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**Plastics — Evaluation of the adhesion  
interface performance in plastic-  
metal assemblies —**

**Part 2:  
Test specimens**

*Plastiques — Évaluation des performances de l'interface d'adhérence  
dans les assemblages plastique-métal —*

*Partie 2: Éprouvettes pour essai*



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# Contents

|                                                                                              | Page      |
|----------------------------------------------------------------------------------------------|-----------|
| <b>Foreword</b> .....                                                                        | <b>iv</b> |
| <b>Introduction</b> .....                                                                    | <b>v</b>  |
| <b>1 Scope</b> .....                                                                         | <b>1</b>  |
| <b>2 Normative references</b> .....                                                          | <b>1</b>  |
| <b>3 Preparation of test specimens</b> .....                                                 | <b>1</b>  |
| <b>4 Type of test specimens</b> .....                                                        | <b>2</b>  |
| 4.1 Butt welded test specimens (type A).....                                                 | 2         |
| 4.2 Overlapped test specimens (type B).....                                                  | 2         |
| 4.3 Test specimens for the peeling test (type C).....                                        | 2         |
| 4.4 Test specimens for sealing properties (type D).....                                      | 3         |
| <b>5 Report</b> .....                                                                        | <b>4</b>  |
| <b>Annex A (normative) Overlapped test specimens for sealing properties (type D.2)</b> ..... | <b>6</b>  |

## Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see [www.iso.org/directives](http://www.iso.org/directives)).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see [www.iso.org/patents](http://www.iso.org/patents)).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation on the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the WTO principles in the Technical Barriers to Trade (TBT) see the following URL: [Foreword - Supplementary information](#)

The committee responsible for this document is ISO/TC 61, *Plastics*, Subcommittee SC 11, *Products*.

ISO 19095 consists of the following parts, under the general title *Plastics — Evaluation of the adhesion interface performance in plastic-metal assemblies*:

- *Part 1: Guidelines for the approach*
- *Part 2: Test specimens*
- *Part 3: Test methods*
- *Part 4: Environmental conditions for durability*

## Introduction

Structures of heterogeneous materials are being manufactured in the automobiles and aerospace industry sectors where higher safety margins are required.

The existing test methods are not appropriate because the evaluation of the plastic-metal interface performance is difficult as the polymer material has a relatively low mechanical strength and therefore fractures outside the joints. Therefore, it is necessary to develop a methodology for the evaluation of the plastic-metal interface performance.

A test method to evaluate accurately the adhesion interface performance or standardization of long-term evaluation under harsh environments is also necessary.

The method in ISO 19095 is intended to ensure the integrity of the interface is realized through the interface and that traceability of the value improves the data comparison.

This part of ISO 19095 defines the appropriate form of test pieces when considering plastic-metal interfaces that cannot be evaluated by the existing ISO standards.

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# Plastics — Evaluation of the adhesion interface performance in plastic-metal assemblies —

## Part 2: Test specimens

**SAFETY STATEMENT** — Persons using this part of ISO 19095 should be familiar with normal laboratory practice, if applicable. This part of ISO 19095 does not purport to address all of the safety problems, if any, associated with its use. It is the responsibility of the user to establish appropriate safety and health practices and to ensure compliance with any regulatory conditions. It is recognized that some of the materials permitted in this part of ISO 19095 might have a negative environmental impact. As technological advances lead to more acceptable alternatives for such materials, they will be eliminated to the greatest extent possible. At the end of the test, care should be taken to dispose of all waste in an appropriate manner in accordance with local regulations.

### 1 Scope

This part of ISO 19095 specifies the test specimens for the evaluation of the adhesion interface performance in plastic-metal assemblies.

### 2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 293:2004, *Plastics — Compression moulding of test specimens of thermoplastic materials*

ISO 294-1:1996, *Plastics — Injection moulding of test specimens of thermoplastic materials — Part 1: General principles, and moulding of multipurpose and bar test specimens*

ISO 294-2:1996, *Plastics — Injection moulding of test specimens of thermoplastic materials — Part 2: Small tensile bars*

ISO 295:2004, *Plastics — Compression moulding of test specimens of thermosetting materials*

ISO 10724-1:1998, *Plastics — Injection moulding of test specimens of thermosetting powder moulding compounds (PMCs) — Part 1: General principles and moulding of multipurpose test specimens*

ISO 10724-2:1998, *Plastics — Injection moulding of test specimens of thermosetting powder moulding compounds (PMCs) — Part 2: Small plates*

ISO 17212, *Structural adhesives — Guidelines for the surface preparation of metals and plastics prior to adhesive bonding*

### 3 Preparation of test specimens

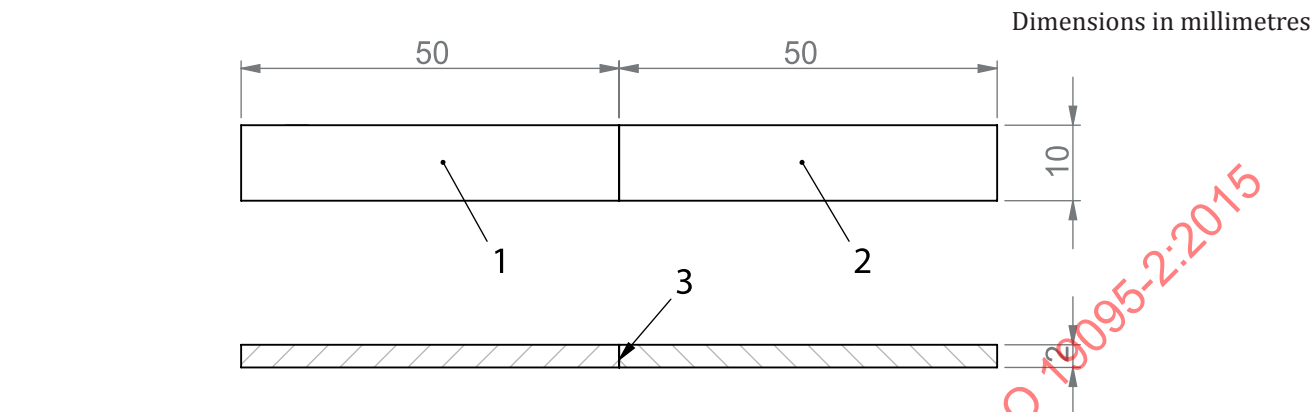
Surface preparation shall be carried out in accordance with the requirements of ISO 17212.

Otherwise, the method of carrying it out shall be recorded.

## 4 Type of test specimens

### 4.1 Butt welded test specimens (type A)

The shape and dimensions are shown in [Figure 1](#).



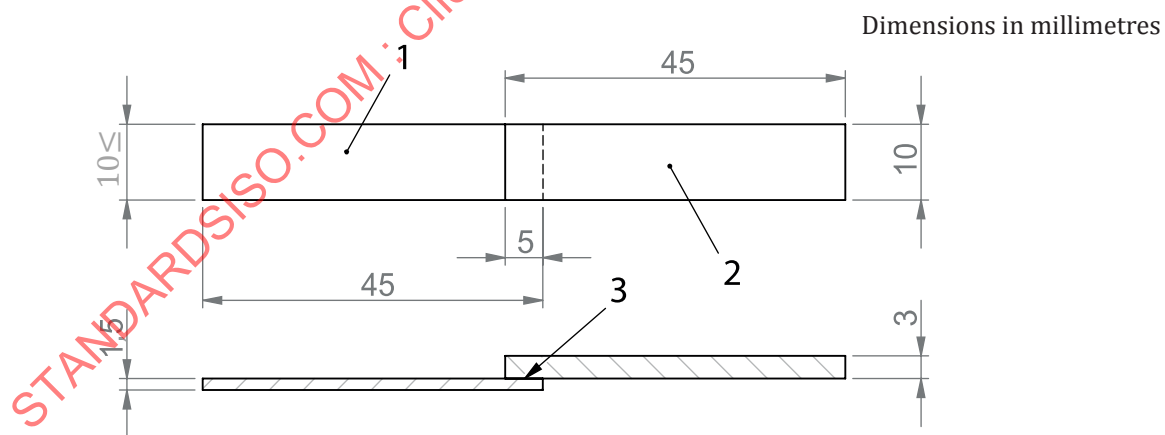
#### Key

- 1 metal specimen
- 2 plastic specimen
- 3 interface

Figure 1 — Shape and dimensions of type A (example)

### 4.2 Overlapped test specimens (type B)

The shape and dimensions are shown in [Figure 2](#).



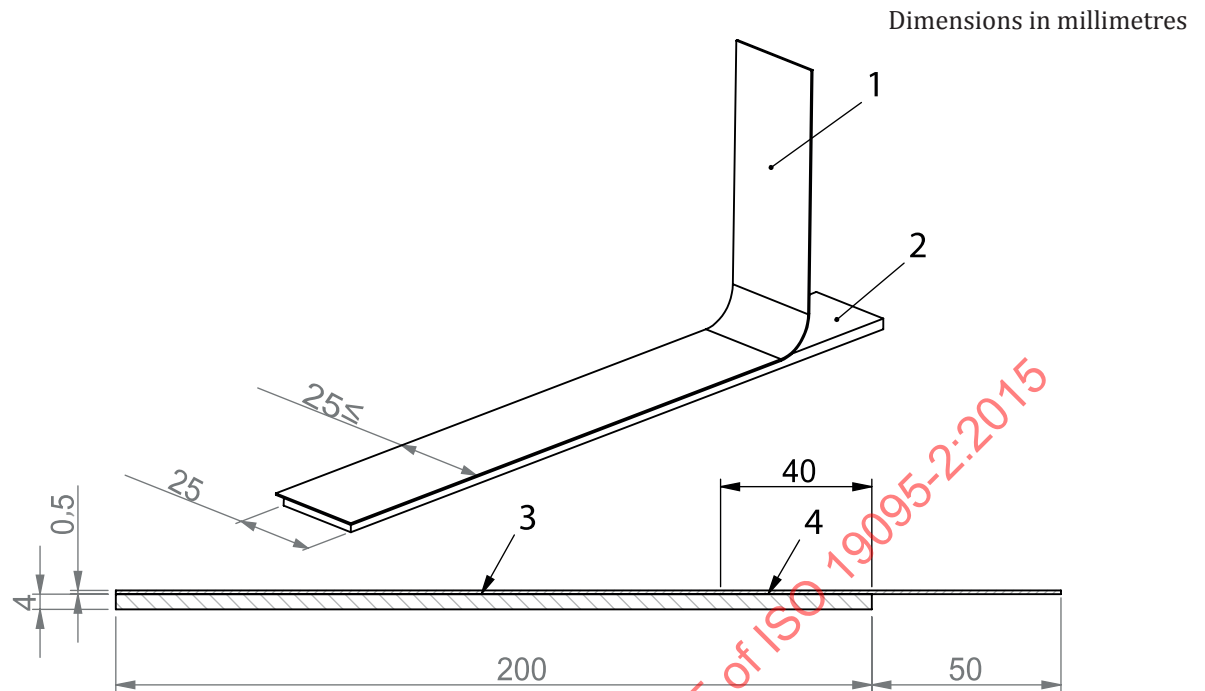
#### Key

- 1 metal specimen
- 2 plastic specimen
- 3 interface

Figure 2 — Shape and dimensions of type B (example)

### 4.3 Test specimens for the peeling test (type C)

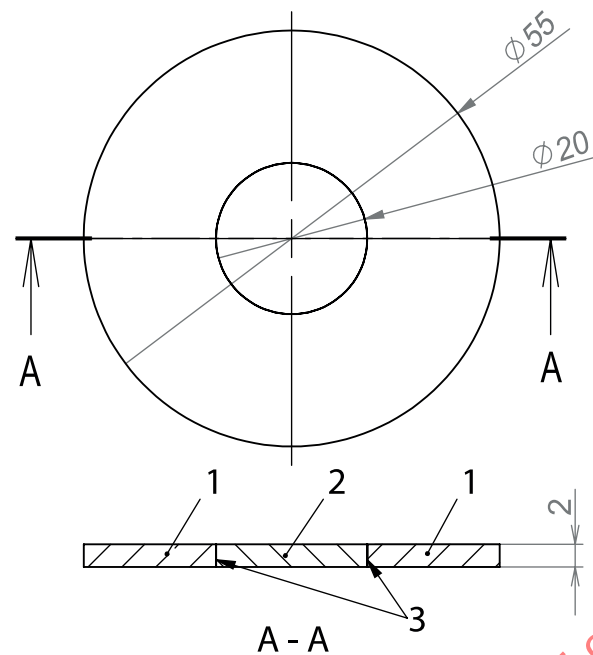
The shape and dimensions are shown in [Figure 3](#).



**Figure 3 — Shape and dimensions of type C (example)**

#### 4.4 Test specimens for sealing properties (type D)

The shape and dimensions are shown in [Figure 4](#).

**Key**

- 1 metal
- 2 plastic
- 3 interface

**Figure 4 — Shape and dimensions of type D (example)**

NOTE If type D specimen cannot be manufactured, the specimen shown in [Annex A](#) can be used alternatively.

**5 Report**

The test report shall include the following information:

- a) the number of this part of ISO 19095, i.e. ISO 19095-2;
- b) the types (shape and size) of specimens;
- c) the preparing condition and the testing condition of specimens;
- d) the method of preparing the specimens;
- e) surface treatment of metal piece;
- f) the number of tests;
- g) the average of measured characteristic values, as representative values of measured properties;
- h) the date of measurement;
- i) other instructions to be specified;
- j) see the following standards on a basis of moulding method:
  - for the compression moulded test specimens of thermoplastic materials, in accordance with ISO 293:2004, Clause 7 a) to i);

- for the injection moulded test specimens of thermoplastic materials, in accordance with ISO 294-1:1996, Clause 6 a) to h) and ISO 294-2:1996, Clause 6;
- for the compression moulded test specimens of thermosetting materials, in accordance with ISO 295:2004, Clause 10;
- for the compression moulded test specimens of thermosetting powders (PMC), in accordance with ISO 10724-1:1998, Clause 6 a) to h) and ISO 10724-2:1998, Clause 6 a) to h).
- k) the types, processing methods, and processing conditions of metal;
- l) the number of prepared test specimens;
- m) the preparation dates of test specimens.

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