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## Standard Test Method for Floating Roller Peel Resistance of Adhesives<sup>1</sup>

This standard is issued under the fixed designation D3167; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon ( $\epsilon$ ) indicates an editorial change since the last revision or reapproval.

### INTRODUCTION

The purpose of this test method is to provide for the determination of the metal-to-metal peel strength of adhesives by a method that will provide good reproducibility at low-, as well as at high-strength levels and yet allow for a simple method of test specimen preparation and testing.

The accuracy of the results of strength tests of adhesive bonds will depend on the conditions under which the bonding process is carried out. Unless otherwise agreed upon between the manufacturer and the purchaser, the bonding conditions shall be prescribed by the manufacturer of the adhesive. In order to ensure that complete information is available to the individual conducting the tests, the manufacturer of the adhesive shall furnish numerical values and other specific information for each of the following variables:

(1) Procedure for preparation of the surfaces prior to application of the adhesive, the cleaning and drying of metal surfaces, and special surface treatments such as sanding, which are not specifically limited by the pertinent test method.

(2) Complete mixing directions for the adhesive.

(3) Conditions for application of the adhesive, including the rate of spread or thickness of film, number of coats to be applied whether to be applied to one or both surfaces, and the conditions of drying where more than one coat is required.

(4) Assembly conditions before application of pressure, including the room temperature and length of time.

(5) Curing conditions, including the amount of pressure to be applied, the length of time under pressure, and the temperature of the assembly when under pressure. It should be stated whether this temperature is that of the glue line, or of the atmosphere at which the assembly is to be maintained.

(6) Conditioning procedure before testing, unless a standard procedure is specified, including the length of time, temperature, and relative humidity.

A range may be prescribed for any variable by the manufacturer of the adhesive, if it can be assumed by the test operator that any arbitrarily chosen value within such a range or any combination of such values for several variables will be acceptable to both the manufacturer and the purchaser of the adhesive.

### 1. Scope

1.1 This test method covers the determination of the relative peel resistance of adhesive bonds between one rigid adherend and one flexible adherend when tested under specified conditions of preparation and testing.

1.2 A variation in thickness of the adherends will generally influence the test values. For this reason, the thickness of the sheets used to make the test specimens shall be specified in the material specification. When no thickness is specified, the flexible adherend shall be 0.63 mm (0.025 in.) thick and the rigid adherend shall be 1.63 mm (0.064 in.) thick.

1.3 The values stated in SI units are to be regarded as the standard. The values given in parentheses are for information only.

1.4 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

<sup>1</sup> This test method is under the jurisdiction of ASTM Committee D14 on Adhesives and is the direct responsibility of Subcommittee D14.80 on Metal Bonding Adhesives. Current edition approved April 1, 2004. Published April 2004. Originally approved in 1973. Last previous edition approved in 2003 as D3167 – 03a (2004). DOI: 10.1520/D3167-03AR04.10.1520/D3167-10.

## 2. Referenced Documents

- 2.1 *ASTM Standards*:<sup>2</sup>  
 B209 [Specification for Aluminum and Aluminum-Alloy Sheet and Plate](#)  
 D907 [Terminology of Adhesives](#)  
 D1781 [Test Method for Climbing Drum Peel for Adhesives](#)  
 E4 [Practices for Force Verification of Testing Machines](#)

## 3. Terminology

3.1 *Definitions*—Many of the terms used in this test method are defined in Terminology D907.

## 4. Summary of Test Method

4.1 This test method consists of testing laminated or bonded adherends, where one adherend is made to be rigid and the other adherend is made to be flexible, by peeling of the flexible adherend from the rigid adherend at a controlled angle of peel using the test fixture shown in Fig. 1.

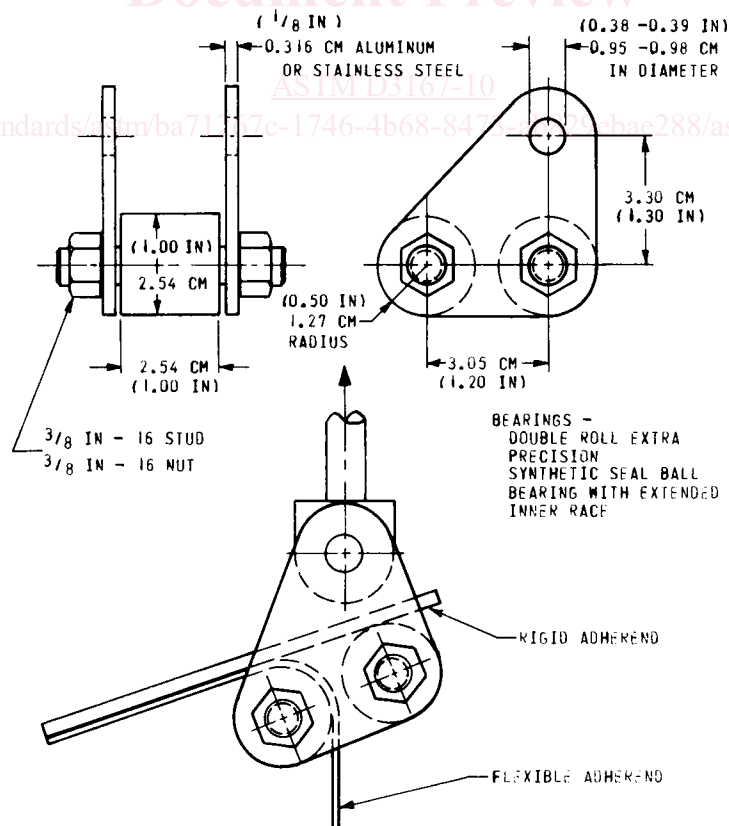
## 5. Significance and Use

5.1 Use this test method for acceptance and process control testing. This test method may be used as an alternative to Test Method D1781 when that facility is not available. This test method is considered more severe since the angle of peel is greater.

## 6. Apparatus

6.1 *Testing Machine*, conforming to the requirements of Practices E4. Select a testing machine that is autographic with chart capability, that reads and records in millimetres (inches) of separation as one coordinate and applied load as the other coordinate, the applied load accurate to within  $\pm 1\%$ . Additional capabilities of the machine are a crosshead rate of 152 mm/min (6 in./min), with self-aligning grips to hold the specimen, and where the breaking load of the specimens falls between 15 and 85 % of the full-scale machine capacity. The grips need to engage the outer 25.4 mm (1 in.) of the flexible adherend firmly and when the load is applied, the direction of the applied pull needs to be through the center line of the grip assembly.

<sup>2</sup> For referenced ASTM standards, visit the ASTM website, [www.astm.org](http://www.astm.org), or contact ASTM Customer Service at [service@astm.org](mailto:service@astm.org). For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.



**FIG. 1 Roller Drum Peel Test Fixture**