

**Arkote Pty Ltd
Cure Test Procedure**

**TITLE:
"DEGREE OF CURE BY
SOLVENT RESISTANCE"**



1. SCOPE:

This procedure determines the resistance of a baked powder coating film to the action of solvent. This is used as a test for degree of cure.

When a baked coated test piece or panel is tested for solvent resistance, there should be no discolouration onto the cloth or erosion of the coating surface.

A. Wear rubber gloves and conduct the test in a well-ventilated area. Avoid breathing and exposure to solvent vapour.

B. When test is completed, dispose of rag by placing in water filled container. Do not leave rag dampened with solvent on an open bench in the laboratory as solvent saturated rags may be a fire hazard.

2. EQUIPMENT:

1. Cotton cloth (preferably white).
2. Methyl Ethyl Ketone solvent

3. PROCEDURE:

1. Wearing rubber gloves, place forefinger in cloth such that forefinger is covered by cloth.
2. Saturate portion of cloth covering forefinger with specified cure test solvent.
3. Rub test piece for 30 rubs (unless otherwise specified) using a back and forth motion. Allow the finger to glide over the surface. DO NOT apply pressure.

Note:

- One rub is equal to 1 stroke in each direction.
- The length of stroke should be approximately 5.0cm.
- Sufficient pressure should be exerted by the finger to ensure good contact between cloth and test piece.
- Test should be completed in 30 seconds.
- If rag becomes dry during test or the test is interrupted before completion, the rag must be re-saturated with solvent and the test repeated.

Quality Means: In-Spec, In-Full, On-Time, Every Time

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4. REPORTING OF RESULTS:

The result is reported as Pass or Fail where:

- Pass, (Powder coating is satisfactorily cured) will show no or very slight discolouration onto cloth and/or no or very slight erosion of the coating surface.
- Fail, (Powder coating is unsatisfactorily cured) will show significant transfer of the coating to the cloth and/or significant erosion of the coating surface.

Note: Bright deep coloured powder coatings based on organic pigments, may tend to exhibit higher levels of discolouration onto the rag due to the pigment colour strength. This should be ignored in the interpretation of the results.