## CONTENTS

1. 2.	<ul> <li>INTRODUCTION</li> <li>1.1 Using the Handbook</li> <li>1.2 The Classification of Adhesives</li> <li>1.3 Background to the use of adhesive bonding</li> <li>1.4 Factors determining whether to bond with adhesives</li> <li>1.5 Advantages and disadvantages of adhesive bonding</li> <li>1.6 The bonding process</li> </ul> JOINT DESIGN 2.1 Types of Stresses 2.2 Types of Joints	1 1 3 4 5 6 7 7 8
	<ul><li>2.3 Selection of joint detail</li><li>2.4 Joint design criteria</li></ul>	8 18
3.	<ul> <li>ADHESIVE SELECTION</li> <li>3.1 Introduction</li> <li>3.2 Requirements of bonded assembly</li> <li>3.3 Materials to be bonded</li> <li>3.4 Compatibility of adherends and adhesives</li> <li>3.5 Bond stresses</li> <li>3.6 Processing requirements</li> <li>3.7 Service conditions</li> <li>3.8 Service life</li> <li>3.9 Assembly storage conditions</li> <li>3.10 Cost</li> <li>3.11 Special considerations</li> <li>3.12 Checklist of Factors for adhesive selection</li> </ul>	21 21 22 23 24 24 24 24 25 26 26 26 26 26 27
4.	<ul> <li>ADHESIVES MATERIALS AND PROPERTIES</li> <li>4.1 The components of an adhesive</li> <li>4.2 Adhesives types</li> <li>4.3 Properties of basic adhesive types</li> </ul>	28 28 29 31
5.	<ul> <li>ADHESIVE PRODUCTS DIRECTORY</li> <li>5.1 Introduction</li> <li>5.2 Adhesive products tables</li> </ul>	78 78 78
6.	SURFACE PREPARATION6.1Introduction6.2Safety precautions6.3Surface treatment6.4Metals6.5Plastics6.6Rubber (natural and synthetic)6.7Fibre products6.8Inorganic materials6.9Wood and allied materials6.10Painted surfaces	235 235 235 235 236 244 250 252 253 255 256
7.	THE BONDING PROCESS 7.1 Storage	258 258

	7.2	Preparation of the adhesive	258
	7.3	Methods of Application	258
	7.4	Methods of adhesive bonding	259
	7.5	Inadequate bonding	260
	7.6	Methods of bond curing	261
	7.7	Bonding pressure	263
	7.8	Equipment for processing adhesives	264
8.	PHYSICAL TESTING OF ADHESIVES		268
	8.1	Introduction	268
	8.2	Strength properties	268
	8.3	Assessment of durability and strength parameters	274
9.	ADHESIVES TABLES		284
	9.1	Introduction	284
	9.2	Physical properties of adhesive materials	284
10.	ADHESIVES AND TRADE SOURCES		318
	10.1	Trade names list	318
	10.2	Basic adhesives types and trade sources	330
	10.3	Adhesives manufacturers	332
	10.4	Sources of further information on adhesives	340
11.	GLOSS	ARY OF TERMS RELATING TO ADHESIVES TECHNOLOGY	343
12.	BIBLIOGRAPHY		