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Second edition
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Adhesives — Determination of the bond strength of engineering-plastic joints

*Adhésifs — Détermination de la résistance de joints collés des
plastiques industriels*



Reference number
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Foreword

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The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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This document was prepared by Technical Committee ISO/TC 61, *Plastics*, Subcommittee SC 11, *Products*.

This second edition cancels and replaces the first edition (ISO 15509:2001), which has been technically revised. The main changes compared to the previous edition are as follows:

- the list of normative references in [Clause 2](#) has been updated;
- the mandatory terms and definitions clause ([Clause 3](#)) has been inserted.

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Introduction

Methods of determining the strength of adhesive joints are well known. Several International Standards describe various methods including the lap-shear test or the butt torsion test. However, these methods are either not suitable for the determination of values which can be used for design purposes, or are restricted to metallic substrates. Because the existing International Standards for the measurement of the strength of bonded plastic materials are derived from test methods for metals and are less suitable for plastic materials due to the bending of substrates and varying modulus of elasticity, a new test method and a new test geometry have been developed and are described in this document.