

Contents

Preface XV

List of Contributors XVII

1	Adhesive Bonding as a Joining Technique	1
2	The Historical Development of Adhesive Bonding	5
3	Adhesion	11
3.1	Introduction	11
3.2	Classical Adhesion Theories	14
3.2.1	Polarization Theory	17
3.2.2	Diffusion Theory	20
3.2.3	Chemical Reactions	21
3.3	Adhesion in Real Systems	24
3.3.1	Gold	25
3.3.2	Polyethylene and Polypropylene	25
3.3.3	Glass	26
3.4	New Concepts in the Field of Adhesion	26
3.5	Conclusions	28
4	Survey and Classification of Adhesives and Primers	29
4.1	Noncuring (Pressure-Sensitive) Adhesives	29
4.2	Physically Setting Adhesives	33
4.2.1	Contact Adhesives	33
4.2.2	Plastisol Adhesives	34
4.2.3	Hot-Melt Adhesives	34
4.3	Chemically Setting Adhesives	35
4.3.1	Two-Part Adhesives	35
4.3.2	Hot-Setting, One-Part Adhesives	36
4.3.3	Cold-Setting, One-Part Adhesives	36

4.3.4	Microencapsulated Adhesives	37
4.4	Primers	37
4.5	General Handling Instructions	38
5	Chemistry and Properties of Adhesives and Primers	39
5.1	Pressure-Sensitive Adhesives (PSAs)	40
5.1.1	Introduction	40
5.1.2	Chemistry of Pressure-Sensitive Adhesives	40
5.1.3	Physical Properties of Pressure-Sensitive Adhesives	43
5.1.4	Properties of Pressure-Sensitive Adhesives as a Function of Temperature	44
5.1.5	Tack	45
5.1.6	Peel Resistance	45
5.1.7	Creep	45
5.1.8	Formulations of PSAs	46
5.1.8.1	Typical Formulation of Natural Rubber-Based PSAs	46
5.1.8.2	Typical Formulation of Block Copolymer PSAs	46
5.1.8.3	Typical Formulation of Acrylate-Based PSAs	47
5.2	Contact Adhesives	47
5.2.1	Composition of Contact Adhesives	47
5.2.2	Properties and Fields of Application of Contact Adhesives	48
5.3	Hot Melts	49
5.3.1	Thermoplastic Hot Melts	50
5.3.2	Hot-Seal Adhesives	51
5.3.3	Plastisols	51
5.3.4	Self-Bonding Varnishes	52
5.3.5	Polyurethane-Based Reactive Hot Melts	52
5.3.6	Epoxy Resin-Based Reactive Hot Melts	52
5.3.7	Trends in Hot-Melt Technology	53
5.4	Phenolic Resin Adhesives	53
5.4.1	Chemistry of Phenolic Resins	53
5.4.2	Formulation of Phenolic Resin Adhesives	56
5.4.3	Behavior and Applications of Phenolic Resin Adhesives	57
5.5	Epoxy Resin Adhesives	58
5.5.1	Chemistry of Epoxy Resin Adhesives	58
5.5.2	Reactions of Epoxy Resins	59
5.5.3	Properties of Epoxy Resin Adhesives	60
5.5.4	Formulations of Epoxy Resin Adhesives	63
5.5.4.1	Epoxy Resins	63
5.5.4.2	Crosslinking Agents	64
5.5.4.3	Hardeners	64
5.5.4.4	Flexibilizers and Additives That Improve Impact Toughness	64
5.5.4.5	Fillers and Thixotroping Agents	65
5.5.4.6	Further Additives	65
5.5.4.7	Typical Epoxy-Resin Adhesive Formulations	65

5.6	Polyurethane Adhesives	66
5.6.1	Chemistry of Polyurethanes	66
5.6.2	Raw Materials	67
5.6.2.1	Isocyanates	67
5.6.2.2	Polyols	68
5.6.2.3	Catalysts	69
5.6.3	Structure and Properties of Polyurethane Adhesives	69
5.6.3.1	One-Part Polyurethane Adhesives	69
5.6.3.2	Two-Part Polyurethane Adhesives	70
5.6.4	Formulations of Polyurethane Adhesives	70
5.7	Acrylate Adhesives	71
5.7.1	Physically Setting Acrylates	71
5.7.1.1	Solvent-Containing Acrylates	71
5.7.1.2	Dispersion Acrylates	71
5.7.1.3	Acrylate-Based Contact Adhesives	71
5.7.2	Chemically Setting Acrylates	71
5.7.2.1	Monomers	73
5.7.2.2	Two-Part Acrylates/Methacrylates	74
5.7.2.3	One-Part Acrylates/Methacrylates	75
5.7.2.4	Examples of Application	75
5.7.2.5	Anaerobic Acrylates	76
5.7.2.6	UV-Setting Acrylates	77
5.7.2.7	Cyanoacrylate Adhesives	83
5.7.3	Formulations of Acrylate Adhesives	84
5.7.3.1	Formulation of a Two-Part Acrylate 'No Mix' Adhesive	84
5.7.3.2	Formulations of UV-Setting Acrylate Adhesives	84
5.7.3.3	Formulations of Cyanoacrylate Adhesives	85
5.8	Silicones	85
5.8.1	One-Part Silicone Adhesives	85
5.8.2	Two-Part Silicone Adhesives	86
5.8.2.1	Condensation Crosslinking	86
5.8.2.2	Addition Crosslinking	87
5.9	Natural Adhesives	88
5.9.1	Introduction	88
5.9.2	Natural Raw Materials	89
5.9.3	Modern Adhesives Based on Natural Raw Materials	91
5.9.3.1	Glutine Glue	92
5.9.3.2	Casein Glues	92
5.9.3.3	Dextrin Glues	93
5.9.3.4	Natural Material-Based Pressure-Sensitive Adhesives	93
5.9.4	Future Trends	94
5.10	Chemistry of Primers and Adhesion Promoters	94
5.10.1	Primers	95
5.10.2	Adhesion Promoters	96
5.11	Fillers	99

6	Design, Production and Quality Assurance of Adhesive Bonded Joints	101
6.1	Design and Dimensioning	101
6.1.1	Interaction of Polymer Behavior and State of Stress	101
6.1.2	Design of Adhesive Bonded Joints	103
6.1.3	Dimensioning of Adhesive Bonded Joints	104
6.2	Surface Preparation	108
6.2.1	Mechanical Surface Preparation Methods	109
6.2.1.1	Grit Blasting	109
6.2.1.2	Grinding	110
6.2.1.3	Brushing	110
6.2.2	Chemical Surface Preparation Techniques	111
6.2.3	Physical Surface Preparation Techniques	111
6.2.3.1	Flame Treatment	111
6.2.3.2	Microplasma Treatment	111
6.2.3.3	Atmospheric Plasma Treatment	112
6.2.3.4	Low-Pressure Plasma Treatment	112
6.2.3.5	Corona Treatment	112
6.2.4	The Preconditions of Adhesion	112
6.2.5	Protection of Prepared Surfaces	114
6.3	Application of the Adhesive	115
6.3.1	Processing of Adhesives	115
6.3.1.1	Processing of Two-Part Adhesive Systems	115
6.3.1.2	Processing of One-Part Adhesive Systems	119
6.3.1.3	Hot-Melt Adhesives	121
6.3.1.4	Film Adhesives	121
6.3.1.5	Hybrid Bonding	122
6.3.2	Quality Assurance	123
7	Adhesives and Adhesive Joints: Test Methods and Properties	125
7.1	Adhesive Bulk Properties	126
7.1.1	Stress–Strain Analysis of Bulk Specimens	126
7.1.2	Determination of T_g by Dynamic Mechanical Analysis or Differential Scanning Calorimetry	127
7.1.3	Coefficient of Thermal Expansion (CTE)	128
7.1.4	Temperature Resistance by Thermogravimetry	128
7.2	Test Categories by Type of Mechanical Stress	128
7.2.1	Tensile Stress (e.g. Butt Joints)	128
7.2.2	Shear Stress (e.g. Single Lap Shear Specimen)	130
7.2.3	Cleavage (e.g. Wedge Test)	132
7.2.4	Fracture Resistance	133
7.2.5	Wedge Test	133
7.2.6	Peel Test	134
7.3	Test Categories by Duration and Load Rate	137
7.3.1	Long-Term Static Tests (e.g. Creep Experiments Under Dead Load)	137

7.3.2	Impact Tests (e.g. Impact Wedge Test to Evaluate Crash Performance)	138
7.3.3	Cyclic Loading (e.g. Fatigue Tests)	139
7.4	Assessment of Durability and Service Life of Adhesive Joints	139
7.5	Tests Related to Storage and Handling of Adhesives	143
7.5.1	Determination of Words and Phrases Relating to the Product Life	143
7.5.2	Open Time and Working Life	143
7.5.3	Extrudability	144
7.5.4	Sagging	144
7.5.5	Volatile Organic Compound (VOC) Emissions	144
7.6	Nondestructive Testing Methods	145
7.6.1	Visual Techniques	146
7.6.2	Radiographic Techniques	146
7.6.3	Magnetic, Electrical and Chemical Techniques	146
7.6.4	Mechanical Vibration	147
7.6.4.1	Impulse-Induced Resonance	147
7.6.4.2	Pulse Echo	148
7.6.4.3	Through-Transmission Sound Testing	149
7.6.5	Thermal Methods	149
7.6.5.1	Optical and Ultrasonic Lockin Thermography	149
7.6.5.2	Ultrasound Burst Phase Thermography	151
7.6.5.3	Excitation Mechanisms for Active Thermography	153
7.6.6	Assessment of Nondestructive Testing Methods	155
7.7	Applications of Test Methods in Structural Adhesive Bonding	156
7.7.1	Tensile Shear Strength Under Short-Term Loading	157
7.7.2	Tensile Shear Strength Under Long-Term Static and Alternating Loading	162
7.7.3	Peel Strength	164
7.7.4	Impact Behavior	165
7.7.5	Durability of Bonded Joints	166
7.7.6	Adhesive Bonding of Aluminum	168
7.7.7	Adhesive Bonding of Steel	183
7.7.8	Adhesive Bonding of Glass	188
7.7.9	Adhesive Bonding of Polymer Materials	191
7.8	Experiences and Learning from Damage Cases	191
7.8.1	Delamination of Bonded Rotor Blade Pockets	193
7.8.2	Total Separation of a Rotor Blade Profile	194
7.8.3	Bond-Line Corrosion in Wing Honeycombs	196
7.8.4	Delamination of the Outer Cover Sheet of Tail Units of Aircraft	197
7.8.5	Temperature-Induced Damage on a Tail Rotor Blade	199
7.8.6	Temperature-Induced Delamination of a Bonded Glass Fiber Patch	200
7.8.7	Incorrect Design of Bonded Filter Elements	201
7.8.8	Deficiencies of the Peel Ply Treatment	202

8	Adhesive Bonding Technology: Fields of Application	205
8.1	Introduction	205
8.2	Transportation	206
8.2.1	Aircraft Manufacture	207
8.2.1.1	Historical Development	209
8.2.1.2	Advantages of Bonding in Aircraft Manufacture	213
8.2.1.3	Adhesives Used in Aircraft Manufacture	216
8.2.1.4	Surface Preparation	217
8.2.1.5	Bonding Techniques	218
8.2.1.6	Quality Control of Bonding in Aircraft Manufacture	218
8.2.1.7	Conclusions	219
8.2.2	The Automotive Industry	220
8.2.2.1	Bonding in Passenger Car Bodywork Construction	223
8.2.3	Bonding in Rail Vehicle Manufacture	234
8.2.4	Shipbuilding	235
8.3	Building Industry	237
8.3.1	Adhesives for the Bonding of Surfaces	237
8.3.1.1	Adhesive Mortars for Tiling	237
8.3.1.2	Floor-Covering Adhesives	238
8.3.2	Adhesive Anchors in the Building and Construction Industry	238
8.3.2.1	Adhesive Anchor Systems	238
8.3.2.2	Adhesives	240
8.3.3	Building Reinforcement by Means of Bonded Surface Reinforcement	241
8.3.4	Structural Bonding in Structural Steel and Facade Engineering	241
8.4	Wooden Constructions	243
8.4.1	Introduction	243
8.4.2	The Structure of Wood	245
8.4.2.1	The Molecular Structure of Wood	245
8.4.2.2	The Macroscopic Structure of Wood	246
8.4.3	Consequences	246
8.4.3.1	Strength, Swelling and Shrinking	246
8.4.4	Adhesive–Wood Interphase	247
8.4.5	Adhesive Systems	247
8.4.6	Adhesives Based on Renewable Resources	248
8.4.7	Synthetic Wood Adhesives	249
8.4.7.1	Physically Setting Systems	249
8.4.7.2	Chemically Setting Adhesives	249
8.4.7.3	Adhesion Promoters (Primers)	251
8.4.8	Wood Composites	251
8.4.9	The Supreme Discipline: Laminated Wood Constructions (Civil Engineering Using Wood as Building Material)	253
8.4.9.1	Development	253
8.4.9.2	Laminated Wood Constructions Today	253
8.4.10	Prefabricated Elements	255

8.4.11	Prospects of Wood Constructions	257
8.5	Paper and Packaging Industry	257
8.5.1	Introduction	257
8.5.2	Manufacture of Packaging Materials	258
8.5.2.1	Corrugated Board and Paperboard Containers	258
8.5.2.2	Lamination	259
8.5.2.3	Folder Gluer	259
8.5.2.4	Folding Cartons	260
8.5.2.5	Flexible Packages	260
8.5.2.6	Bags, Pouches and Sacks	263
8.5.3	The Setting-Up and Closing of Trays and Boxes	264
8.5.3.1	Setting-Up a Tray	264
8.5.3.2	Carton Closing	264
8.5.4	Pallet Securing	267
8.5.5	Labeling	269
8.5.5.1	Pressure-Sensitive Labels	269
8.5.5.2	Inline Labeling	270
8.5.5.3	Tamper-Evident Bottle Closures	273
8.5.5.4	Membrane Bonding	274
8.5.6	Cigarette Production	274
8.5.7	Manufacture of Tissue Paper Products	274
8.5.7.1	Core Winding	275
8.5.7.2	Lamination	276
8.5.7.3	Pick-Up Adhesives	277
8.5.7.4	Tail Tie Adhesives	277
8.5.8	Graphic Products	278
8.5.8.1	Unsewn Binding	278
8.5.8.2	Unsewn Binding with Dispersion Adhesives	279
8.5.8.3	Unsewn Binding with Hot Melts	279
8.5.8.4	Unsewn Binding with Reactive Polyurethane Hot Melts	280
8.5.8.5	Multilayer Unsewn Binding	282
8.5.8.6	Side Gluing	283
8.5.8.7	Backgluing of Thread-Sewn Book Blocks	284
8.5.8.8	Book Manufacture	284
8.5.8.9	Making the Case	285
8.5.8.10	Casing-In	285
8.5.8.11	Fold Gluing	286
8.5.9	Envelopes and Advertising Mail	286
8.5.10	Reuse and Recycling of Paper and Packages	287
8.5.10.1	Reuse	287
8.5.10.2	Recycling	288
8.5.10.3	Recycling of Paper Products	288
8.5.10.4	Recycling of Plastic Packaging	291
8.5.10.5	Compostable Products	291
8.5.11	Regulations Stipulated by Law	292

8.5.12	Perspectives	292
8.6	Small-Scale Industries and Handicraft Trades	293
8.6.1	Joining	293
8.6.1.1	Structural Adhesives	294
8.6.1.2	Cyanoacrylate Adhesives	295
8.6.1.3	Postcuring Hot Melts	296
8.6.1.4	Hot-Melt Adhesive Systems	296
8.6.1.5	Aerosol Adhesives	297
8.6.1.6	Dispersion Adhesives	297
8.6.1.7	Solvent-Based Adhesives	298
8.6.1.8	High-Performance Acrylic PSA Tapes	298
8.6.1.9	Reclosable Fasteners	300
8.6.1.10	Screen-Printable Adhesives	301
8.6.2	Protecting, Splicing and Masking	301
8.6.3	Damping	304
8.6.4	Labeling, Marking and Coding	305
8.7	Electronics Industry	307
8.7.1	Thermally Conductive Adhesives	307
8.7.2	Electrically Conductive Adhesives	308
8.7.3	Underfill Materials	310
8.7.4	Functional PSA Tapes	310
8.7.5	Spacers	311
8.7.6	Labeling	311
8.8	Optical Industry	312
8.8.1	General Requirements for Adhesives in Optical Industry	312
8.8.2	Optical Adhesives for the Temporary Fixture of Optical Elements	313
8.8.3	Optical Cementing	314
8.8.4	Bonding Optical Elements to Mounts	315
8.9	Mechanical Engineering and Process Equipment Construction	316
8.9.1	Mechanical Engineering	316
8.9.2	Domestic Appliance Industry	317
8.9.3	Manufacture of Internal Combustion Engines and Transmission Manufacturing	317
8.9.4	Stainless Steel Structures	319
8.10	Textile Industry	320
8.10.1	The Early History of Fabric-Reinforced Rubber Materials	320
8.10.2	How Textile Fibers Contribute to the Living Standards of the Industrial World	321
8.10.2.1	Technical Textiles	322
8.10.2.2	Textiles as Rubber Reinforcements	322
8.10.3	General Properties of Elastomers (Rubber)	323
8.10.4	Treatment of Textiles for Rubber Reinforcement	324
8.10.4.1	Reinforcement Fibers	324
8.10.4.2	Adhesive Systems Used to Treat Textiles	324

- 8.10.4.3 Effect of the Fiber Type on the Adhesive System 326
- 8.10.4.4 Direct Adhesion Through Addition of the Adhesion Promoter to the Rubber Mixture 328
- 8.10.5 Adhesion Mechanisms 328
- 8.10.6 Aging of RFL-Dipped Textiles 330
- 8.11 Footwear Industry 332
- 8.12 Road and Highway Engineering 333
 - 8.12.1 Traffic Signs 334
 - 8.12.2 Pavement Markings 335
 - 8.12.3 License Plates 337
- 8.13 Surface Design 337
 - 8.13.1 Surface Design and Surface Protection 337
 - 8.13.2 Fleet Graphics 338
 - 8.13.3 Public Transport Advertising 338
 - 8.13.4 Building and Floor Graphics 340
- 8.14 Tamper-Indicating Labels 341
- 8.15 Medical Sector 343
 - 8.15.1 Medical Devices with Short-Term, Superficial Body Contact 343
 - 8.15.2 Medical Devices with Several (up to 30) Days Body Contact 343
 - 8.15.3 Medical Devices with Long-Term (Over 30 Days) Body Contact 344
- 8.16 Adhesion in Nature 346
 - 8.16.1 Design Principles of Biological Attachment Devices 346
 - 8.16.2 Gluing Under Water 347
 - 8.16.2.1 Byssus Adhesion in Mollusks 348
 - 8.16.2.2 Tube Feet of Starfish 351
 - 8.16.2.3 Adhesion in Barnacles 353
 - 8.16.2.4 Temporary Adhesion in Cladoceran Crustaceans 354
 - 8.16.2.5 Adhesion in Larval Fish and Ascidians 354
 - 8.16.3 Adhesion in Terrestrial Insects 354
 - 8.16.3.1 Permanent Adhesion in Insects and Spiders 354
 - 8.16.4 Adhesion in Plants 355
 - 8.16.5 Surface-Replicating Mechanism Based on Growth 356
- 8.17 Little-Known Applications 356
 - 8.17.1 Foils for the Rotors of Wind Turbines 356
 - 8.17.1.1 Erosion-Protection 357
 - 8.17.1.2 Lightning Protection and Performance Enhancement 358
 - 8.17.2 Adhesive Elastomer Composites 358
 - 8.17.3 Light Bulbs 359
 - 8.17.4 Bonding in Art, Jewelry Making and Archeology 361
 - 8.17.4.1 Art 361
 - 8.17.4.2 Jewelry Making 363
 - 8.17.4.3 Archeology 364
 - 8.17.5 Removable Adhesive Joints 365
 - 8.17.5.1 Commercially Available Removable Adhesive Systems 365
 - 8.17.5.2 High-Strength Removable Adhesives 367

9	Perspectives	371
9.1	Economic Trends	371
9.2	Technical Trends	371
	Appendix	375
	References	393
	Index	403