Testing	: **Climbing Drum Peel for Adhesives**	
Test Method	: ASTM D1781 - 98 (Reapproved 2012)	Revised 5/27/2020
Project Number	: P20200821	Average Peel Torque in N-mm/mm added.
Customer	: Albond Aluminyum Sanayi ve Ticaret A.S.	
Attention	: Egemen Yörür	
Analyst	: A. Galusha / K. Schuman	
Date	: May 12, 2020	

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TESTING LABORATORY

Sample Description	: Sandwich, composite core
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

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