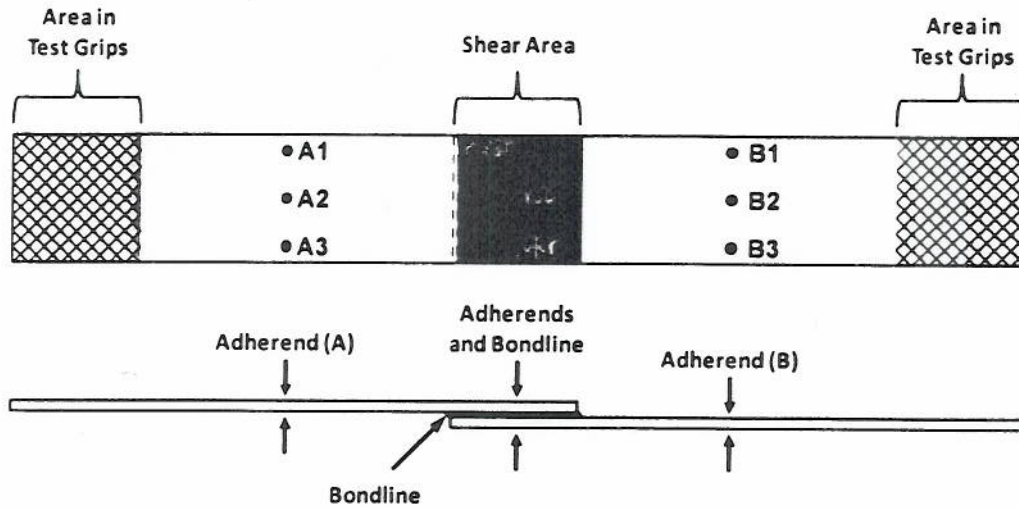
Two-component, 490 mL cartridge 10:1 mix ratio dispensed using  
mixPac type DP 400-100 No. 2008-07153Tooling fixture and bonding pressure notes: aluminum fixture w/ 3 steel weightsAdhesive mixing to applied pressure time: <5 minsCure cycle: 91.5 hrs @ RT

Oven used (model and serial number): \_\_\_\_\_

Conditioning procedure: \_\_\_\_\_

Comments: 1010 mild steelX-Bond 4000RT

## 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)
20150478	.0610	.0609	.0609	.06093
Comments	Adherend (B1)	Adherend (B2)	Adherend (B3)	Average (B)
	.0618	.0619	.0622	.06197
	Adherends and Bondline (C1)	Adherends and Bondline (C2)	Adherends and Bondline (C3)	Average (C)
	.1463	.1467	.1478	.14693
				C – (A + B)
	Average bondline thickness			.02403

.06143

Sample ID	Adherend (A1)	Adherend (A2)	Adherend (A3)	Average (A)
20150479	.0611	.0611	.0611	.0611
Comments	Adherend (B1)	Adherend (B2)	Adherend (B3)	Average (B)
	.0622	.0622	.0621	.06217
	Adherends and Bondline (C1)	Adherends and Bondline (C2)	Adherends and Bondline (C3)	Average (C)
	.1528	.1520	.1514	.15207
				C - (A + B)
	Average bondline thickness			.02880

.06164

.06162

Sample ID	Adherend (A1)	Adherend (A2)	Adherend (A3)	Average (A)
20150480	.0612	.0611	.0611	.06113
Comments	Adherend (B1)	Adherend (B2)	Adherend (B3)	Average (B)
	.0622	.0620	.0621	.0621
	Adherends and Bondline (C1)	Adherends and Bondline (C2)	Adherends and Bondline (C3)	Average (C)
	.1498	.1491	.1489	.14927
				C - (A + B)
	Average bondline thickness			.02604

Sample ID	Adherend (A1)	Adherend (A2)	Adherend (A3)	Average (A)
20150481	.0612	.0610	.0611	.0611
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)
	.1496	.1484	.1474	.14847
				C – (A + B)
	Average bondline thickness			.02567

Sample ID	Adherend (A1)	Adherend (A2)	Adherend (A3)	Average (A)
20150482	.0615	.0613	.0615	.06143
Comments	Adherend (B1)	Adherend (B2)	Adherend (B3)	Average (B)
	.0618	.0615	.0619	.06173
	Adherends and Bondline (C1)	Adherends and Bondline (C2)	Adherends and Bondline (C3)	Average (C)
	.1490	.1482	.1496	.1486
				C - (A + B)
Average bondline thickness			.02544	