



Designation: D4501 – 01 (Reapproved 2023)

Standard Test Method for Shear Strength of Adhesive Bonds Between Rigid Substrates by the Block-Shear Method¹

This standard is issued under the fixed designation D4501; 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 describes a procedure and fixture used to determine shear strengths of adhesives used to bond materials with moduli higher than the modulus of the adhesive. The size and shape of the specimens are variable within the physical restraints of the fixture.

1.2 The values stated in SI units are to be regarded as the standard.

1.3 *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, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

1.4 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 *ASTM Standards:*²

D907 Terminology of Adhesives

E4 Practices for Force Calibration and Verification of Testing Machines

2.2 *ASTM Adjuncts:*

Shearing Fixture Drawings³

3. Terminology

3.1 Many terms used in this test method are defined in Terminology D907.

¹ This test method is under the jurisdiction of ASTM Committee D14 on Adhesives and is the direct responsibility of Subcommittee D14.40 on Adhesives for Plastics.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

³ Detailed drawings of the fixture are available from ASTM International Headquarters. Order Adjunct No. [ADJD4501](#). Original adjunct produced in 1985.

4. Summary of Test Method

4.1 In this test method, blocks, plates, or disks are bonded together, and the maximum force to shear them apart is determined.

5. Significance and Use

5.1 This test method provides an estimate of the shear strength of an adhesive on various machinable and nonmachinable substrate materials. It is particularly applicable for testing bonds between ceramic, glass, magnet moldings, and plastic parts with one flat face where machining would be difficult or impractical.

6. Apparatus

6.1 *Testing Machine*, conforming to the requirements of Practices E4, with a capacity of not less than 44 kN (10 000 lbf) in tension.

6.2 *Shearing Fixture*—Perform the tests by using a shearing fixture consisting of a holding block and a shearing tool (Figs. 1 and 2). The holding block can accommodate specimens up to 80 mm by 80 mm by 13 mm (3 in. by 3 in. by ½ in.). For small specimens as shown in Fig. 3B, an adapter plate (Fig. 4) can be inserted into the holding block to keep the shearing blade within its guides and to locate the specimen under the clamp. The shearing blade can accommodate specimens up to 30 mm by 30 mm by 13 mm (1½ in. by 1½ in. by ½ in.).³

7. Test Specimens

7.1 Test specimens can be any size within the limits of the shearing fixture capacity, as given in 6.2. Suggested sizes are as follows:

7.1.1 *Metal Blocks*—25 mm by 25 mm by 6 mm (1 in. by 1 in. by ¼ in.).

7.1.2 *Ferrite or Ceramic Blocks*—25 mm by 18 mm by 13 mm (1 in. by ¾ in. by ½ in.).

7.1.3 *Wood or Plastic Blocks*—25 mm by 25 mm by 13 mm (1 in. by 1 in. by ½ in.).

7.1.4 *Glass Plates*—75 mm by 75 mm by 13 mm (3 in. by 3 in. by ½ in.).

7.2 Prepare the adhesive and apply in accordance with the recommendations of the adhesive manufacturer. Assemble the