

Testing : **Climbing Drum Peel for Adhesives**
 Test Method : ASTM D1781 - 98 (Reapproved 2012)
 Project Number : P20200821
 Customer : Albond Aluminium Sanayi ve Ticaret A.S.
 Attention : Egemen Yörür
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Revised 5/27/2020
 Average Peel Torque in N-mm/mm added.
 Revised 6/1/2020
 Revised sample description.



Sample Description : Albond 9000 A2 Aluminum Composite Panel
 Adherend Thickness (mm) : 0.5
 Sample Dimensions (mm) : 356 x 76 x 4.3 (Nominal)
 Bonding Conditions : Not Supplied
 Sample Preparation : Tested as received
 Conditioning : 7 days at 23°C ± 2°C / 50% ± 10% RH
 Test Machine Type : Instron 5569
 Speed Of Testing : 25.4 mm/min
 Flange Radius (mm) : 63.68
 Drum Radius (mm) : 50.94
 Calibration Method : Adherend
 Torque Compensation (kg_f) : 15.5
 Preload (kg_f) : 19.5
 Test Conditions : 23°C ± 2°C / 50% ± 10% RH

Sample ID	Test Number	Average Peel Load (kgf)	Maximum Peel Load (kgf)	Minimum Peel Load (kgf)	Specimen Width (mm)	Average Peel Torque (mm-kg/mm of specimen width)	Average Peel Torque (N-mm/mm of specimen width)	Failure Type
Albond 9000 A2	1	85.7	93.7	72.0	75.6	11.6	114	3,4
	2	86.5	96.0	73.4	76.3	11.6	114	3,4
	3	75.9	83.3	65.0	75.9	9.9	97.5	3,4
	4	76.4	83.6	69.6	75.6	10.1	99.0	3,4
	5	81.2	88.5	75.3	75.6	10.9	107	3,4
	6	80.5	88.8	67.7	76.0	10.7	105	3,4
				Average		10.8	106	
				Std. Dev.		0.7	7	

Failure Types:
 1= Cohesive failure within the adhesive
 2= Adhesion to the facing
 3= Adhesion to the core
 4= Failure within the core