

Hebei Hanna (Powder) Technology Co., Ltd

Boiled adhesion test

Standard: GB/T 23257-2017

SY/T 0315-2013

SY/T 0442-2010/18

CAN CSA.Z.245.20-14(2015)

Equipment: constant temperature water bath, knife

Test steps:

a) Before immersing the specimen in each test, preheat the fresh water to $75^{\circ}\text{C}\pm 3^{\circ}\text{C}$, put the specimen in an oven or water bath, submerge the specimen with the preheated water, and soak at least at $75^{\circ}\text{C}\pm 3^{\circ}\text{C}$ 24h, then take out the test piece; if necessary, you can soak the test piece for 28 days at the same temperature, and then take it out for testing.

b) When the test piece is still warm, immediately use a knife to mark a large 30mm+15mm rectangle on the coating, and reach the base plate through the coating, and then naturally cool to $20^{\circ}\text{C}\pm 3^{\circ}\text{C}$ in the air, 1h after taking out the test piece From any corner of the rectangle, insert the tip of the knife under the coating, pry the coating with horizontal force, and continue to push the tip of the knife until the coating in the rectangle is completely pried off or the coating shows obvious pry resistance.

c) Evaluate the adhesion level of the rectangular inner coating according to the following classification standards:

- 1) Grade 1 —The coating obviously cannot be peeled off by prying.
- 2) Grade 2—The coating being pried off is less than or equal to 50%.
- 3) Grade 3—More than 50% of the coating is pried away, but the coating shows obvious pry resistance.

4) Grade 4 — The coating is easily peeled off into strips or large pieces of debris.

5) Grade 5 — The coating was pulled off as a whole piece.

Authorized by	Quality Management Department	Review by	Michael Zhang	Approve By	Mark Lee
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