

ISO 18468:2017-06 (E)

Ductile iron fittings, accessories and their joints and valves - Epoxy coating

Contents		Page
Foreword		iv
1	Scope	1
2	Normative references	1
3	Terms and definitions	1
4	Routine test requirements	2
4.1	General	2
4.2	Surface preparation	3
4.3	Coating appearance	3
4.4	Coating thickness	3
4.5	Adhesion (pull off test/cross cut knife test)	3
4.6	Cross linkage (MIBK/Tg)	3
4.7	Non-porosity	3
4.8	Repairs	4
5	Performance requirements	4
5.1	General	4
5.2	Materials in contact with water intended for human consumption	4
5.3	Materials in contact with sewage waters	4
5.4	Impact resistance	4
5.5	Resistance to hot water	4
6	Test methods	5
6.1	Routine tests	5
6.1.1	Surface preparation	5
6.1.2	Coating appearance	5
6.1.3	Coating thickness	5
6.1.4	Adhesion (pull off/cross cut knife test)	5
6.1.5	Cross linkage (MIBK/Tg)	5
6.1.6	Non-porosity	5
6.2	Performance test	6
6.2.1	Impact resistance strength	6
6.2.2	Resistance to hot water	6
Annex A (normative) Quality assurance		7
Annex B (normative) Cross cut knife test method		9
Annex C (informative) Coating material		10
Annex D (informative) Handling, transportation and storage		11
Bibliography		12