

**Structural adhesives - Characterization of a surface
by measuring adhesion by means of the three point
bending method**

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

<p>Käesolev Eesti standard EVS-EN 1966:2009 sisaldab Euroopa standardi EN 1966:2009 ingliskeelset teksti.</p> <p>Standard on kinnitatud Eesti Standardikeskuse 27.03.2009 käskkirjaga ja jõustub sellekohase teate avaldamisel EVS Teatajas.</p> <p>Euroopa standardimisorganisatsioonide poolt rahvuslikele liikmetele Euroopa standardi teksti kättesaadavaks tegemise kuupäev on 11.02.2009.</p> <p>Standard on kättesaadav Eesti standardiorganisatsioonist.</p>	<p>This Estonian standard EVS-EN 1966:2009 consists of the English text of the European standard EN 1966:2009.</p> <p>This standard is ratified with the order of Estonian Centre for Standardisation dated 27.03.2009 and is endorsed with the notification published in the official bulletin of the Estonian national standardisation organisation.</p> <p>Date of Availability of the European standard text 11.02.2009.</p> <p>The standard is available from Estonian standardisation organisation.</p>
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English Version

Structural adhesives - Characterization of a surface by
measuring adhesion by means of the three point bending
method

Adhésifs structuraux - Caractérisation d'une surface par
mesure de l'adhérence au moyen de la méthode de la
flexion en trois points

Strukturklebstoffe - Charakterisierung einer Oberfläche
durch Messung der Adhäsion nach dem Dreipunkt-
Biegeverfahren

This European Standard was approved by CEN on 27 December 2008.

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This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the CEN Management Centre has the same status as the official versions.

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Foreword

This document (EN 1966:2009) has been prepared by Technical Committee CEN/TC 193 “Adhesives”, the secretariat of which is held by AENOR.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by August 2009, and conflicting national standards shall be withdrawn at the latest by August 2009.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN [and/or CENELEC] shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN 1966:2002.

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1 Scope

This European Standard describes a test method to determine ability of a cured adhesive (possibly with a primer) to adhere to a substrate which has had a certain surface finish or with a specific surface preparation by using the "three point bending method".

It is only used for quality assurance and the substrate should be rigid or resistant enough to bending such as steel or aluminium alloys. For other substrates the thickness should be adjusted to the modulus of elasticity or a suitable stiffener should be used.

The adhesive should be polymerisable (curable) without pressure in order to obtain the thickness needed to provide sufficient rigidity, otherwise, a bonded reinforcing piece of the same type and same thickness as the substrate can be substituted for the bloc of adhesive.

It is not suitable for film adhesives.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 923:2005, *Adhesives — Terms and definitions*

EN 10025-2, *Hot rolled products of structural steels - Part 2: Technical delivery conditions for non-alloy structural steels*

EN 13887, *Structural adhesives — Guidelines for surface preparation of metals and plastics prior to adhesive bonding*

EN ISO 291, *Plastics — Standard atmospheres for conditioning and testing (ISO 291:2005)*

EN ISO 9142, *Adhesives — Guide to the selection of standard laboratory ageing conditions for testing bonded joints (ISO 9142:2003)*

EN ISO 10365, *Adhesives — Designation of main failure patterns (ISO 10365:1992)*

ISO 286-1, *ISO system of limits and fits — Part 1: Bases of tolerances, deviations and fits*