

11.0 Appendix. Single-Lap-Joint Fabrication Check List

Sample ID's: 20150488, 20150489, 20150490, 20150491, 20150492Date: 6/25/15 @ 1630 Temperature: 74.1°F Humidity 52.9%Testing facility and operator: MSAdhesive, 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, AVEV, Lot #: MDMD0205-4304, grit blatt (60 grit Al₂O₃), N₂ blow off4200SR: 14-JLS-035B (filled 11-13-14)dip 2 mins, DI rinse 30 sec, N₂ blow off

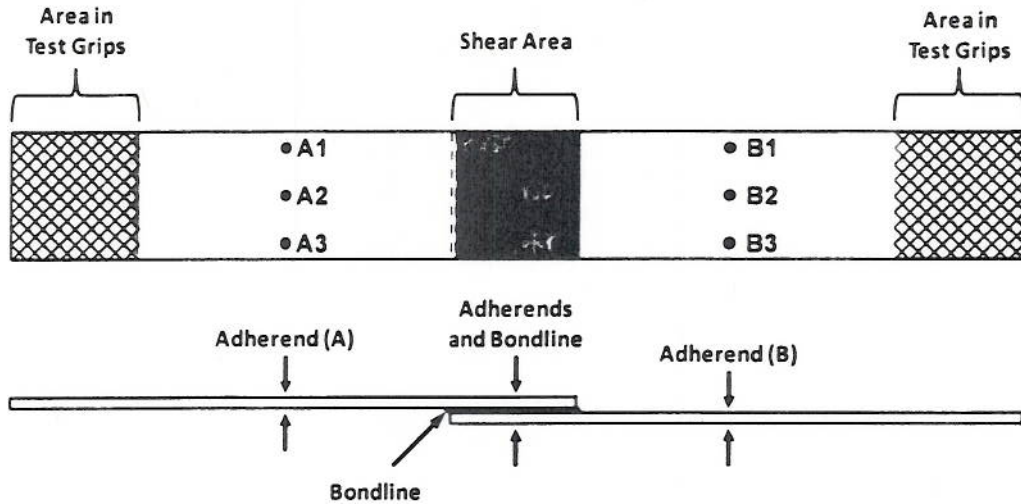
Adhesive preparation, application, and bonding conditions:

Two-component, 490 mL cartridge 10:1 mix ratio dispensed using
MIXPAC type DP 400-100 No. 2008-67153Tooling 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): ~~7000 308, 7000 308, 7000 308, 7000 308, 7000 308~~

Conditioning procedure: _____

Comments: 1010 mild steelZIRCOBOND 4200SRRT

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)
20150488	.0623	.0620	.0623	.0622
Comments	Adherend (B1)	Adherend (B2)	Adherend (B3)	Average (B)
	.0619	.0619	.0617	.06183
	Adherends and Bondline (C1)	Adherends and Bondline (C2)	Adherends and Bondline (C3)	Average (C)
	.1541	.1531	.1525	.15323
				C – (A + B)
Average bondline thickness			.02920	

.0620

Sample ID	Adherend (A1)	Adherend (A2)	Adherend (A3)	Average (A)
20150489	.0622	.0621	.0621	.06213
Comments	Adherend (B1)	Adherend (B2)	Adherend (B3)	Average (B)
	.0618	.0616	.0615	.06163
	Adherends and Bondline (C1)	Adherends and Bondline (C2)	Adherends and Bondline (C3)	Average (C)
	.1533	.1534	.1541	.1536
				C – (A + B)
	Average bondline thickness			.02984

.0618

.0618

Sample ID	Adherend (A1)	Adherend (A2)	Adherend (A3)	Average (A)
201504 90	.0622	.0621	.0621	.06213
Comments	Adherend (B1)	Adherend (B2)	Adherend (B3)	Average (B)
	.0615	.0615	.0614	.06147
	Adherends and Bondline (C1)	Adherends and Bondline (C2)	Adherends and Bondline (C3)	Average (C)
	.1569	.1550	.1537	.1552
				C - (A + B)
	Average bondline thickness			.03160

Sample ID	Adherend (A1)	Adherend (A2)	Adherend (A3)	Average (A)
20150491	.0622	.0620	.0621	.0621
Comments	Adherend (B1)	Adherend (B2)	Adherend (B3)	Average (B)
	.0616	.0617	.0619	.06173
	Adherends and Bondline (C1)	Adherends and Bondline (C2)	Adherends and Bondline (C3)	Average (C)
	.1536	.1527	.1532	.15317
				C – (A + B)
	Average bondline thickness			.02934

.06192

Sample ID	Adherend (A1)	Adherend (A2)	Adherend (A3)	Average (A)
20150492	.0621	.0620	.0622	.0621
Comments	Adherend (B1)	Adherend (B2)	Adherend (B3)	Average (B)
	.0619	.0620	.0621	.0620
	Adherends and Bondline (C1)	Adherends and Bondline (C2)	Adherends and Bondline (C3)	Average (C)
	.1516	.1524	.1542	.15273
				C - (A + B)
	Average bondline thickness			.02863

.50290