

| thickness (mm) | material rivet diameter (mm) |
|----------------|------------------------------|
| 0.6 to 1.2     | 4                            |
| 1.2 to 2       | 6                            |
| 2 and more     | 8                            |

5- SOLUTIONS



If the material rivet is absent or too small:

- 
- Increase the weld current to improve its penetration,

If the current is already at maximum, increase the drilling diameter and the weld time.



Note:

A new peeling test must be performed if any settings or drilling parameters are modified.



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# CONNECTIONS BY BONDING: PRECAUTIONS FOR THE REPAIR

## 1. INTRODUCTION

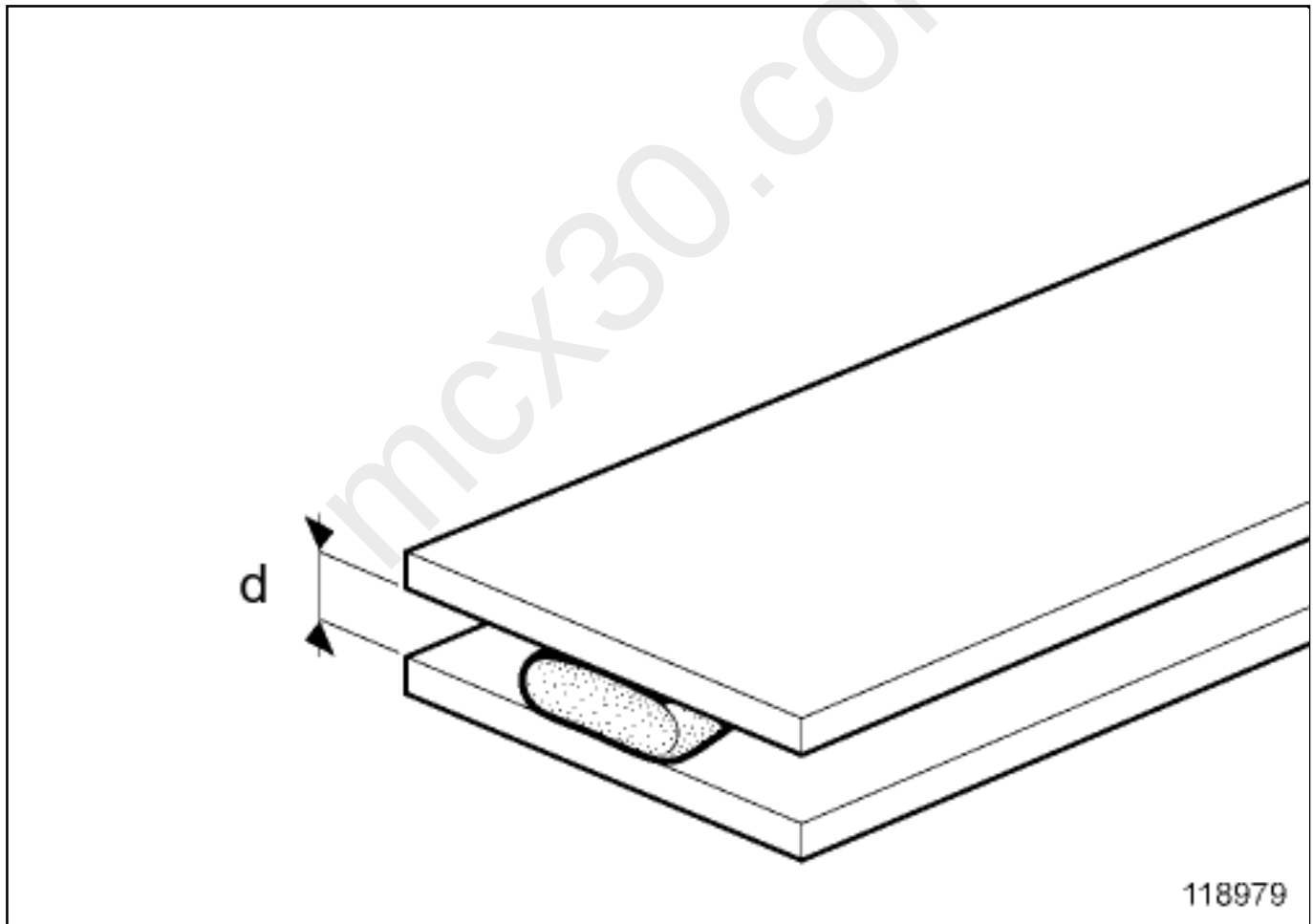
The purpose of this document is to provide the information necessary for making a high quality bonded joint.

The main requirement is good preparation of the surfaces to be bonded; the mating faces must be clean, and free from any contamination which could prevent the cement from holding (e.g.: grease or dust).

(see 40F, [Bonded connections, Connections by rigid bonding: Description](#))

## 2. PRELIMINARY TESTS AND OPERATIONS

### 1- VALIDATING THE BEAD DIAMETER



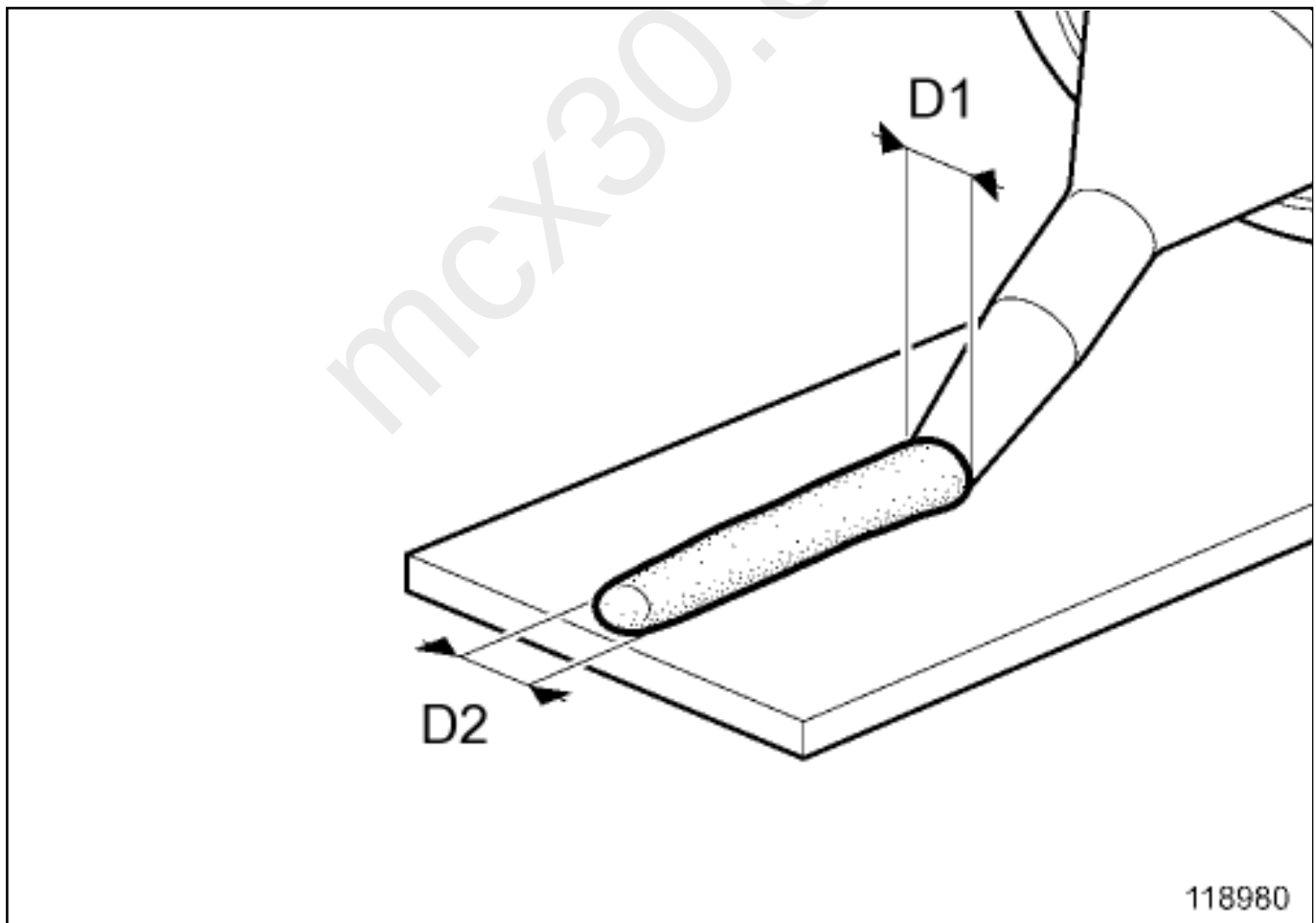
Depending on the gap between the parts to be assembled, adjust the diameter of the cement bead, cutting the end of the cartridge nozzle accordingly. To do this, after adjusting the part to be assembled, use a set of feeler gauges to measure the joint gap:

■ for rigid bonding,  $d$  should be between 0 and 2 mm,

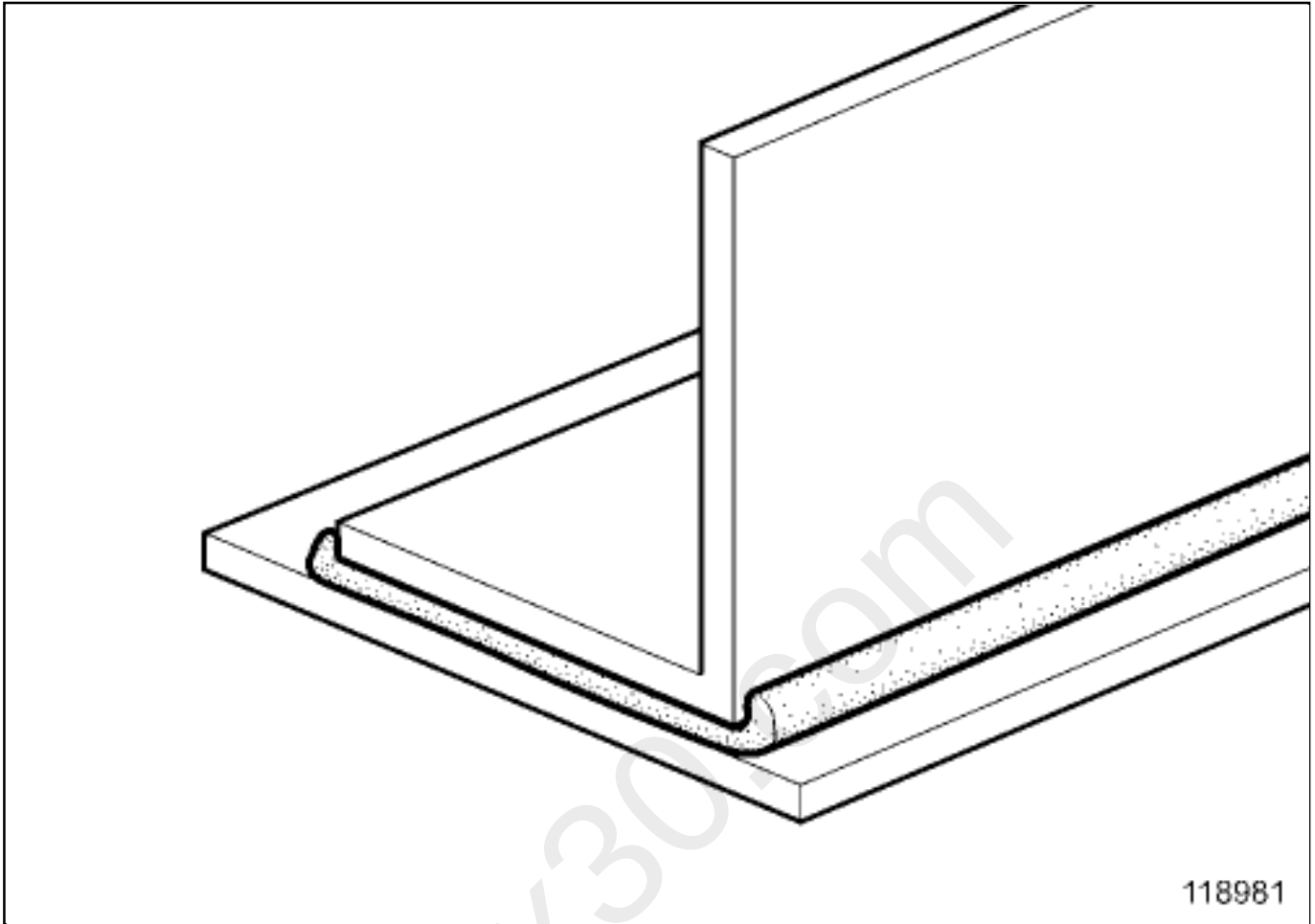
■ for elastic bonding,  $d$  should be between 2 and 4 mm.

Select the required diameter of the extruded bead according to the following table.

| Distance $d_{\text{measured}}$ between panels ( mm ) | Diameter $D_{2\text{extruded bead}}$ average ( mm ) |
|------------------------------------------------------|-----------------------------------------------------|
| Up to 2                                              | 4                                                   |
| 3                                                    | 6                                                   |
| 4                                                    | 8                                                   |



Cut the end of the nozzle to a diameter  $D1$ , 1 mm smaller than the required diameter of the bead  $D2$  after extrusion.



If the joint between the two parts to be bonded is limited to the width of the mating face, check that the cement overlaps the two sides of the bonding zone.

## 2- VALIDATING THE PRODUCT MIXTURE FOR DUAL COMPONENT BONDING CEMENT

When testing the bead diameter, check that the dual component mixture has a uniform colour.

### 1) REMINDER:

If the bonded joint is associated with a plug welded joint, the cement bead should be broken 1 cm either side of each weld point so that the cement does not alter the weld point.