

RESISTANCE TO BLEEDING OF PAINT

Application

This method is used to test enamel for bleeding after spraying and baking to simulate production conditions.

Apparatus Required

Mechanical Convection Oven

Capable of maintaining temperatures up to 180 +/- 2 °C.

Materials Required

Test Panels

Clean untreated steel body skin panels in accordance with FLTM BI 103-02, 300 x 150 mm.

Masking Tape

High Temperature - 25 mm nominal width.

Sanding Paper

No. 360 wet and dry paper.

Naphtha

Reagent grade; CAUTION: Low flash point.*

Lint-free Cloth

White Production Enamel

Use current approved production enamel.

* Refer to Industrial Hygiene for health and safety comments.

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 19	Revised	Editorial – no technical change A. Cockman
1990 05 11		

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Procedure

1. Spray panels with primer or apply electrocoat primer according to the paint system which will be used with the enamel under test. Bake according to the applicable Engineering Material Specification.
2. Mask Section C of test panel with masking tape as shown in Figure 1.
3. Spray area A and B with the enamel under test as described in BI 103-02, Method C. Remove masking tape and bake panel according to Engineering Material Specification.
4. Scuff (dry sand lightly) all of Section A and sand to bare metal an area approximately 50 mm in diameter. After scuffing, the panel is wiped off with a lint-free cloth dampened with naphtha.
5. Spray approved white production enamel over the entire panel to a dry film thickness of 40 - 50 micrometres.
6. Bake according to Engineering Material Specification.
7. Examine the panel immediately after baking and/or as specified in the applicable Engineering Material Specification. Report any evidence of bleeding.

Note: For truck paints, bleeding tests should use materials as specified by Product Engineering.

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.