DIN EN ISO 21368:2024-10 (E)

Adhesives - Guidelines for the fabrication of adhesively bonded structures and reporting procedures suitable for the risk evaluation of such structures (ISO 21368:2022)

Contents

Page

European foreword 5

Foreword 6

Introduction 7

1 Scope 9

2 Normative references 10

3 Termsanddefinitions 10

4 Core element 1: Classification of adhesively bonded joints according to safety requirements 17
4.1 General 17
4.2 Definition of safety classes 18
4.3 Documentation of the classification according to safety classes 19

5 Core element 2: Adhesive bonding personnel (ABP)-- Competences, knowledge and experiences 19
5.1 General 19
5.2 Adhesive bonding operators (ABO) 20
5.2.1 General 20
5.2.2 Functions 20
5.2.3 Duties 20
5.2.4 Competences, knowledge and experiences 20
5.3 Adhesive bonding coordinator (ABC) 21
5.3.1 General 21
5.3.2 Functions 21
5.3.3 Duties 21
5.3.4 Competences 23
5.3.5 Organizational integration of adhesive bonding coordination 23
5.4 Levels of competences, knowledge and experiences for adhesive bonding personnel (ABP) 24
5.4.1 General 24
5.4.2 Requirements for each level of competences, knowledge and experiences 24
5.5 Assignment of the three competence levels to the safety classes depending on the respective scope of work -- Correlation of the core elements 26
5.6 Comparability of competences, knowledge and experience 27
5.7 Monitoring, inspection and testing personnel 27

6 Coreelement3:Designandverificationofadhesivelybondedjoints 27
6.1 General 27
6.2 Assignment to safety classes 27
6.3 Requirements to be met by the adhesively bonded joints 28
6.4 Design of adhesively bonded joints 28
6.5 Adherends 28
6.6 Adhesive 28
6.7 Surface treatment 29
6.8 Factors affecting the adhesive bonding process 29
6.9 Verification 29
6.9.1 General 29
6.9.2 Method 1 -- Load in use < maximum load capacity 29

6.9.3 Method 2 -- Component testing 30
6.9.4 Method 3 -- Documented experience 30
6.9.5 Method 4 -- Combination of methods 1 to 3 30

7 Drafting contracts and subcontracting (outsourcing) 30
7.1 General 30
7.2 Subcontracting (Outsourcing) 31
7.2.1 General 31
7.2.2 Deciding on subcontracting 32
7.2.3 Details and documentation of procurement 32
7.2.4 Selection of external service provider (subcontractor/supplier) and contracting 32
7.2.5 Management of external service providers (subcontractors/suppliers) 33

8 Workmanship 33
8.1 General 33
8.2 General process requirements 33
8.2.1 Production planning 33
8.2.2 Process design 33
8.2.3 Planning the use of production aids and tools 34
8.2.4 Production documents 35
8.2.5 Process approval 35
8.2.6 Transport, storage and logistics for adhesives, auxiliary materials and adherends 35
8.2.7 Production environment 36
8.2.8 Materials 37
8.2.9 Preparation of work stations and acclimatization of materials 37
8.2.10 Health and safety and environmental protection 38
8.2.11 Checking for fitting accuracy concerning shape, position and dimension 38
8.2.12 Checks prior to start of production 38
8.2.13 Treatment of the adherend surfaces 39
8.2.14 Dosing, mixing and application 40
8.2.15 Inspection and testing during adhesive bonding and adhesive solidification 41
8.2.16 Joining the adherends 41
8.2.17 Fixing 42
8.2.18 Solidification of the adhesive 42
8.2.19 Inspection and testing of finished components 43
8.2.20 Packaging and transport of adhesively bonded components 43
8.3 Work instructions: minimum requirements 34
8.4 Process reliability 45
8.4.1 General 45
8.4.2 Quality planning 45
8.4.3 Control of planning and manufacturing documents 45
8.4.4 Process validation 45
8.4.5 Production-accompanying work samples as proof of application quality 446
8.4.6 Quality control of process reliability/traceability 47
8.4.7 Instruction of adhesive bonding personnel (ABP) 48
8.4.8 Post-adhesive bonding finishing 48
8.5 Rework 48
8.6 Quality assurance 48
8.6.1 General 48
8.6.2 Quality planning 48
8.6.3 Quality inspection 49
8.6.4 Action in the case of deviations 49
8.6.5 Monitoring of measuring and test equipment and of production aids and tools 50
8.6.6 Imperfections in adhesively bonded joints 50
8.6.7 Control of non-conforming products 51
8.6.8 Preventive and corrective action 51
9 Maintenance and repair 51
9.1 General 51
9.2 Planning of maintenance and repair 51
9.3 Maintenance and repair instructions 52
9.4 Performing maintenance work/execution rules 52

9.5 Documentation 53
9.6 Sub-contracting 53

Annex A (informative) Assistance for providing adhesive bonding technology competences 54

Annex B (informative) Requirements 71

Annex C (informative) Guideline for the implementation of the design of adhesively bonded jointsanditsverification 72

Annex D (informative) Criteria for choosing an adhesive bonding system 91

Annex E (informative) Description of non-destructive and destructive testing methods 94

Annex F (informative) Description of accelerating ageing tests 97

Annex G (informative) Examples of non-decorative and decorative imperfections of adhesive bonds 101

Annex H (informative)Exampleofajobhistorysheet 103

Annex I (informative) Notes on quality planning 104

Bibliography 106