# 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