DIN 6701-3:2015-12 (E)

Adhesive bonding of railway vehicles and parts - Part 3: Guideline for construction design and verification of bonds on railway vehicles

Contents

Page

Foreword 4

1 Scope 5

2 Normative references 5

3 Terms and definitions 7

4 Classification of bonds 7
4.1 General 7
4.2 Classification according to level of safety requirements 7

5 Requirements profile 8

6 Choice of bonding system 8

7 Preparation for bonding, design of assemblies, components and bonded joints 9

8 Verification 9
8.1 General 9
8.2 Documentation of verification 11
8.3 Determining loads 11
8.3.1 General 11
8.3.2 Design considerations 11
8.3.3 Finite element method 12
8.4 Determining the load limit 12
8.4.1 General 12
8.4.2 Adhesion 12
8.4.3 Bonding parameters 13
8.4.4 Component testing 14
8.4.5 Permissible stress and strain 14
8.5 Design of joint 15
8.6 Effects of manufacturing on permissible bonding parameters 15

9 Verification according to bond class 16

Annex A (normative) Determining the load limit 18

A.1 General 18
A.2 Characteristic values and the permissible load limit 18
A.3 Testing low-modulus (flexible) adhesives 20
A.3.1 General 20
A.3.2 Determining the modulus of elasticity, the Poisson's ratio and the stress/strain characteristic using adhesive test pieces 20
A.3.3 Testing the quasi-static bond strength for bonds formed with low-modulus adhesives 21
A.3.4 Testing the elongation at break after relaxation of bonds using low-modulus adhesives 21
A.3.5 Testing the elongation at break after relaxation of bonds using low-modulus adhesives 22
A.3.5 Testing the creep behaviour of bonds using low-modulus adhesives 22
A.3.6 Testing the fatigue strength of bonds using low-modulus adhesives 23
A.4 Testing high-modulus (very stiff) adhesives 23

A.4.1 Determining the modulus of elasticity, the Poisson's ratio and the stress/strain characteristic using adhesive test pieces 23
A.4.2 Testing lap shear strength 23
A.4.3 Testing the creep behaviour of bonds using high-modulus adhesives 23
A.4.4 Testing the fatigue strength of bonds using high-modulus adhesives 23
A.5 Other tests: Measurement of pH value of cured adhesives exposure to moisture 24

Annex B (informative) **List of requirements** 25

Annex C (informative) **Criteria for choosing a bonding system** 26

Annex D (informative) **Design documentation** 30

Annex E (informative) **Ageing tests** 34

Bibliography 36

Figures

Figure 1 — Verification flow chart 10

Figure A.1 — Type S2 test piece as in DIN 53504 (thickness *d*: 2 mm ± 0,5 mm) 20

Figure A.2 — Test piece for testing the strength of bonds using a low-modulus adhesive (example) 21

Figure A.3 — Test piece for compression test 22

Figure D.1 — Identification of adhesives and auxiliary materials (example) 31

Figure D.2 — Dimensioning of bonds (example) 32

Figure D.3 — Other lettering (example) 33

Tables

Table 1 — Classification of bonds 8

Table 2 — Measures to be taken and documentation in the verification for bond classes 16

Table A.1 — One-sided statistical tolerance interval (unknown variance), normal distribution (as in DIN ISO 16269-6:2009-10, Table D.4) 19

Table B.1 — Major items dealt with in a list of requirements (on the lines of [1]) 25

Table C.1 — Criteria for choosing a bonding system 26

Table E.1 — List of commonly used ageing tests 34