

Contents

Preface	VII
1 Introduction	1
1.1 Introduction and Chapter Objectives	1
1.2 Basic Definitions	2
1.3 Advantages and Disadvantages of Adhesive Bonding	3
1.4 Uses of Adhesive Bonding in Modern Industry	6
1.5 Economics of Adhesive Technology	13
1.6 Literature and Other Sources of Information	13
1.7 Summary	15
References	16
2 The Mechanical Properties of Materials as They Relate to Adhesion	17
2.1 Introduction	17
2.2 Definition of Mechanical Stresses for Materials Testing	17
2.3 Stress-Strain Plots and the Definition of Materials Property Parameters	19
2.3.1 Tensile Forces	19
2.3.2 Shear Forces	22
2.3.3 Strain Energy Density	23
2.4 Introduction to Linear Elastic Fracture Mechanics	24
2.5 Introduction to Rheology of Liquids	27
2.6 Introduction to Linear Viscoelasticity	29
2.7 An Application of Materials Properties and Mechanics: The Bending of Beams	34

2.8	Summary	43
	Bibliography	43
	Problems and Review Questions	44
3	Mechanical Tests of Adhesive Bond Performance	47
3.1	Introduction	47
3.2	Failure Modes and the Definition of Practical Adhesion	48
3.3	Tensile Testing of Adhesive Bonds	49
3.4	Shear Loading of Adhesive Bonds	52
3.4.1	The Standard Lap Shear Specimen	54
3.4.2	Variations on the Lap Shear Specimen	58
3.4.3	Specimen for Determining the True Shear Properties of an Adhesive	60
3.4.4	The Goland-Reissner Analysis of the Lap Shear Specimen	61
3.5	Cleavage Loading of Adhesive Bonds	69
3.5.1	Cleavage or Fracture Specimens	70
3.5.1.1	Double Cantilever Beam Specimens	71
3.5.1.2	Linear Elastic Fracture Mechanics Applied to the Double Cantilever Beam Specimen	72
3.5.2	Blister Test	73
3.5.3	Compact Tension Test	74
3.5.4	Wedge Test	75
3.6	Peel Tests	76
3.6.1	Stress Analysis in a Peel Specimen	79
3.7	Summary	82
	Bibliography	83
	References	83
	Problems and Review Questions	84
4	The Basics of Intermolecular Forces and Surface Science	85
4.1	Introduction	85
4.2	Fundamental Forces	86
4.2.1	Electrostatic Forces	87
4.2.2	van der Waals Interactions	88

4.2.2.1	Dipole–Dipole Interactions	89
4.2.2.2	Dipole-Induced Dipole	90
4.2.2.3	Dispersion Forces	91
4.2.3	Interactions through Electron Pair Sharing	93
4.2.4	Repulsive Forces	93
4.3	Surface Forces and Surface Energy	94
4.4	Work of Cohesion and Adhesion	98
4.5	Methods of Measurement of Surface Energy and Related Parameters ..	101
4.5.1	Surface Tension	101
4.5.1.1	Drop Weight/Volume Method	101
4.5.1.2	Du Nuoy Tensiometer	102
4.5.2	Surface Energy of Solids	102
4.5.2.1	Contact Angle Methods	103
4.5.2.2	Contact Mechanics and Direct Measurement of Solid Surface Energy	106
4.6	Surface Thermodynamics and Predictions of Surface and Interfacial Tensions	112
4.6.1	The Good-Girifalco Relationship	114
4.6.2	The Fowkes Hypothesis and Fractional Polarity	115
4.6.3	The Zisman Plot	117
4.6.4	Modern Application of Contact Angle Measurements	118
4.7	Modern Methods of Surface Analysis	119
4.7.1	Modern Methods for Analysis of the Chemistry of Surfaces	120
4.7.2	Topological Methods of Surface Analysis	122
4.8	Summary	124
	Bibliography	124
	References	125
	Problems and Review Questions	126
5	Basic Physico/Chemical Properties of Polymers	129
5.1	Introduction	129
5.2	Basic Terminology	130
5.2.1	Monomers versus Polymers	130

5.2.2	Basic Types of Polymeric Materials	130
5.2.3	Molecular Weight	132
5.3	Thermal Transitions of Polymers	134
5.3.1	Measurement of T_g	135
5.4	Dynamic Mechanical Measurements and Viscoelasticity	136
5.4.1	Methods of Measurement of Dynamic Mechanical Properties	136
5.4.2	Examples of Dynamic Mechanical Data for Polymers	139
5.5	Time-Temperature Superposition	142
5.6	Summary	144
	Bibliography	144
	References	144
6	The Relationship of Surface Science and Adhesion Science	145
6.1	Introduction	145
6.2	Rationalizations of Adhesion Phenomena	145
6.3	Electrostatic Theory of Adhesion	146
6.4	Diffusion Theory of Adhesion	149
6.4.1	Diffusive Adhesive Bonding and Block Copolymers at Interfaces	152
6.5	Mechanical Interlocking and Adhesion	155
6.5.1	Kinetics of Pore Penetration	158
6.6	Wettability and Adhesion	160
6.7	Acid-Base Interactions at Interfaces	163
6.8	Covalent Bonding at Interfaces	166
6.8.1	Coupling Agents	168
6.9	The Relationship of Fundamental Forces of Adhesion and Practical Adhesion	171
6.10	The Weak Boundary Layer	175
6.11	Summary	176
	Bibliography	177
	References	177
	Problems and Review Questions	179

7	The Surface Preparation of Adherends for Adhesive Bonding	181
7.1	Introduction	181
7.2	Plastic Surface Preparation	183
7.2.1	Corona Discharge Treatment	184
7.2.1.1	Corona Discharge Treatment of Polyethylene	185
7.2.1.2	Corona Discharge Treatment of Polypropylene	188
7.2.1.3	Corona Discharge Treatment of Poly(ethylene terephthalate)	189
7.2.1.4	Corona Discharge Treatment of Other Materials	191
7.2.2	Flame Treatment	192
7.2.3	Plasma Treatment	194
7.2.3.1	Plasma Treatment of PE	195
7.2.3.2	Plasma Treatment of Other Substrates	196
7.2.4	Other Physical Treatment Methods of Polymer Surfaces	197
7.2.4.1	Treatments Using Ultraviolet Radiation	197
7.2.4.2	Other Vacuum Methods of Surface Preparation	198
7.2.5	Wet Chemical Methods of Treatment of Polymer Surfaces	199
7.2.5.1	Single Surface Chemical Functionalization and Chromic Acid Treatment of PE	199
7.2.5.2	Wet Chemical Surface Treatment of Poly(tetrafluoroethylene)	200
7.2.6	Priming of Polymer Surfaces	201
7.2.6.1	Priming of Polyolefins for Cyanoacrylates	202
7.2.6.2	Chlorinated Polyolefins	202
7.2.7	Surface of Composite Materials	202
7.2.7.1	Mechanical Surface Treatment of Composites	203
7.2.7.2	Peel-Plies as a Method of Composite Surface Preparation	203
7.2.7.3	A Comparison of Treatment Methods for Graphite Epoxy Reinforced Composite	204
7.2.7.4	Summary	206
7.3	Metal Surface Preparation	206
7.3.1	Surface Preparation of Aluminum for Adhesive Bonding	207
7.3.1.1	The Forest Products Laboratory (FPL) Etch	207

7.4	Anodization Treatments for Adhesive Bonding of Aluminum	211
7.4.1	Mechanism of Anodization	213
7.4.2	Anodization Media	213
7.4.3	Phosphoric Acid Anodization in the Aerospace Industry	214
7.5	General Techniques for the Surface Preparation of Metals	215
7.5.1	Conversion Coatings	216
7.5.2	Abrasion	216
7.5.3	Electrochemical Methods for Treating Metals other than Aluminum	218
7.6	Summary	218
	Bibliography	219
	References	219
	Problems and Review Questions	222
8	The Chemistry and Physical Properties of Structural Adhesives	223
8.1	Introduction to Chapters 8–11 and 13	223
8.2	Introduction to Structural Adhesives	223
8.2.1	Physical Forms of Uncured Structural Adhesives	224
8.3	Chemistry of Base Resins Used in Structural Adhesives	226
8.3.1	Phenolics	226
8.3.2	Proteins	229
8.3.3	Epoxy Resins	230
8.3.3.1	Time-Temperature-Transformation Diagrams and the Cure of Epoxy Resins	234
8.3.4	Urethane Resins	236
8.3.5	Acrylics	238
8.3.6	High Temperature Performance Structural Adhesives	241
8.4	Formulation of Structural Adhesives for Optimum Performance	244
8.4.1	Formulation of Phenolic Resins	244
8.4.2	Epoxy Resins	247
8.4.3	Acrylics	254
8.4.4	High Temperature Performance Structural Adhesives	257
8.5	Summary	259

Bibliography	259
References	259
Problems and Review Questions	261
9 Durability of Structural Adhesive Bonds	263
9.1 Introduction	263
9.2 Methods of Examining Durability of Structural Adhesive Bonds	263
9.3 Mechanisms of Durability Failure of Adhesive Bonds	267
9.4 Methods Used to Predict Durability	273
9.5 Summary	274
References	275
10 The Chemistry and Physical Properties of Elastomer-Based Adhesives	277
10.1 Introduction	277
10.2 Pressure-Sensitive Adhesives	277
10.2.1 Chemistry of the Base Resins Used in PSAs	278
10.2.2 Chemistry of Tackifiers	281
10.2.2.1 Natural Product Based Tackifiers	281
10.2.2.2 Petroleum Based Tackifiers	282
10.2.2.3 Other Tackifiers	284
10.2.3 Testing of Pressure-Sensitive Adhesives	285
10.2.3.1 Measurements of Tack	285
10.2.3.2 Measurement of Peel	287
10.2.3.3 Measurement of Shear	289
10.2.4 Balance of Properties	290
10.2.5 PSA Performance Viewed as a Time Scale in Viscoelastic Response	291
10.2.6 PSA Viscoelasticity and Tack	291
10.2.7 PSA Peel and Viscoelasticity	295
10.2.8 Shear and Creep Behavior of PSAs	298
10.2.9 Summary	300
10.3 Rubber-Based, Contact Bond and Other Elastomeric Adhesives	300
10.3.1 Formulation of RBAs	301

10.3.2	Base Polymers	301
10.3.3	Tackifiers	303
10.3.4	Pigments and Fillers	304
10.3.5	Crosslinking/Vulcanization of RBAs	304
10.3.6	Solvents	306
10.3.7	Elastomeric Adhesives, Sealants and Release Coatings Based upon Silicone Chemistry	306
10.4	Summary	309
	Bibliography	310
	References	310
	Problems and Review Questions	311
11	Thermoplastic, Pseudothermoplastic, and Other Adhesives	313
11.1	Introduction	313
11.2	Hot Melt Adhesives	313
11.2.1	Introduction	313
11.2.2	Polymer Physical Properties and Hot Melt Adhesives	314
11.2.3	Formulation of Hot Melt Adhesives	317
11.2.4	Synthetically Designed Hot Melt Adhesives	321
11.2.5	Curing Hot Melts	325
11.3	Polyvinyl Acetate-Based Adhesives	326
11.4	Polyvinyl Acetal Adhesives	327
11.5	Thermoplastic or Pseudo-thermoplastic Adhesives Based upon Natural Products	328
11.5.1	Starches	328
11.5.2	Cellulosics	328
11.6	Summary	330
	Bibliography	330
	References	330
12	Adhesion in Biological Systems	331
12.1	Introduction	331
12.2	Adhesion in Microbiological Systems	331
12.3	Biofilm Formation	332

12.4	Growth Stages of Biofilms	333
12.4.1	Attachment to a Surface	333
12.4.2	Irreversible Attachment of Bacteria	333
12.4.3	Maturation Phase	334
12.4.4	Biofilm Dispersal	334
12.5	Maintenance or Elimination of Biofilms	335
12.6	Adhesion in the Cling Ability of the Tokay Gecko	336
12.6.1	Attempts to Artificially Produce the Gecko Features and Adhesive Ability	339
12.7	Summary	341
	References	341
13	The Basis for Adhesive Bond Design	343
13.1	Introduction	343
13.2	Chemistry and Mechanical Properties of Adhesives	343
13.3	Application Criteria	346
13.4	Interfaces and Surface Preparations	349
13.5	Miscellaneous Concerns	350
13.6	Basic Criteria for the Design of an Adhesive Bond	352
13.6.1	Hart-Smith Design Criteria for Double Lap Joints	353
13.7	Summary	357
	References	357
	Problems and Review Questions	358
	Answer Key	359
	Index	371