

ZINC PRIMER WASH-OFF TEST**Application**

This procedure is used to determine the adhesion characteristics of zinc rich weld primer when subjected to hot caustic cleaning and phosphatizing solutions.

Apparatus Required**Two Six-Liter Beakers****Hot Plate or Beaker Heaters with Thermostatic Controls****Test Panels**

Which have previously been prepared per FLTM BI 103-04, Part C.

Chemicals Required

M 5B192-A (F) Alkaline Cleaner

M 5B193-A (F) Synthetic Detergent

M 3B34-A Zinc Phosphating Compound

M 13844 Sodium Nitride

M 3B 32-A & B Chromate Rinse

Conditioning and Test Conditions

All test values indicated herein are based on material conditioned in a controlled atmosphere of 23 +/- 2 °C and 50 +/- 5 % relative humidity for not less than 24 h prior to testing and tested under the same conditions unless otherwise specified.

Date	Action	Revisions
2001 03 02	Revised	Editorial – no technical change A. Cockman
1992 06 08		

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Procedure

1. Prepare solutions to the following concentrations:
 - (a) To four liters tap water, add 28 g of M 5B192-A (F) alkaline cleaner and 4.8 g M 5B193-A (F) synthetic detergent.
 - (b) To four liters tap water, add 30 mL of M 3B34-A and 1.75 g of M 13844.
 - (c) To four liters tap water, add 5.0 mL M 3B32-A and 2.0 mL of M 3B32-B.
2. Suspend panel being tested in the cleaning solution "A" and gently agitate for one minute. Temperature of the solution to be 71 - 77 °C.
3. Rinse in tap water 63 - 69 °C for one minute.
4. Immerse panel in solution "B" and agitate gently for one minute. Temperature of the solution to be 57 - 63 °C.
5. Rinse panel in tap water for 30 seconds at 32 - 49 °C.
6. Immerse panel in solution "C" and agitate gently for 30 seconds. Temperature of the solution to be 49 +/- 3 °C.
7. Dry panel in oven at 121 °C for 6 minutes.
8. Examine and report any loss of adhesion per the Engineering specification.

Chemicals, materials, parts, and equipment referenced in this document must be used and handled properly. Each party is responsible for determining proper use and handling in its facilities.