

TITLE: Paint Adhesion Testing

1.0 PURPOSE

1.1 To ensure proper paint adhesion and to verify that the paint is mixed properly and sufficiently dried for further processing or packaging and shipment.

2.0 SCOPE

2.1 This procedure includes all paint types utilized by Northeastern.

3.0 PROCEDURE

3.1 A sample, alodined, aluminum panel, approximately 3" X 10", shall be supplied to the painter with each shipment of material to be painted for this testing.

3.2 The painter, at his discretion, may perform this testing and return the sample to Northeastern's quality department for review. If the painter does perform this testing, Northeastern is not required to duplicate the testing. However, if the testing is not performed by the painter, then it shall be performed by Northeastern's quality department.

3.3 If either of the following tests fail the stated requirements, the entire lot of material shall be returned to the supplier for rework.

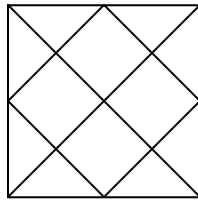
3.4 Paint Adhesion

3.4.1 Cross hatch (score to base metal) 3 lines diagonally in each direction within approximately one square inch area. (See figure on page two)

3.4.2 Apply 3M #250 masking tape over the cross hatch area and remove the tape at an approximately 90° angle. There should be no evidence of paint lifting.

3.5 Solvent Testing to determine proper mixture and drying.

3.5.1 Using isopropyl alcohol, wet a clean, white, rag and vigorously wipe a small painted area with the dampened rag. There shall be no change in the painted surface finish and there should be only minimal, if any, evidence of paint on the rag.



EXAMPLE OF CROSS HATCH