



The field adhesion test is a simple screening procedure that may help detect application problems such as improper cleaning, use of improper primer, poor primer application or improper joint configuration. As a check for adhesion, a simple hand pull test is required at the job site after the sealant is fully cured (usually within 7 to 21 days.) Field adhesion testing should be documented using the Field Adhesion Testing Log. It is recommended that 10 tests for the first 300 meters (1000 feet) and one test per 300 meters (1000 ft) thereafter be submitted or one test per floor per elevation. The hand pull test procedure is as follows:

- a. Make a knife cut horizontally from one side of the joint to the other.
- b. Make two vertical cuts (from the horizontal cut) approximately 75 mm (3") long, at both sides of the joint.
- c. Place a 25 mm (1") mark on the sealant tab as shown in the illustration.
- d. Grasp 50 mm (2") piece of sealant firmly just beyond the 25 mm (1") mark and pull at a 90° angle.
- e. If dissimilar substrates are being sealed, check the adhesion of sealant to each substrate separately. This is accomplished by extending the vertical cut along one side of the joint, checking adhesion to the opposite side, and then repeating for the other surface.
- f. Pass/fail criteria for each **M-1** structural adhesive sealant bond is cohesive failure with no adhesion loss. If the **M-1** structural adhesive sealant does not pass according to the guidelines provided, consult Chem Link technical Services.
- g. Inspect the joint for complete fill. The joint should not have voids, and joint dimensions should match those shown in the weathersealing details.

NOTE: When a sealant is used to weatherseal between two dissimilar substrates, it is recommended that the sealant adhesion to each side of the joint be individually tested. (See step e.)

### Field Adhesion Test – Weatherseal Joint

