

**CON-SERV INC
STANDARD OPERATING PROCEDURE**

S.O.P. No 1010

EFFECTIVE DATE: January 1, 1979

DESCRIPTION:

Q.C. APPRVD.: *R.E.*

Peel Test on bonded TFE sheet to steel. (This test will be performed at the beginning of a job lot or if the adhesive lot changes).

SHT. 1 OF 1

REVISED DATE: October 28, 1996

STEP	PROCEDURE	COMMENTS
1.	Clamp the bonded piece and/or sample in a vice.	
2.	Cut with a Stanley knife a 1" wide strip. Cut through the TFE until the knife hits the steel back-up.	
3.	With a small chisel, start the edge to peel at 90° to the back-up plate.	
4.	Peel with pliers about 1" of material until a hole can be put in the material and the spring load indicator placed in the hole.	
5.	Pull slowly reading the minimum load to peel the TFE.	
6.	Record this load.	
7.	Note if the etch was left on the TFE sheet.	Ideally the etch should be stripped away from the TFE by the strength of the bond to the steel surface.

RECEIVED
 OK'D BY _____
 DEC 15 2006
 RESUBMIT APPROVED ✓
 BY _____ DATE 01-05-07

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