

Testing : **Climbing Drum Peel for Adhesives**  
 Test Method : ASTM D1781 - 98 (Reapproved 2012)  
 Project Number : P20200821  
 Customer : Albond Alüminyum Sanayi ve Ticaret A.S.  
 Attention : Egemen Yörür  
 Analyst : A. Galusha / K. Schuman  
 Date : June 5, 2020



Sample Description : Albond 9000 FR (B1) Aluminum Composite Panel  
 Adherend Thickness (mm) : 0.5 (254 mm x 51 mm x 7 mm (nominal) steel plate added for stiffening)  
 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<sub>f</sub>) : 16.3  
 Preload (kg<sub>f</sub>) : 20.3  
 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 width)	Average Peel Torque (N-mm/mm width)	Failure Type
<b>Albond 9000 FR (B1)</b>	1	248	276	212	76.1	38.0	373	4
	2	---	---	---	76.1	---	---	Peel Substrate
	3	233	241	209	76.1	35.6	349	4
	4	269	319	157	76.4	41.3	405	4
	5	---	---	---	76.2	---	---	Peel Substrate
	6	---	---	---	76.4	---	---	Peel Substrate
	7	246	274	179	75.7	37.9	372	4
Average						<b>38.2</b>	<b>375</b>	
Std. Dev.						2.3	23	

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

Note: Per ASTM D1718, no acceptable failure modes occurred.