Ford Motor Company

FORD LABORATORY TEST METHOD BI 009-05

BEND TEST FOR COATING ADHESION

Application

This is a test for coating adhesion using a precoated steel panel and bending on a bending die.

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.

Procedure

1. Select a precoated specimen and shear to 95 x 300 mm. The length must be parallel to the rolling direction.

2. Place the panel coated side up, over a steel bending die which must be three times the thickness of the panel. The radius must be 1/2 its thickness.

3. Bend the panel transversely and at midpoint of the length (See Figures 1 and 2).

4. Bend to 180°, applying the bending load smoothly without shock.

5. When the bending is completed, examine the convex surface for any flaking of the coating. Disregard 1/4 inch from each edge.

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.

Date	Action	Revisions
2001 03 13	Revised	Editorial – no technical change A. Cockman
1992 06 17		

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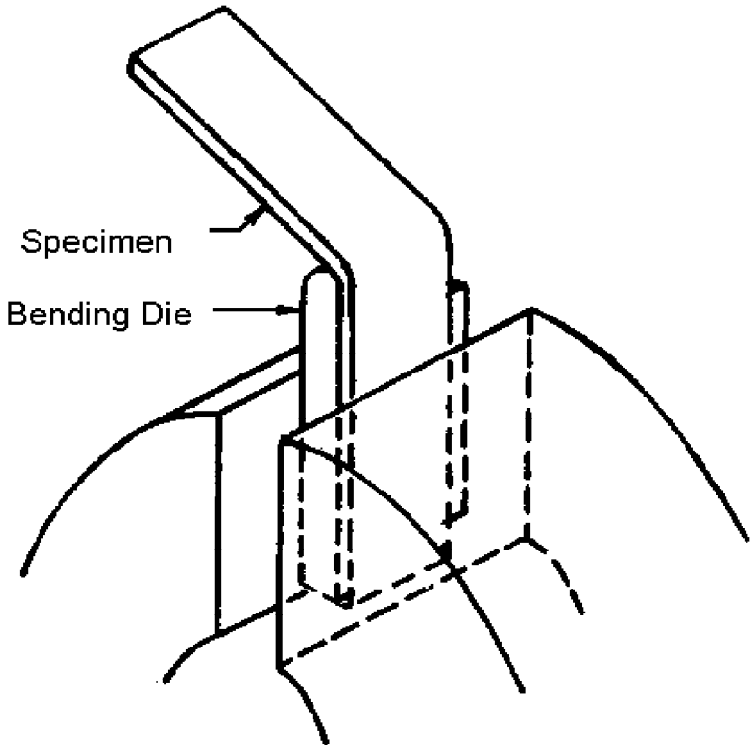

Semi-Guided Bend Test

Figure 1

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