

MATERIALS / PAINTS

FNHA-2-J-001.13

SALT SPRAY RESISTANCE**1. SCOPE**

This is a procedure for evaluating the ability of a cured paint system to resist corrosion when subjected to salt spray.

2. REFERENCE STANDARDS

ASTM B117 - Salt Spray
 ASTM D610 - Surface Rusting
 ASTM D714 - Blistering of Paint
 ASTM D1654 (For scraping procedure)
 86507631(FNHA-2-J-001.01) - Panel or Part Preparation

3. MATERIALS & EQUIPMENT

3.1 Salt spray cabinet meeting all operating parameters set forth in ASTM B117.

3.2 Scribing knife

3.3 Kimwipes or equivalent

3.4 Ruler capable of measuring within 0.5 mm

3.5 Scalpel or sharp pen knife

4. PROCEDURE

4.1 Prepare duplicate test panels according to 86507631 (FNHA-2-J-001.01). Include Bonderite 1000 panels as controls.

4.2 Paint panels with the appropriate paint or paint system and follow the proper curing schedule and allow to age at room temperature ($25^{\circ} \pm 5^{\circ}\text{C}$) for 14 days.

4.3 Using a sharp knife, cut an X on each test panel, making sure to cut through the paint film to bare metal keeping at least 1/2" from any edge.

4.4 Protect the back and edges of each panel with a suitable inhibitive primer. An alternative to edge priming is to apply wax or tape with no more than 1/2" coverage from any edge. 3.5 Conduct salt spray test for 240 hours for a single coat of paint and 480 hours for a two-coat paint system (primer and topcoat).

4.5 When test is complete, wash each panel with clean water and dry with Kimwipes or equivalent.

4.6 Allow panels to recover for 15 minutes and remove all loose paint by briskly scraping across each scribe mark using medium pressure with a rigid spatula or pen knife.

4.7 Examine the surface for face blistering and rusting and measure the amount of paint creepage from each scribed line. Record creepage, blistering, rusting and other surface film defects.

5. REPORT

5.1 Measure paint creepage from each scoreline to nearest 0.5 mm on production panels (or parts) and on Bonderite 1000 panels.

5.2 Report all surface rusting and degree of blistering on both production and Bonderite substrates.

5.3 Report any other surface imperfections.

					NAME	STD SALT SPRAY				
					 NEW HOLLAND			ENGINEERING SPECIFICATION		
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5.4 The panel or part will pass if the surface film appearance is visually equal in gloss and is free of blisters and the amount of creepage is under 3.0 mm from each scoreline on production parts and panels.

NOTE: If the Bonderite panels are acceptable and production parts or panels are not, the pre-paint process should be examined and corrected and the evaluation rerun.

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