



Designation: D 2093 – 9703

Standard Practice for Preparation of Surfaces of Plastics Prior to Adhesive Bonding¹

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1. Scope

1.1 This practice describes surface preparations for plastic adherends, to be used prior to adhesive bonding of test specimens. It should be noted, however, that this practice specifies only the pretreating conditions of the plastic and does not cover the preparation of test specimens, testing conditions, or evaluation of tests. These are covered in the various ASTM test methods or specifications for specific materials.

1.2 *Physical Treatments* (for example, sanding and solvent wiping) are used in order to remove the glossy finish and all traces of dirt, grease, mold release, or other contaminants from the bonding surfaces.

1.3 *Chemical Treatments* (for example, sulfuric acid—dichromate solution and sodium naphthalene complex) are used in some cases to alter chemically the surface layers of the polymer itself to improve its adhesion characteristics.

1.4 The values stated in SI units are to be regarded as the standard. The values given in parentheses are for information only.

1.5 *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.* Specific precautionary statements are given in 6.1.

2. Referenced Documents

2.1 ASTM Standards:

¹ This practice is under the jurisdiction of ASTM Committee D-14 on Adhesives and is the direct responsibility of Subcommittee D14.40 on Adhesives for Plastics .
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