

ADHESION TEST FOR ZINCROMETAL

Application

This is a test for adhesion of coated steel by use of a ductility cup tester.

Materials and Application

Equipment

Test Machine

Tinius Olsen Ductomatic or equivalent.
Model BP-612A or BP-612

Source: Tinius Olsen Testing Machine Company
Easton Road
Willow Grove, Pennsylvania 19090

Accessories

Top Die

33.34 mm inside diameter. Place in breach.

Bottom Die

13.34 mm inside diameter. Place on lower ram.

Tape

3M type 898, 25 mm wide

Forming Tool

20 mm diameter ball ram 6.10 - 6.35 mm pillow washer.

Date	Action	Revisions
2001 03 14	Revised	Editorial – no technical change A. Cockman
1993 05 27		

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Evaluation Photographs - see Page 4

Source: Standards Operations
20000 Rotunda
P.O. Box 2053
Bldg. #3, Mail Drop 3033
Dearborn, MI 48121-2053
(313) 845-7226

or Central Laboratory Services
15000 Century Drive
Dearborn, MI 48120 U.S.A.
(313) 322-2167

Test Sample

Zincrometal coated.
Panels 95 x 300 x .089 mm

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. Set ductility cup tester:
Clamp Load: 2224 N
Rate of Draw: 10.0 (lower left control)
Draw to: 6.35 mm
Actual extrusion height
2. Lock the breach on the ductility cup tester.
3. Select the test panel and center it under the breach between the upper and lower dies with the test side up.
4. Run the ductility cup tester the 6.35 mm cycle using the start button at the front of the machine, the preset automatic stop and the redraw button at the upper left of the machine.
5. Slide the panel out of the breach carefully so that the test area (crown) is not abraded.