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FORD LABORATORY TEST METHOD BI 120-05

CONTINUOUS PROCESS TEST FOR ELECTROCOATING PRIMERS

Application

This procedure is used for the determination of the life span of electrocoating bath when coatings from it are produced in a continuous process.

Apparatus Required

Coil Stock Coating Device

With variable speed, drive, heat exchangers and paint feeding equipment.

Power Source

A direct current power source which can be adjusted between 0 - 1000 volts D.C. and 0 - 20 amps.

Steel Coil Stock *

Dimensions 305 mm wide x .127 mm thick with perforated center and phosphate coated to meet the requirements of Engineering Materials Specification WSK-M3P1-C.

* Available from:

Parker Rust Proof Co.
Detroit, Michigan U.S.A.

Procedure

1. The tank and lines are filled with the paint to be tested and the agitation system put into operation.

2. A representative sample of the bath is taken and its composition determined by appropriate test methods.

3. Test panels are prepared in the tank and the customary film properties are established by test.

4. Coil stock is threaded into the equipment, submerging in the bath the desired length of stock; for instance, 305 mm.

Date	Action	Revisions
2001 03 19	Revised	Editorial – no technical change A. Cockman
1989 08 03		

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5. The coil stock drive is started at the desired rate; for instance, 305 mm/minute, and the tank is energized to the coating voltage, maintaining the desired coating temperature: for instance, 35 °C.

6. Paint and other materials are fed in at the rate needed for coating.

7. Periodically the bath composition and the film properties are tested for as outlined in Steps 2 and 3.

8. The run is continued as long as the bath and the paint films received from it meet the applicable specifications or until the desired amount of paint, usually 20 times the weight of solids used as original fill, has been converted into coatings of specified properties.

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.

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