Contents

Preface xi

- **1** Benefits, Limitations, and Applications of Adhesive Bonding *1*
- 1.1 Definition of Basic Concepts 2
- 1.2 Historical Context on Adhesive Bonding 3
- 1.3 Benefits and Limitations of Adhesive Bonding 4
- 1.4 Examples of Current Applications of Adhesive Bonding 8

۱v

- 1.4.1 Transportation 8
- 1.4.1.1 Aeronautical Industry 8
- 1.4.1.2 Road Transport and Rail Industry 11
- 1.4.1.3 Naval Industry 13
- 1.4.2 Civil Engineering 15
- 1.4.2.1 Tiling 15
- 1.4.2.2 Floor and Wall Covering 15
- 1.4.2.3 Anchoring Systems 15
- 1.4.2.4 Building Facades 16
- 1.4.2.5 Wooden Construction 17
- 1.4.3 Labelling and Packaging Industry 18
- 1.4.3.1 Labelling of Consumable Products 18
- 1.4.3.2 Packaging 18
- 1.4.4 Medical Applications and Devices 19
- 1.4.5 Electronic Devices 23
- 1.4.6 Sport Equipment 23
- 1.4.7 Footwear 24

2 Principles of Adhesion 27

- 2.1 Forces Associated with Adhesion 28
- 2.2 Surface Roughness 31
- 2.3 Wettability 32
- 2.4 Adhesion and Cohesion Work 35
- 2.5 Spreading 36

vi Contents

- 2.6 Adhesion Theories 37
- 2.6.1 Adsorption Theory 37
- 2.6.2 Mechanical Theory 38
- 2.6.3 Diffusion Theory 41
- 2.6.4 Electrostatic Theory 41
- 2.7 Defects and Weak Spots in Adhesive Joints 42

3 Surface Preparation 45

- 3.1 Objectives of Surface Preparation 45
- 3.2 Classes of Substrate Materials 47
- 3.2.1 Metals 47
- 3.2.2 Polymers 47
- 3.2.3 Composites 48
- 3.2.4 Other Materials 49
- 3.3 Surface Preparation Processes 49
- 3.3.1 Passive Processes 51
- 3.3.1.1 Passive Chemical Processes 51
- 3.3.1.2 Passive Mechanical Processes 55
- 3.3.2 Active Processes 59
- 3.3.2.1 Active Chemical Processes 59
- 3.3.2.2 Physical–Chemical Processes 62
- 3.3.3 Primers and Adhesion Promoters 65
- 3.4 Conservation of the Post-treatment Surface 67

4 Main Families of Adhesives and Adhesive Selection 69

- 4.1 Typical Composition of a Modern Adhesive 69
- 4.2 Methods for Adhesive Classification 70
- 4.2.1 Molecular Structure 70
- 4.2.1.1 Thermosets 71
- 4.2.1.2 Thermoplastics 71
- 4.2.1.3 Elastomers 72
- 4.2.1.4 Hybrid Materials 72
- 4.2.2 Physical Form 74
- 4.2.3 Mechanical Properties 74
- 4.2.4 Hardening and Implementation Method 75
- 4.2.4.1 Hardening by Chemical Reaction 75
- 4.2.4.2 Hardening via Physical Processes 76
- 4.2.4.3 Pressure-Sensitive Adhesives 76
- 4.2.5 Chemical Composition 77
- 4.3 Main Structural Adhesives 77
- 4.3.1 Epoxy Adhesives 77
- 4.3.2 Polyurethane Adhesives 78
- 4.3.3 Acrylic Adhesives 79
- 4.3.4 Phenolic Adhesives 80
- 4.3.5 Aromatic Adhesives 81

Contents vii

- 4.4 Main Non-structural Adhesives 81
- 4.4.1 Elastomeric Adhesives *81*
- 4.4.2 Polyester Adhesives 82
- 4.4.3 Hot Melt Adhesives 82
- 4.4.4 Inorganic Adhesives 83
- 4.5 How to Select an Adhesive 83
- 4.5.1 Case Study: Adhesive Selection for the Automotive Industry 84
- 4.6 How to Test and Characterise an Adhesive 88
- 4.6.1 Mechanical Testing 88
- 4.6.1.1 Strength Tests 89
- 4.6.1.2 Fracture Tests 93
- 4.6.1.3 Testing Under Severe Environmental and Loading Conditions 98
- 4.7 Mechanical Properties of Adhesives 102

5 Manufacture 107

- 5.1 Adhesive Storage 107
- 5.1.1 Storage Time 108
- 5.1.2 Humidity 109
- 5.1.3 Temperature 109
- 5.1.4 Light and UV Radiation 110
- 5.2 Adhesive Metering and Mixing 110
- 5.2.1 Adhesive Metering 111
- 5.2.2 Adhesive Mixing 111
- 5.3 Adhesive Forms and Application 114
- 5.3.1 Liquid Adhesives 114
- 5.3.2 Paste Adhesives 115
- 5.3.3 Film Adhesives 116
- 5.3.4 Tapes 117
- 5.4 Joint Assembly and Fixturing 117
- 5.4.1 Moulds and Fixtures 117
- 5.4.2 Adhesive Thickness Control 119
- 5.4.3 Joint Assembly 119
- 5.5 Adhesive Hardening 120
- 5.5.1 Heat Curing Processes 121
- 5.5.2 Evaporation-Based Processes 125
- 5.6 Finishing Steps 126

6 Quality Control 127

- 6.1 Quality Control of the Incoming Materials 128
- 6.1.1 Control of Adhesive Quality 128
- 6.1.1.1 Mechanical Properties 128
- 6.1.1.2 Viscosity 128
- 6.1.2 Control of Adherend Quality 129
- 6.1.2.1 Mechanical Properties 129
- 6.1.2.2 Wettability, Contact Angle, and Surface Energy 129

6.1.2.3 Surface Roughness 131	
-------------------------------	--

- 6.2 Quality Control of the Manufacturing Process 133
- 6.3 Quality Control on Bonded Structures 137
- 6.3.1 Types of Defects Present in Bonded Joints 137
- 6.3.2 Destructive Tests 138
- 6.3.2.1 Proof Tests 139
- 6.3.2.2 Fractography Analysis 139
- 6.3.3 Non-destructive Tests 141
- 6.3.3.1 Visual Inspection 141
- 6.3.3.2 Tap Test 142
- 6.3.3.3 Ultrasonic Test 143
- 6.3.3.4 Acoustic Emission Test 143
- 6.3.3.5 Radiography Test 144
- 6.3.3.6 Eddy Current Test 145
- 6.3.3.7 Thermal Infrared Method 146
- 6.3.3.8 Lamb Wave-Based Testing 146
- 6.3.3.9 Electromechanical Impedance Spectroscopy 146
- 6.3.3.10 Laser-Based Testing 149

7 Environment, Health, and Safety 151

- 7.1 Toxicity of Adhesives: Are Adhesives Really Toxic? 153
- 7.2 General Precautions for Handling Adhesives 153
- 7.2.1 Pictograms 154
- 7.2.2 Training for Handling Adhesives 157
- 7.2.3 Safety Eyewear 158
- 7.2.4 Hand Protection Gloves 158
- 7.2.5 Safety Shoes 159
- 7.2.6 Lab Coat 159
- 7.2.7 Ventilation Systems 159
- 7.3 Hazardous Characteristics of the Most Common Adhesives 160
- 7.3.1 Structural Adhesives 160
- 7.3.1.1 Epoxies 160
- 7.3.1.2 Polyurethanes 161
- 7.3.1.3 Acrylic Adhesives 161
- 7.3.1.4 Phenolic Adhesives 161
- 7.3.1.5 Aromatic Adhesives 161
- 7.3.2 Non-structural Adhesives 162
- 7.3.2.1 Synthetic Rubbers 162
- 7.3.2.2 Polyesters 162
- 7.3.2.3 Hot Melt Adhesives 162
- 7.3.2.4 Inorganic Adhesives 162
- 7.4 Surface Preparation Precautions *162*
- 7.5 Adhesive Application Precautions 164
- 7.6 Environmental Protection 164
- 7.6.1 Air 165

- 7.6.2 Water 165
- 7.6.3 Soil 166
- 8 Design of Bonded Joints 167
- 8.1 Main Loading Modes on Adhesive Joints 168
- 8.2 Main Adhesive Joint Geometries 169
- 8.3 Joint Strength Prediction Using Analytical Methods 171
- 8.3.1 Determination of Stresses Acting on an Adhesive Joint 172
- 8.3.2 Failure Criteria for Bonded Joints 175
- 8.3.2.1 Failure in the Adhesive 176
- 8.3.2.2 Failure in the Adherends 177
- 8.4 Joint Strength Prediction Using Numerical Methods 180
- 8.5 Parameters That Affect Joint Performance 183
- 8.5.1 Effect of Adhesive Thickness 183
- 8.5.2 Effect of Overlap Length 184
- 8.5.2.1 Overlap Length and Adhesive Behaviour 185
- 8.5.2.2 Overlap Length and Adherend Strength 186
- 8.5.2.3 Overlap Length and Composite Adherends 187
- 8.5.3 Effect of Temperature and Thermal Stresses 187
- 8.6 Methods to Improve Joint Strength 189
- 8.6.1 Adhesive Fillet 189
- 8.6.2 Mixed Adhesive Joints 190
- 8.6.3 Functionally Graded Joints 190
- 8.6.4 Hybrid Joints 191
- 8.7 Case Studies 192
- 8.7.1 Case Study 1 Effect of Adhesive Type on the Strength of Adhesive Joints *192*
- 8.7.2 Case Study 2 Effect of Overlap Length and Adherend Type on the Strength of Adhesive Joints *194*
- 8.7.3 Case Study 3 Effect of Adhesive Thickness on the Strength of Adhesive Joints *197*
- 8.7.4 Case Study 4 Strength Prediction of Adhesive Joints with Composite Adherends 201
- 8.7.5 Case Study 5 Strength Prediction of an SLJ with Cohesive Zone Modelling 205
- 8.7.6 Case Study 6 Effect of Thermal Stresses on Adhesive Joints 208

9 Durability of Adhesively Bonded Joints 213

- 9.1 Environmental Effects 214
- 9.1.1 Hygrothermal Ageing 214
- 9.1.2 Temperature 220
- 9.2 Loading Conditions 221
- 9.2.1 Fatigue 221
- 9.2.1.1 Total Fatigue Life (S–N) Approach 223
- 9.2.1.2 Fatigue Crack Growth Approach 225
- 9.2.2 Creep 229

x Contents

10 Case Studies *235*

- 10.1 Vehicle Construction 235
- 10.2 Seat Fixation in Passenger Trains 237
- 10.3 Aeronautical Applications 239
- 10.4 Flexible Cooling Circuits 241
- 10.5 Glass to Metal Bonding in Appliances 243
- 10.6 Roof Coverings 245
- 10.7 Shoe Manufacture 246
- 10.8 Food Packaging 248

Recommended Bibliography 251 Referenced Bibliography 251 Index 253