



Standard Test Method for Flexibility Determination of Hot-Melt Adhesives by Mandrel Bend Test Method¹

This standard is issued under the fixed designation D 3111; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope

1.1 This test method covers the determination of the flexibility of a hot-melt adhesive in sheet form under specific test conditions. This is a working test. Its results are useful for comparing adhesives, not for absolute characterization of adhesives.

1.2 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 ASTM Standards:

D 907 Terminology of Adhesives²

D 1737 Test Method for Elongation of Attached Organic Coatings with Cylindrical Mandrel Apparatus³

E 171 Specification for Standard Atmospheres for Conditioning and Testing Flexible Barrier Materials⁴

2.2 Other Method:

Federal Test Specification U.S. 141C, Peat, Varnish, Lacquer, and Related Materials: Methods of Inspection, Sampling and Testing⁵

NOTE 1—Although no tests related specifically to flexibility of unsupported hot-melt adhesives in sheet form, the above tests concerned with film flexibility of coatings (supported films) are similar.

3. Terminology

3.1 *Definitions*—Many terms in this test method are defined in Terminology D 907.

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *flexibility, n*—that property of a material by virtue of which it may be flexed or bowed repeatedly without undergoing rupture.

¹ This test method is under the jurisdiction of Committee D-14 on Adhesives and is the direct responsibility of Subcommittee D14.50 on Hot Melt and Pressure Sensitive Adhesives.

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² *Annual Book of ASTM Standards*, Vol 15.06.

³ Discontinued—see 1988 *Annual Book of ASTM Standards*, Vol 06.01. Replaced by Test Method D 522.

⁴ *Annual Book of ASTM Standards*, Vol 15.09.

⁵ Available from Standardization Documents Order Desk, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094, Attn: NPODS.

3.2.2 *hot-melt adhesive*—an adhesive that is applied in a molten state and forms a bond on cooling to a solid state.

4. Summary of Test Method

4.1 Test strips of a hot-melt adhesive properly sized and conditioned, are bent 180° over a mandrel (rod). Using a fresh specimen for each test, the test is repeated with smaller diameter mandrels until the adhesive fails on bending. The flexibility of the adhesive is the smallest diameter mandrel over which four out of five test specimens do not break.

5. Significance and Use

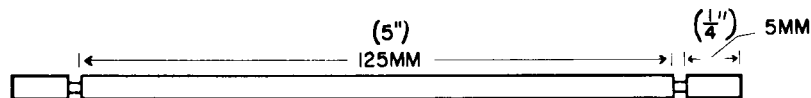
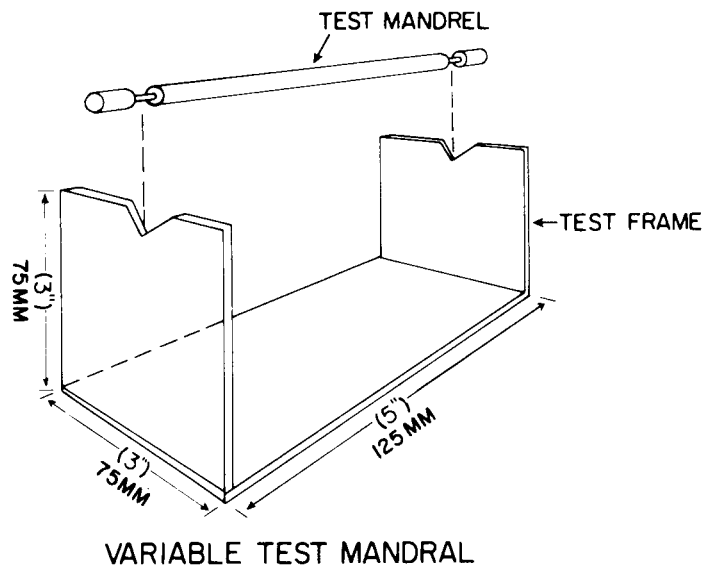
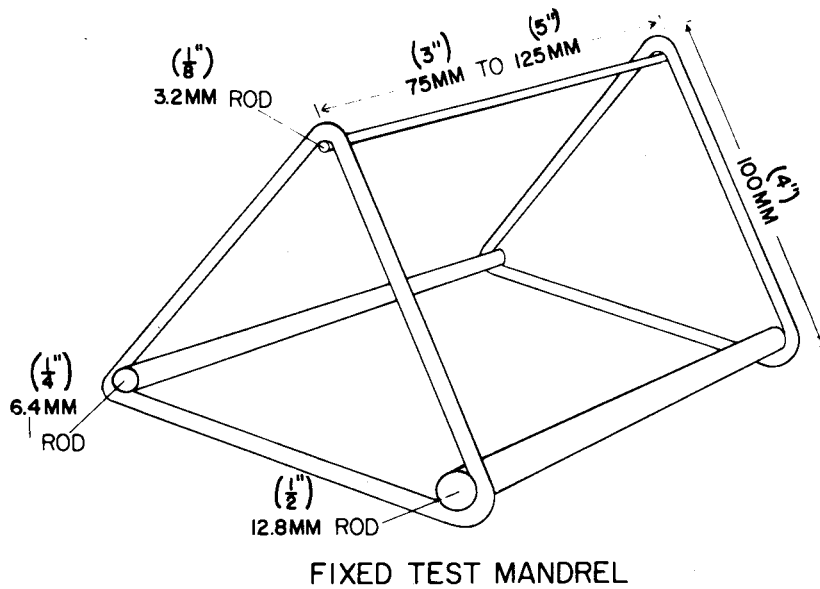
5.1 The “Mandrel Bend” test is simple and fast. It requires little investment in equipment and little operator training. The prime purpose is to determine whether a hot-melt adhesive meets flexibility requirements. This test is also useful for comparing flexibility of several adhesives. It can be used to design adhesives by comparing the flexibility of various formulations to meet specific end use parameters. The adhesive flexibility can be determined at temperatures other than ambient by conditioning the test apparatus and test specimens at the desired temperature and performing the test under these temperature conditions.

6. Apparatus

6.1 The test apparatus consists of a series of different diameter cylindrical rods or mandrels supported at each end. There shall be enough space to permit placement of the flat side of a test specimen tangentially at right angles to the longitudinal axis of the test mandrel. Individual requirements determine the diameter and lengths of the rods needed. For most tests, 3.2 mm ($\sim 1/8$ in.), 6.4 mm ($\sim 1/4$ in.), and 12.8 mm ($\sim 1/2$ in.) diameter by 75 to 150-mm (~ 3 to 6-in.) long rods made of brass or stainless steel are satisfactory. Fig. 1 describes two simple test frames, one with fixed mandrels and the other designed to take any diameter mandrel.

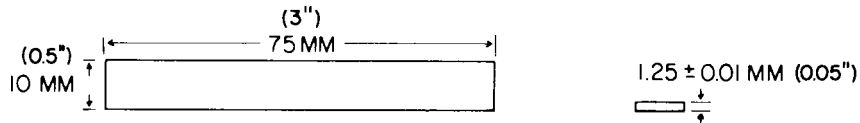
7. Test Specimen

7.1 The test specimen dimensions can be varied depending on the end use requirements of the hot-melt adhesive. Fig. 2 describes a recommended specimen size. It is 10 mm (~ 0.4 in.) wide, 75 mm (~ 3 in.) long and 1.25 ± 0.01 mm (~ 0.05 in.) thick. The thickness dimension is critical and must be accurately measured. The test specimens shall be cut from



NOTE 1—(Recess to fit test frame) Figures in parentheses are approximate.

FIG. 1 Test Mandrel (Various Diameters) for Test Frame



molded or extruded sheets or film. Plying of several thinner samples shall not be permitted. No flaws visible anywhere in the sample to the naked eye shall be permitted.

8. Conditioning

8.1 Store the test specimens and test apparatus at the test conditions for 24 h. Perform the test under these same

conditions. For rapid screening, particularly at low temperatures, a minimum of 4 h conditioning can be used. Note this change when recording data. If other conditions are not specified, the storage and test conditions will be $23 \pm 2^\circ\text{C}$ and $50 \pm 5\%$ relative humidity. Specification E 171, details these and other tests conditions.

9. Failure

9.1 Failure is a visible fracture, crazing, or cracking of the hot-melt adhesive. This can occur at any time during the bending of the adhesive test specimen over the mandrel. Color changes or blushing not affecting the tensile properties of the material is not a failure, but should be reported.

10. Procedure

10.1 Run the tests in the same environment used to condition the test specimens and test apparatus.

10.2 Put the largest diameter mandrel in the horizontal operating position in the test frame.

10.3 Grasp the test specimen between the thumb and forefinger of one hand with the longest dimension between the fingers. For low temperature testing, use ordinary cotton work gloves to insulate the test specimens from the warm fingers.

10.4 Lay the flat-side of the test specimen tangentially at right angles to the longitudinal axis of the test mandrel.

10.5 Within 1 s, fold the test specimen 180° to form an inverted “U” shaped angle over the mandrel maintaining intimate contact with the mandrel.

10.6 If no failure occurs, fold a fresh specimen over the next smaller diameter mandrel. Repeat the test using a fresh sample each time until failure occurs.

10.7 Now repeat the test five times using five fresh test specimens on the smallest diameter mandrel at which failure had not occurred. To be significant, at least four out of five test

specimens must pass. Follow this procedure with smaller or larger diameter mandrels until four out of five test specimens pass.

10.8 Record the flexibility of the hot-melt adhesive as the smallest diameter mandrel over which four out of five test specimens passed.

11. Report

11.1 Report the following information:

11.1.1 Method of specimen preparation, molded, extruded, or other method.

11.1.2 Specimen dimensions, especially thickness to within 0.01 mm ($\frac{1}{2}$ in.).

11.1.3 Conditioning and test conditions, temperature and, if important, relative humidity.

11.1.4 Smallest diameter mandrel over which four out of five specimens did not fail.

11.1.5 Color changes or blushing of nonfailing test specimens after bending.

12. Precision and Bias

12.1 No information about either the precision or bias of Test Method D 3111 for measuring flexibility of hot-melt adhesives is available since the test result is non-quantitative.

13. Keywords

13.1 flexibility; hot melt; mandrel

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