Your reliable partner for adhesive bonding

Adhesive laboratory
Test methods

Standard laboratory ageing conditions for testing adhesive connections
The most appropriate method accelerated aging will depend on the type of adhesive and adherent material, and the intended use of the adhesive joint. In general, stimulatory aging methods are used in which the aging conditions attempt to simulate natural conditions, usually with only a moderate acceleration of the factors. For examples of aging methods include: heat aging, water resistance, freeze-thaw, corrosion and chemical resistance, artificial weathering. The ageing conditions are applicable to bonded assemblies and may be used to constitute a set of tests for the evaluation of an adhesive. For general applications, the following overview may serve to suggest accelerating aging cycles as being both applicable and relevant to the major mechanism of degradation.

Exposure to moisture (cataplasm test)
Aging at extreme humidity and 70°C for 7 or 14 days, depending on the intended application.

Exposure to water and other liquids
Immersion on 20, 23, 40, 60 or 80°C for typically 150 to 1500h, depending on the intended application. Note that this type of exposure simulates degradation under elevated temperature and high humidity, but does not promote corrosive attack due to the lack of oxygen in the immersion bath unless constantly aerated.

Aging on elevated temperature
Aging on elevated temperature in the absence of moisture especially promotes oxidation, embitterment and thermal degradation. Typical temperatures depend on the intended application. For adhesive bond under outside weathering temperatures of 80–120°C are common, depending on the geographical area of application.

Thermal cycling
Accelerated aging tests under cyclic change of temperature include the freeze-thaw transition to consider the detrimental effect of water penetration and icing. Temperatures typically span from -20 or -40°C to 60 or 80°C with 95% relative humidity during the warm period of the cycles. Typical number of cycles range from 100 to 300h. It should be considered that rapid transitions between high and low temperature limits may induce thermal stress beyond levels representative of outside weather conditions, for example.

UV exposure
Climatic chambers with phytotron system are available to simulated aging conditions, combining moisture, temperature and UV radiations. The test duration depends on the irradiation doses to be expected in the specific application, and typically range from 500 to 3000h. Clearly, such tests should mainly be considered if one or both adherents is/are transparent to the applied spectra of radiation.

Salt spray test
The salt spray test is an accelerated corrosion test that produces a corrosive attack to the metal and coated samples. The appearance of corrosion products (oxides) is evaluated after a period of time. Test duration depends on the corrosion resistance of the metal or coating. Standard cabinets for corrosion testing create a salt spray environment at 35°C. Exposure times typically range from 300 to 1000h depending on the intended application.
Equipment

- Cyclic corrosion chamber
  Ascott CCip 450

- Climatic chambers
  Binder MKF 240 / Poleco TOP+

- Drying ovens
  Binder ED 53 / Binder FD 115

- Universal testing machine
  Zwick Z050 TN ProLine

- Laboratory freezer
  Fryka B30-40

- Temperature and humidity measurement
  QMSYSTEM Module QLabPoll

- Viscometer Fungilab
  Smart Series L

- Precision balance Sartorius
  to 4 kg/0.01 g
Test methods and equipment

Determination of mechanical properties

Type of Test & Properties:
Used to determine the tensile strength and more of various materials from metals to plastics.

- Capacities of 1 kN and of 50 kN
- Tension, 90 degree, 180 degree, and T peel adhesion, shear, flexural

Equipment
- Zwick Z050 TN ProLine with wedge-screw grips - Fmax 50 kN

Determination of thermal properties of adhesives

Differential Scanning Calorimetry (DSC)
Measures other thermal and physical characteristics of polymers: glass transition temperature, melting point, curing efficiency, post-curing effects, phase transitions in thermoplastic polymers, thermal degradation of organic phase, oxidation of thermoplastics, filament content (accuracy of 0.01%), and more. We can also use these chemical analysis techniques to understand the «thermal history» of a material and determine failure modes.

- Temperature range: -180°C – 700°C
- Heating rates 0.001 K/min – 200 K/min

Equipment
- Netzsch 204 F1 Phoenix
- Mettler Toledo DSC 1

Thermogravimetric Analysis (TGA)
Measures the mass changes in a material as the sample is slowly heated. We can roughly determine the amount of water, volatiles, and non-volatiles in a sample by this technique.

- Temperature range: RT to 1100°C

Equipment
- Netzsch TG 209 F1 Libra
- Netzsch Jupiter STA 449F3

Determination of thermo-mechanical properties of adhesives

Dynamic Mechanical Analysis (DMA)

Type of Test & Properties
Measures the mechanical properties of materials as a function of time, temperature and frequency. It is most useful for studying the viscoelastic behavior of polymers. One important application of DMA is measurement of the glass transition temperature under cyclic deformation, measurement of dynamic viscosity in oscillatory mode, storage modulus, loss modulus, viscoelastic behaviour of adhesives vs. temperature and shear rates or deformation amplitude, etc.

- Temperature range: -150°C – 450°C

Equipment
- Oscillatory rheometer, dynamic-mechanical thermal analyzer, DMTA apparatus Anton Paar CTD 450
- Capillary rheometer Dynisco
- Melt Flow Indexer Dynisco

The laboratory offers a humidity test, a salt spray test and other analysis.
BODO MÖLLER CHEMIE laboratory

Our laboratory is an independent adhesives and materials R&D, consulting, and testing laboratory, offering a comprehensive knowledge of adhesive technology. It is located in Poland in the High Technology Incubators Complex of Poznań Science and Technology Park of Adam Mickiewicz University Foundation. The High Technology Incubators Complex is the largest laboratory and office complex designed for innovative companies and offering a friendly environment for the development of new technologies.

Our laboratory utilizes a Quality Management System in conformance with ISO 9001:2008 as well as the certificate for manufacturing adhesive bonds in accordance with DIN 2304. Furthermore, the laboratory is certified by TBB Cert according to the DIN 6701 standard for adhesive bonding of railway vehicles and parts. As we fulfill our duty to establish, execute, and evaluate product and regulatory requirements, we do so reinforcing themes of comprehensive planning, reliable reporting, and continual improvement.

Our adhesive testing lab provides you with exceptional precision and versatility to test everything from adhesives and sealants to specialty materials and packaging.

ISO standards

PN-ISO 4588-1999  
Guidelines for the surface preparation of metals

PN-EN 13887:2005  
Guidelines for surface preparation of metals and plastics prior to adhesive bonding

PN-EN ISO 9142:2005  
Guide to the selection of standard laboratory ageing conditions for testing bonded joints

PN-EN ISO 291:2010  
Standard atmospheres for conditioning and testing

PN-EN ISO 9227:2012  
Corrosion tests in artificial atmospheres – Salt spray tests

PN-EN 13523-27:2010  
Test methods: Resistance to humid poultice (Cataplasm test)

PN-EN ISO 10365:1998  
Designation of main failure patterns

PN-EN 1465:2009  
Determination of tensile lap-shear strength of bonded assemblies

PN-EN 28510-1:2000  
Peel Test for a Flexible-Bonded-to-Rigid Test Specimen Assembly – Part 1: 90 Degree Peel

PN-EN 28510-2:2000  
Peel Test for a Flexible-Bonded-to-Rigid Test Specimen Assembly – Part 2: 180 Degree Peel

PN-EN ISO 11339:2010  
T-peel test for flexible-to-flexible bonded assemblies

DIN 6701-2:2006  
Adhesive bonding of railway vehicles and parts  
Part 2: Qualification of manufacturer of adhesive bonded materials, quality assurance

DVS 1618:2002  
Elastic thick layer bonding in rail vehicle construction

DIN 54457:2014  
Testing of adhesively bonded joints: Bead peel test

PN-EN ISO 2555:2011  
Liquid polymers in form of emulsions or dispersions – determination of apparent viscosity by the Brookfield test method

PN-EN ISO 4892:1:2001  
Methods of exposure to laboratory light sources – Part 1: General guidance

PN-EN ISO 4892:2:2013  
Methods of exposure to laboratory light sources – Part 2: Xenon-arc lamps

PN-EN ISO 4892:3:2013  
Methods of exposure to laboratory light sources – Part 3: Fluorescent UV lamps

PN-EN ISO 9227:2014  
Corrosion tests in artificial atmospheres – Salt spray tests
Costs and service prices

Aging for Lap Shear Strength
A – 7 days RT 23°C. 50% rh
B – 7 days water, RT
C – 1 day 80°C
D – 7 days 70°C in 100% of RH (Cataplasma), 2h 23°C 50% rh, cool shock -30°C

Price per 1 bead of peel test or sample for lap shear acc. EN 1465 8,– €

Aging in special conditions (N₂, CO₂, -70°C, chemical treatment etc.) will be charged separately

Peel Test
Price per one line of adhesives 8,– €

Lap Shear Strength (LSS) – EN 1465
Lead cells: capacities of 1 kN and of 50 kN
Application: Determination of Tensile Lap-Shear Strength, according to EN 1465
Tear strength, Flexular strength, etc.
Price per one sample according to EN 1465 20,– €

Determination of thermal properties of adhesives
Equipment: DSC Differential Scanning Calorimeter Netzsch 204 F1 Phoenix and Mettler Toledo DSC 1
Temperature range: -180°C – 700°C, Heating rates 0.001 K/min – 200 K/min
TGA Thermogravimetric analyzer Netzsch TG 209 F1 Libra and Netsch Jupiter STA 449F3
Temperature range: RT to 1100°C
Application: Determination of glass transition, melting point, curing efficiency, post-curing effects, phase transitions in thermoplastic polymers, thermal degradation of organic phase, oxidation of thermoplastics, filament content (accuracy of 0.01%), etc.
Price per sample 99,– €

Determination of thermo-mechanical properties of adhesives
Equipment: Oscillatory rheometer, Dynamic-mechanical thermal analyzer, DMTA apparatus Anton Paar CTD 450
Temperature range: -150°C – 450°C, capillary rheometer Dynisco, melt indexer Dynisco
Application: Determination of glass transition temperature under cyclic deformation, measurement of dynamic viscosity in oscillatory mode, storage modulus, loss modulus, viscoelastic behaviour of adhesives vs. temperature and shear rates or deformation amplitude, etc.
Price per sample 99,– €

The laboratory offers a broad range of analytical techniques in the materials analysis and testing lab, including mass spectrometry, gas and liquid chromatography, elemental analysis, and spectroscopy.

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