

TECHNICAL BULLETIN

Field Adhesion Test Method

6. Within 90 ± 30 seconds of application, remove the tape by holding the free end and pulling it off rapidly, but evenly, back upon itself at about a 180° angle.

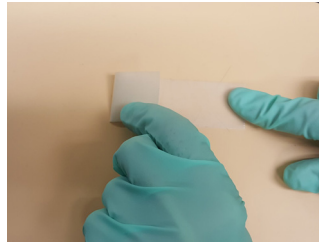


Figure 3

7. Inspect the X-cut area for removal of the coating from the substrate or previous coating and rate the adhesion.

Rating the Adhesion

The following scale should be used to rate the adhesion of the coating (**Figure 4**):

- | | |
|---|--|
| 5 | No peeling or removal of the coating |
| 4 | Trace peeling or removal along incisions or at their intersection |
| 3 | Jagged removal along incisions up to 1/16 inch (1.6mm) on either side |
| 2 | Jagged removal along most of the incisions up to 1/8 inch (3.2mm) on either side |
| 1 | Removal from most of the area of the X under the tape |
| 0 | Removal beyond the area of the X |

Ideally, for a new coating, a rating of 4 or higher should be achieved. A rating of 3 would be the lowest acceptable rating, while 2 or below would be considered a fail.

It is important that more than one trial is made in each area tested, so that the results may be representative of the entire

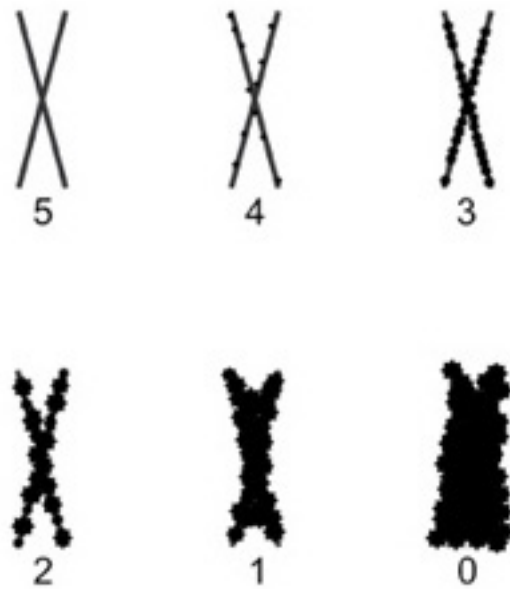


Figure 4

surface. Report the coating/s that was tested, the number of tests that were conducted, the results for each trial, the location where each trial was conducted, and the environmental conditions at the time of testing.

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