

ISO/TR 19402:2018-08 (E)

Paints and varnishes - Adhesion of coatings

Contents		Page
Foreword		v
Introduction		vi
1	Scope	1
2	Normative references	1
3	Terms and definitions	1
4	Adhesive strength tests without scratch/cut	3
4.1	Tests with mechanical stress application on the coating	3
4.1.1	Pull-off test	3
4.1.2	Twist-off test	5
4.1.3	Peel-off test 1	6
4.1.4	Peel-off test 2	8
4.2	Tests with continuous deformation of test specimens	9
4.2.1	Bend test with a wedge-shaped conical mandrel	9
4.2.2	Bend test with a conical mandrel	11
4.2.3	Bend test with a cylindrical mandrel 1	12
4.2.4	Bend test with a cylindrical mandrel 2	14
4.2.5	Three point bending method	15
4.2.6	T-bend test 1	17
4.2.7	T-bend test 2	19
4.2.8	Cupping test 1	20
4.3	Test with impact stress application	22
4.3.1	Single-impact test 1	22
4.3.2	Single-impact test 2	25
4.3.3	Single-impact test 3	27
4.3.4	Single-impact test 4	28
4.3.5	Falling-weight test 1	30
4.3.6	Falling-weight test 2	33
4.3.7	Falling-weight test 3	35
4.3.8	Multi-impact test 1	36
4.3.9	Multi-impact test 2	38
4.3.10	Multi-impact test 3	41
4.3.11	Multi-impact test 4	43
4.3.12	Impact-bend test	44
5	Adhesive strength tests with scratch/cut	45
5.1	Tests with single scratch	45
5.1.1	Scratch test 1	45
5.1.2	Scratch test 2	46
5.1.3	Scratch test 3 (Scrape-adhesion test)	47
5.2	Test with multiple scratch (without deformation of test specimens)	49
5.2.1	Pressure-water jetting test	49
5.2.2	Cross-cut test 1	53
5.2.3	Cross-cut test 2	56
5.2.4	Cross-cut test 3	57
5.2.5	X-cut test 1	58
5.2.6	X-cut test 2	58
5.2.7	X-cut test 3	59

5.2.8	X-cut test 4	59
5.2.9	Scribe test with a square-diagonal grid	60
5.2.10	Scribe test with a rhombus grid	61
5.3	Test with multiple scratch (with deformation of test specimens)	62
5.3.1	Cupping test 2	62
6	Evaluation methods for adhesive strength	63
6.1	Auxiliary methods	63
6.1.1	Contrasting 1	63
6.1.2	Contrasting 2	64
6.2	Visual methods	64
6.2.1	Failure pattern analysis	64
6.2.2	Comparison of areas	65
6.2.3	General assessment	66
6.3	Instrumental methods	67
6.3.1	Digital image evaluation 1	67
6.3.2	Digital image evaluation 2	67
	Annex A Synoptical tables for the methods	69
	Bibliography	76