

EDGE COVERAGE TEST FOR ELECTROCOAT MATERIALS

Application

This method is used to test the ability of electrocoat materials to cover sharp metal edges.

Apparatus and Materials Required

Electrocoat Bath and Coating Apparatus

Knife Blades	Embee # 172 blades	(See Figure 1)
Sources:	EMBEE Corp.	Nivo Office Products B.V.
	P.O. Box 1268	Lichtenhorststraat 11A
	522 W. State St.	P.O. Box 104
	Springfield, Ohio 45501	6940 AA Didam, Holland
	Tel: (513) 323-3795	Tel: 0 8362-28400
	Fax: (513) 323-0733	Fax: 0 8362-28450

Salt Fog Cabinet

As specified in FLTM BI 103-01.

Magnifying Scope or Lens

30x Power

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. Phosphate 3 knife blades per the applicable electrocoat specification. Visually inspect the hardened steel blade edge for phosphate. Reject blades with shiny appearance which indicates lack of phosphate.

Date	Action	Revisions
2001 03 20	Revised	Editorial – no technical change A. Cockman
1995 06 29		

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2. Electrocoat knife blades to target film build specified in the relevant material specification.
3. The blades should be completely electrocoated by suspending them from the hole with a paper clip and coating them to the target film build.
4. Bake at temperature and time specified.
5. Blades should be coated in triplicate for each variable.
6. Blades are placed in a 5 % Salt Fog Cabinet (FLTM BI 103-01) for 7 days. Blades must be at 90° to the horizontal with the sharp edge straight up and totally exposed.
7. After 7 days, rinse with D.I. water and allow to air dry. Do not wipe blades.
8. The rust spots along the sharp edge may be counted using a 30x power scope. Record the average of three blades.

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.