



Designation: D952 – 15 (Reapproved 2021)

Standard Test Method for Bond or Cohesive Strength of Sheet Plastics and Electrical Insulating Materials¹

This standard is issued under the fixed designation D952; 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 (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope

1.1 This test method covers the determination of the bond strength or ply adhesion strength of sheet plastic and electrical insulating materials. It is applicable to both laminated and nonlaminated thermoplastic and thermosetting materials.

1.2 Test data obtained by this test method is relevant and appropriate for use in engineering design.

1.3 The values stated in SI units are to be regarded as standard. The values given in parentheses after SI units are provided for information only and are not considered standard.

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, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

NOTE 1—There is no known ISO equivalent to this standard.

1.5 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 *ASTM Standards:*²

[D618 Practice for Conditioning Plastics for Testing](#)

[D883 Terminology Relating to Plastics](#)

[D4000 Classification System for Specifying Plastic Materials](#)

[D5947 Test Methods for Physical Dimensions of Solid Plastics Specimens](#)

[D6988 Guide for Determination of Thickness of Plastic Film Test Specimens](#)

[E691 Practice for Conducting an Interlaboratory Study to Determine the Precision of a Test Method](#)

2.2 *ANSI Standard:*³

[B1.1 Standard for Unified Screw Threads](#)

3. Terminology

3.1 *Definitions*—For definitions of technical terms pertaining to plastics used in this test method, see Terminology [D883](#).

4. Significance and Use

4.1 This test, when applied to laminated plastics, is a measure of the interlaminar or intralaminar strength, whichever is smaller, in a direction normal to the plane of the laminate. When applied to nonlaminated plastics, the test is a measure of the cohesive strength of the material. The property determined is fundamental and has not yet been correlated with the results of any other method for bond strength.

4.2 The test is potentially useful as (1) a research test when studying the effects of changes in independent variables, (2) a specification test, or (3) a referee test.

4.3 Before proceeding with this test method, make reference to the specification of the material being tested. Any test specimen preparation, conditioning, dimensions or testing parameters or combination thereof covered in the relevant ASTM materials specification shall take precedence over those in this test method. If there are no relevant ASTM material specifications then the default conditions apply. [Table 1](#) of Classification System [D4000](#) lists the ASTM materials standards that currently exist.

5. Apparatus and Materials

5.1 *Testing Machine*—Any suitable tensile testing machine capable of crosshead movement at a constant rate of 1.3 mm/min. (0.05 in./min.) and of sufficient capacity to exceed the failure load of the material being tested.

¹ This test method is under the jurisdiction of ASTM Committee [D09](#) on Electrical and Electronic Insulating Materials and is the direct responsibility of Subcommittee [D09.07](#) on Electrical Insulating Materials.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

³ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.

TABLE 1 Precision Data

Materials	Average Strength, MPa (psi)	Coefficient of Variation	
		v_r Within ^A Laboratories	v_R Between ^B Laboratories
BMC	12.7 (1840)	7.1	7.1
SMC	14.0 (2030)	5.4	8.8

^A v_r is the within-laboratories standard deviation of the mean, expressed as a percentage of the listed average.

^B v_R is the between-laboratories standard deviation of the mean, expressed as a percentage of the listed average.

5.2 *Loading Fixtures*—The loading fixtures shall be self-aligning and shall not apply eccentric loads.

5.3 *Metal Blocks*—A pair of 51-mm (2-in.) square metal blocks each having a maximum height of 51 mm (2 in.). Each block shall be configured to permit attachment to the testing machine's loading fixture (see Fig. 1).

NOTE 2—Blocks constructed from heat-treated aluminum alloy, each having a hole in one end tapped $\frac{7}{8}$ in. in accordance with ANSI B1.1, to accommodate threaded $\frac{7}{8}$ -in. studs of convenient length, have been used successfully.

5.4 *Adhesive*—It is acceptable to use any adhesive that is found to perform satisfactorily under this test provided that it will not influence the specimen behavior by physical or chemical effects.

NOTE 3—Redux⁴ has been found satisfactory for use with certain thermoset materials. Cyanoacrylate cement and room-temperature-curing epoxy have been used successfully for both thermoplastic and thermoset materials.

6. Test Specimen

6.1 The test specimen shall consist of sheet material 51 mm (2 in.) square, prepared in such a manner as to produce smooth edges. The thickness of the specimen shall be the thickness of

⁴ Redux is available from the Shur-Lok Bonded Structures, Ltd., 1300 E. Normandy Place, Santa Ana, CA.

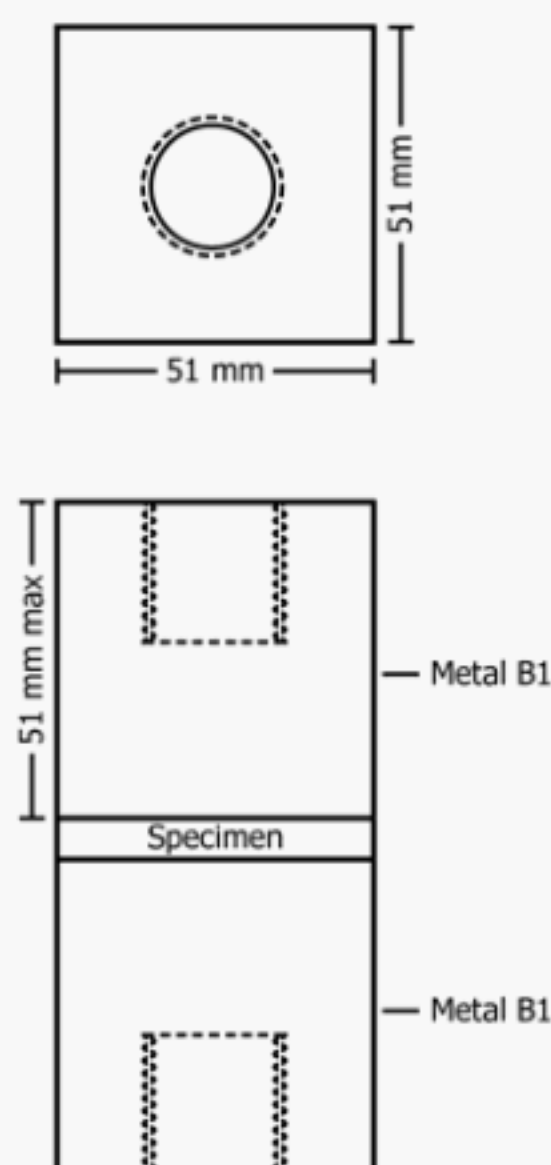


FIG. 1 Test Assembly for Bond Strength Test

the material. Opposite surfaces need to be as parallel as possible to prevent eccentric loading of the material.

6.1.1 Thickness of the test specimens shall be determined in accordance with Guide D6988 for materials 0.25 mm or less in thickness, and Test Methods D5947 for materials greater than 0.25 mm in thickness.

6.2 At least five specimens shall be tested for each sample.

6.3 For testing the material specified, this test method is designed so that failure between the adhesive and the metal does normally not occur. If failure does occur between the adhesive and the metal blocks, or between the adhesive and the specimen, discard the result and test another specimen.

7. Conditioning

7.1 *Conditioning*—Condition the test specimens at 23 ± 2 °C (73.4 ± 3.6 °F) and 50 ± 10 % relative humidity for not less than 40 hours for test specimens 7 mm or less in thickness, and at 23 ± 2 °C (73.4 ± 3.6 °F) and 50 ± 10 % relative humidity for not less than 88 hours for test specimens greater than 7 mm in thickness in accordance with Procedure A of Practice D618, unless otherwise specified by contract or the relevant ASTM material specification. In cases of disagreement, the tolerances shall be ± 1 °C (± 1.8 °F) and ± 5 % relative humidity. Conditioning time is specified as a minimum. Temperature and humidity tolerances shall be in accordance with Section 7 of Practice D618 unless specified differently by contract or material specification.

7.2 *Test Conditions*—Conduct tests at 23 ± 2 °C (73.4 ± 3.6 °F) and 50 ± 10 % relative humidity in accordance with Section 7 of Practice D618 unless otherwise specified by contract or the relevant ASTM material specification. In cases of disagreement, the tolerances shall be ± 1 °C (± 1.8 °F) and ± 5 % relative humidity.

8. Specimen Preparation

8.1 Determine the cross-sectional area of the test specimen in a plane parallel to the surface. Gently rub both sides of the specimen with 00 emery cloth. Do not rub the specimen on the cloth since the corners will then be abraded more than other parts of the surface. Clean the bond areas of the specimen and metal blocks with a suitable solvent which does not chemically affect the surfaces. Do not touch the cleaned surfaces with the hands. Apply a coating of adhesive to the cleaned surfaces of the blocks.

8.2 Place the specimen between the coated blocks being certain that the blocks are aligned. If pressure or temperature, or both, is (are) necessary to cure the adhesive, insert the assembly into a properly adjusted press or oven, or both. The bonding pressure shall not be greater than the pressure used in the construction of the material. The bonding temperature shall be room temperature or at least 50 °C below the temperature at which the material was constructed. In any case, the bonding procedure shall not alter the material. Permit specimens to condition in accordance with 7.1.

9. Procedure

9.1 Attach the assembly to the loading fixtures and determine the tensile load required to break the specimen at a speed of $1.3 \text{ mm} \pm 0.33 \text{ mm}$ ($0.05 \pm 0.01 \text{ in.}$)/min.

NOTE 4—To prepare the metal blocks for reuse, the remaining portions of the test specimen and adhesive may be removed from the surfaces of the blocks by using a surface grinder. An abrasive wheel 178 mm (7 in.) in diameter and having a 12.7-mm ($\frac{1}{2}$ -in.) face, running at 2900 r/min, has been found to be satisfactory. Aloxite-AA-46-G6-V60, of the Carborundum Co., Niagara Falls, NY, has been found suitable for this purpose. In order to maintain a truly plane surface, it is recommended that the metal blocks be finished on a flat emery surface.

10. Calculation

10.1 Calculate the bond strength of each specimen in megapascals (or pounds-force per square inch) by dividing the load by the area of the test specimen.

10.2 Calculate the arithmetic mean of all values obtained to three significant figures and report as the “average value.”

10.3 Calculate the standard deviation (estimated) and report to two significant figures.

11. Report

11.1 Report the following information:

11.1.1 Complete identification of the material tested, including type or grade, nominal thickness, source, principal dimensions, previous history, etc.,

11.1.2 The adhesive used and the conditions under which it was applied (pressure or temperature applied, or both),

11.1.3 The atmospheric conditions in the test room,

11.1.4 The total load, in newtons (or pounds-force), required to break each specimen,

11.1.5 The average unit stress for all tests, in megapascals (or pounds-force per square inch), and the standard deviation,

11.1.6 *Description of Failure*—Whether progressive or sudden, adhesive or cohesive, and

11.1.7 The Test Method number and published/revision date.

12. Precision and Bias

12.1 **Table 1** is based on an interlaboratory test conducted in 1979 involving two materials tested by three laboratories. Each test result was the average of five specimens. Each laboratory obtained four test results for each material. (**Warning**—With such limited testing, the standard deviations in **Table 1** are likely to have a high degree of error. Therefore, the usual statistics for repeatability and reproducibility are not warranted.)

NOTE 5—A questionnaire circulated in May 1988 generated only one response from a user of this test method as well as one nonuser, both of whom would vote negative on any ballot to withdraw this test method. There were 19 other responses.

12.2 Do not apply the data in **Table 1** to acceptance or rejection of the material, as those data are specific to the round robin and are not necessarily representative of other lots, conditions, materials, or laboratories. Users of this test method need to apply the principles outlined in Practice **E691** to generate data specific to their laboratory and materials, or between specific laboratories.

12.3 *Bias*—There are no recognized standards by which to estimate bias of this test method.

13. Keywords

13.1 adhesive; bond strength; cohesive strength; interlaminar; intralaminar; laminated; plastics

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