

**Lennunduse ja kosmonautika seeria.  
Konstruktsiooniliimid. Katsemeetodid. Osa 2: Metallil  
metallilt rebimise teim**

Aerospace series - Structural adhesives - Test methods -  
Part 2: Peel metal-metal

## EESTI STANDARDI EESSÕNA

## NATIONAL FOREWORD

Käesolev Eesti standard EVS-EN 2243-2:2000 sisaldab Euroopa standardi EN 2243-2:1991 ingliskeelset teksti.

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Standard on kättesaadav Eesti standardiorganisatsioonist.

This Estonian standard EVS-EN 2243-2:2000 consists of the English text of the European standard EN 2243-2:1991.

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EUROPEAN STANDARD

EN 2243

Part 2

NORME EUROPEENNE

EUROPAISCHE NORM

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English version

Aerospace series - Structural adhesives - Test methods - Part 2: Peel metal-metal

Série aérospatiale - Adhésifs structureaux - Méthodes d'essais - Partie 2: Essai de pelage métal-métal  
Luft- und Raumfahrt - Strukturelle Klebstoffe - Prüfverfahren - Teil 2: Rollen-Schälversuch Metall-Metall

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CEN

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Foreword

This European Standard has been prepared by the European Association of Aerospace Manufacturers (AECMA).

After inquiries and votes carried out in accordance with the rules of this Association, this Standard has successively received the approval of the National Associations and the Official Services of the member countries of AECMA, prior to its presentation to CEN.

According to the Common CEN/CENELEC Rules, the following countries are bound to implement this European Standard :

Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxemburg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom

## 1 Scope and field of application

This standard specifies the dimensions of the test samples and the test method for the determination of the strength of structural adhesives in metal to metal peel at ambient and other temperatures.

This test procedure is not suitable for adhesives having an average peeling strength of less than 30 N per 25 mm.

## 2 References

EN 2090 Aerospace series - Aluminium alloy 2024-T3 - Clad sheets and strips  $0,4 \leq a \leq 6$  mm 1)

EN 2334 Aerospace series - Acid chromate pickle for aluminium alloys 2).

## 3 Test samples

3.1 The shape and dimensions of the test pieces and the panel from which the test pieces are cut shall correspond to figure 1.

### 3.2 Materials

The test panel shall be made from the following material :

Aluminium alloy, see EN 2090.

## 4 Surface preparation

The surface preparation prior to bonding shall conform to EN 2334.

## 5 Bonding

The application of the adhesive system (adhesive and primer if applicable) and curing shall be carried out according to the instructions of the adhesive manufacturer or the material standard.

## 6 Storage of test samples after bonding

After curing, samples made with elevated temperature curing adhesives shall be exposed and/or tested after a storage period of 16 hours under the conditions as given below (unless otherwise specified by the adhesive manufacturer).

Samples with room temperature curing adhesives which are not exposed and/or tested immediately after curing, shall also be stored under the conditions as given below (unless otherwise specified by the adhesive manufacturer).

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1) Published as AECMA standard at the date of publication of the present standard.

2) In preparation at the date of publication of the present standard.