

# C contents

1	Introduction .....	1
2	Types of Engineering and Structural Adhesives.....	5
2.1	Anaerobic Adhesives.....	6
2.2	Epoxy Adhesives.....	14
2.3	Reactive Acrylic Adhesives .....	23
2.4	UV Adhesives .....	30
2.4.1	Basic Chemistry of UV Systems .....	30
2.4.1.1	Free-Radical Systems .....	31
2.4.1.2	Cationic Systems .....	33
2.4.2	Benefits of UV Systems .....	35
2.4.3	Advances in UV Technology.....	35
2.4.4	Applications of UV Adhesives .....	36
2.5	Polyurethane Adhesives .....	38
2.5.1	Non-reactive Adhesives .....	41
2.5.2	Reactive Adhesives .....	42
2.6	RHMU .....	45
2.7	Cyanoacrylate Adhesives .....	47
2.7.1	Low-volatile Cyanoacrylates .....	52
2.7.2	Surface-insensitive Cyanoacrylates .....	52
2.7.3	Thermally Resistant Cyanoacrylates.....	52
2.7.4	Toughened Cyanoacrylates.....	53
2.7.5	Bonding of Non-polar Plastics.....	54

*Update on Engineering and Structural Adhesives*

2.7.6	Preventing Skin Bonding.....	54
2.7.7	Glass Bonding and Moisture Resistance ....	54
2.8	Comparison of Engineering and Structural Adhesives	55
3	Applications of Adhesives.....	63
3.1	Industrial Assembly .....	64
3.1.1	Appliances.....	64
3.1.2	Electrical and Electronic .....	66
3.1.3	Medical Devices .....	71
3.2	Transportation.....	75
3.2.1	OEM Automotive.....	77
3.2.1.1	Powertrain Applications .....	79
3.2.1.2	Body Applications.....	84
3.2.1.3	Electrical Applications.....	88
3.2.1.4	Trim Applications .....	88
3.2.2	Aerospace.....	91
3.2.3	Marine .....	94
4	Advances in Adhesive Technology .....	99
4.1	Bonding of Metals .....	99
4.1.1	Bonding of Aluminium .....	103
4.1.2	Bonding of Dissimilar Metals and Metals to other Substrates .....	104
4.2	Bonding of Plastics and Composites .....	105
4.2.1	General Plastic and Composite Bonding ..	105
4.2.2	Bonding of Specific Plastics.....	107
4.2.3	Bonding of Non-polar Plastics.....	109
4.2.3.1	Flame Treatment .....	109
4.2.3.2	Chemical-surface Treatment....	109
4.2.3.3	Plasma Treatment.....	110

4.2.3.4	Fluorination .....	111
4.2.3.5	Polymer Modification.....	111
4.2.3.6	Surface Primers .....	112
4.2.3.7	Organoboranes .....	114
4.3	Bonding of Glass and Ceramics .....	123
5	Durability of Adhesively Bonded Structures .....	137
5.1	Surface Treatments for Metals .....	140
5.2	Testing and Inspection of Adhesive Bonds .....	145
6	Application and Curing of Adhesives .....	155
7	Standards for Adhesives .....	161
7.1	ISO Standards.....	162
7.2	European Standards.....	164
7.3	ASTM Standards .....	166
8	Health and Safety Issues .....	169
9	Future Trends .....	171
	Abbreviations.....	173
	Index.....	175

*Update on Engineering and Structural Adhesives*