

INTERCOAT PAINT ADHESION TEST

Application

This method is used to test the intercoat adhesion between two coats of enamels.

Apparatus and Materials Required

Test Panels

Panels prepared according to FLTM BI 103-02.

Tape - 3M No. 898

Scriber

Carbide tipped (preferred), or a hardened sharp steel needle.

Source: Model No. 90 C
 Aircraft Specialties
 Lapeer, MI 48446 U.S.A.

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. Prepare one panel with the material under test, as described in FLTM BI 103-02, Method B or C.
2. Immediately after the panel has been cooled to 23 +/- 2 °C, rebake according to the relevant Engineering Materials Specification. Care must be taken to avoid touching the panel test surface with the hands. Do not wipe.
3. Respray the panel with the enamel under test to 30 - 50 micron film thickness. Flash-off for three minutes, then normal bake as specified by the relevant Engineering Materials Specification.

Date	Action	Revisions
2001 03 14	Revised	Editorial – no technical change A. Cockman
1990 11 27		

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Page 1 of 2

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4. When the enamel under test is used in a two-tone system, either over or under, then it must be checked with all the other enamels with which it may be used in production.

Evaluation

Age test panel according to the relevant Engineering Materials Specification and check adhesion as follows:

1. Scribe a line for approximately 100 mm across the panel and through the topcoat.
2. Remove all loose debris (brush off) from scribed line.
3. Apply tape over the scribed line in a parallel direction using firm finger pressure to ensure contact with the panel surface (i.e. scribe line to be visible).
4. Remove the tape by pulling back rapidly at 90° to the panel.
5. Observe and report any occurrence of poor adhesion between coats of enamel, i.e. flaking and chipping of the top enamel coat.

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.