

ISO 4624:2023-06 (E)

Paints and varnishes - Pull-off test for adhesion

Contents	Page
Foreword.....	iv
Introduction.....	v
1 Scope	1
2 Normative references	1
3 Terms and definitions	1
4 Principle	2
5 Apparatus	2
6 Adhesives	5
7 Sampling	6
8 Test panels	6
8.1 Substrate.....	6
8.2 Preparation and coating.....	6
8.3 Drying and conditioning.....	6
8.4 Thickness of coating.....	6
9 Procedure	6
9.1 Number of determinations.....	6
9.2 Ambient conditions.....	6
9.3 Adhesive.....	6
9.4 Test assemblies.....	7
9.4.1 Method A: General method (using two dollies) for testing both rigid and deformable substrates.....	7
9.4.2 Method B: Method for testing from one side only, using a single dolly (suitable for rigid substrates only).....	7
9.4.3 Method C: Method using dollies, one as a painted substrate.....	8
9.5 Measurement.....	9
9.5.1 Breaking strength.....	9
9.5.2 Nature of the fracture.....	9
10 Calculation and expression of results	9
10.1 Breaking strength.....	9
10.2 Nature of failure.....	10
10.3 Example.....	10
11 Precision	10
12 Test report	10
Bibliography	12