

ADHESION (ROOM TEMPERATURE)**1. SCOPE**

This procedure evaluates the ability of a dry paint film to adhere to a substrate.

2. REFERENCE STANDARDS

ASTM D3359 - Measuring Adhesion by Tape Test.
85607636(FNHA-2-J-001.01) - Panel or Part
Preparation

3. MATERIALS AND EQUIPMENT

3.1 Cutting tool (Gardner PA-2000 or equivalent) with six teeth and 2.0 mm blade.

3.2 Painted production panels prepared according to 85607636 (FNHA-2-J-001.01). Panels must be allowed to age at room temperature ($25^{\circ} \pm 5^{\circ} \text{C}$) for 14 days.

3.3 Scotch cellophane tape, #600, 1" wide.

3.4 Kleenex, Kimiwipes or equivalent.

3.5 Rubber eraser on the end of a pencil.

4. PROCEDURE

4.1 Make two cuts at right angles to each other, approximately 1.5" (40 cm) long on each test panel to be evaluated. The second cut should be made on top of the first cut forming 25 small squares. When cutting, cut through the film to the substrate in one steady motion.

4.2 Brush the test area lightly with a Kleenex to remove any detached pieces or ribbons of coating.

4.3 Press the center of about a 3-inch (50 cm) long tape over the cross hatched area at about a 45° angle.

4.4 Rub the tape with the pencil eraser to make sure the tape to painted film has total contact.

4.5 Within 1 minute, remove the tape with a rapid pull (not jerked) back upon itself as close to a 180° angle as possible.

4.6 Visually examine the test specimen without magnification and compare the results to the adhesion guide. See Figure 1.

5. REPORT

5.1 Report the rating that best matches the adhesion guide.

5.2 A rating of 3B or better is acceptable. Intercoat adhesion loss or adhesion to substrate loss of 2B or worse is cause for rejection.

					NAME	STD ADHESION	
					 NEW HOLLAND		ENGINEERING SPECIFICATION
ALL	C	JDF	112450	8/3/98			FRAME 1 OF 3
ALL	B	RLF	110274	JUL 97	THE INFORMATION HEREON IS THE CONFIDENTIAL AND PROPRIETARY PROPERTY OF NEW HOLLAND NORTH AMERICA, INC. AND/OR NEW HOLLAND CANADA, LTD. ANY USE, EXCEPT THAT FOR WHICH IT MAY BE LOANED, IS PROHIBITED.		PART NUMBER
ALL	A	RE	104739	940216			
FRAME NO.	REV	BY	ECN NO.	DATE			
APP.	DRAWN		AP	NOV 93			86507645 
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ADHESION (COLD 20°F)**1. SCOPE**

This procedure evaluates the ability of a dry paint film to adhere to a substrate at 20°F (-7°C).

2. REFERENCE STANDARDS

ASTM D3359 - Measuring Adhesion by Tape Test.
86507636(FNHA-2-J-001.01) - Panel or Part
Preparation

3. MATERIALS AND EQUIPMENT

3.1 Cutting tool (Gardner PA-2000 or equivalent) with six teeth and 2.0 mm blade.

3.2 Painted production panels prepared according to 85607636 (FNHA-2-J-001.01). Panels must be allowed to age at room temperature ($25^{\circ} \pm 5^{\circ}\text{C}$) for 14 days.

3.3 Kleenex, Kimiwipes or equivalent.

3.4 Freezing chamber capable of holding $20^{\circ} \pm 1^{\circ}\text{F}$ ($-7^{\circ} \pm 1^{\circ}\text{C}$).

4. PROCEDURE

4.1 Place the test panel in the freezing chamber for 16-18 hours.

4.2 Remove panel and immediately make two cuts at right angles to each other, approximately 1.5" (40 cm) long on each test panel to be evaluated. The second cut should be made on top of the first cut forming 25 small squares. When cutting, cut through the film to the substrate in one steady motion.

NOTE: The elapsed time from removing the panel from the freezing chamber to making the cut must be within 15 seconds.

4.3 Brush the test area lightly with a Kleenex to remove any detached pieces or ribbons of coating.

4.4 Visually examine the test specimen without magnification and compare the results to the adhesion guide. See Figure 1.

5. REPORT

5.1 Report the rating that best matches the adhesion guide.

5.2 A rating of 2B or better is acceptable. Intercoat adhesion loss or adhesion to substrate loss of 1B or worse is cause for rejection.

 NEW HOLLAND	NAME			PART NUMBER	
	STD ADHESION				
ENGINEERING SPECIFICATION			REV. C	FRAME 2	OF 3