

# ISO 15509:2019 (E)

## Adhesives — Determination of the bond strength of engineering-plastic joints

---

### Contents

|       |  |
|-------|--|
|       | Foreword                                     |
|       | Introduction                                 |
| 1     | Scope  |
| 2     | Normative references                         |
| 3     | Terms and definitions                        |
| 4     | Principle                                    |
| 5     | Specimen                                     |
| 5.1   | Preparation                                  |
| 5.1.1 | General                                      |
| 5.1.2 | Mould  |
| 5.1.3 | Injection-moulding parameters                |
| 5.1.4 | Removal of the sprue                         |
| 5.1.5 | Geometry                                     |
| 5.2   | Surface preparation                          |
| 5.3   | Assembly of the specimen in the mounting jig |
| 5.4   | Application of the adhesive                  |
| 5.5   | Conditioning and testing atmosphere          |
| 6     | Apparatus                                    |
| 7     | Procedure                                    |
| 8     | Expression of results                        |
| 9     | Precision                                    |
| 10    | Test report                                  |

Page count: 8