Off site bulk adhesive specimen preparation

Specimens required: 3 Dumbbells and 3 DMTA

Equipment required:
- Mould for casting specimens (Fig.1)
- Release agent
- Spatula / small trowel

Procedure for preparing bulk off-site QC test specimens:

1. Ensure all equipment is clean and free from contamination
2. Open mould and coat all surfaces that will have contact with the adhesive with release agent

WARNING – Take care to not spray release agent near to anything to be bonded
   - e.g. away from site and down wind
3. Mix the adhesive as recommended by the adhesive supplier
4. (DO NOT add any ballotini or bondline spacers to the adhesive)
5. Apply the adhesive liberally over the mould ensuring that each cavity has been slightly over-filled.
   - Take care to avoid air pockets as these will cause voids in the specimens, rendering them
     unsuitable for testing
6. Close the mould and tighten the bolts starting from the centre. Progressively tighten bolts, as
   shown in the Fig.2, to ensure the mould plates are kept parallel

Fig.1 Dumb bell and DMTA mould and specimens

Fig.2 Bolt-tightening sequence

7. Remove excess adhesive from edges of joint with a spatula.
8. Place mould next to the actual job and allow adhesive to cure on-site
9. Record date, time, temperature, humidity and adhesive batch numbers on the corresponding
   specimen information sheet.

IMPORTANT:

Spray release agent on bolts and in threads to aid in mould disassembly
Retighten bolts after 2 minutes, as they will loosen as excess adhesive is extruded from the mould

Note: This sheet is for guidance only.
Please also refer to adhesive manufacturer’s data and safety sheets.