

This supplement includes the procedure for the fabrication of Test Piece II.2 in the DVS® 2220 guideline.

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1 Scarfed joint

In compliance with Table 1 in the DVS® 2220 guideline, the two halves of the plate are scarfed from one side in each case by means of grinding. The scarfing dimension is 120 mm per half of the plate. This entails a scarfing dimension of 20 mm per scrim layer. The scarfing must not contain any graduations and should run uniformly over the entire scarfing region. The execution is carried out by hand with mechanical support. After the grinding, the grinding dust must be removed from the surface in the dry condition.

2 Fibre cut

The fibre cut is carried out in conformity with the stipulated scarfing dimension. Table 1 includes the required cut dimensions of the individual scrim layers.

Table 1. Cutting of the glass fibre scrim.

Fibre layer	Dimensions of cut, width x length in mm
1	40 x 400
2	80 x 400
3	120 x 400
4	160 x 400
5	200 x 400
6	240 x 400

3 Lamination

During the lamination operation, both the scarfed halves of the plate are joined with each other by building up a new laminate, beginning with Fibre Layer 1 in the centre of the pushed together halves of the plate. The laminate is then built up step by step until the last layer.

Upon completion of the building-up of a new laminate, it is necessary to follow the tempering instructions stipulated by the resin manufacturer and to carry them out correspondingly. The projection of the fibre material at the surface of the newly built-up laminate must be ground off flat after the tempering.

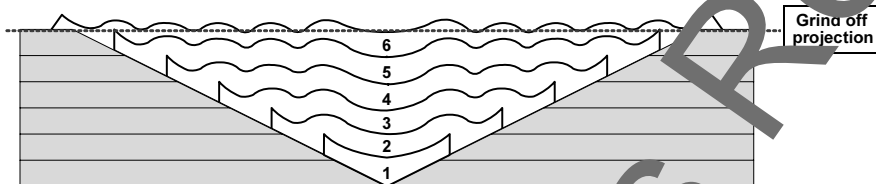


Figure 1. Building up a new laminate layer by layer.

This publication was drawn up by a group of experienced experts in cooperative work on an honorary basis and was approved by the "Training and Qualification Testing" working group. It is binding for DVS educational facilities. The user must always check whether the version in his possession is still valid.

DVS, Technical Committee, Working Group "Joining of Plastics"
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4 Taking the test specimens

The test specimens for determining the bending properties according to DIN EN ISO 14125 are taken in conformity with those positions in the newly built-up laminate stipulated on Fig. 2. In this respect, at least one specimen should be taken from each quadrant of the plate. The reference specimen needed for the comparison is taken from the unscarfed region of the plate.

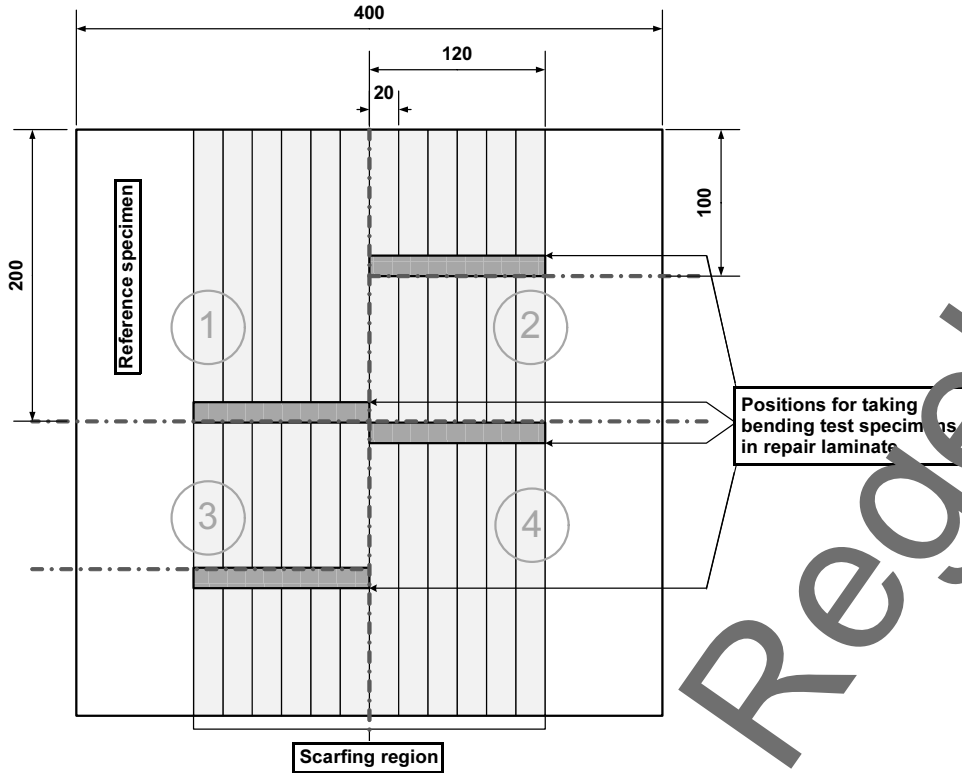


Figure 2. Positions for taking the test specimens.