



Standard Test Method for Adhesion of Organic Coatings by Scrape Adhesion¹

This standard is issued under the fixed designation D2197; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

This standard has been approved for use by agencies of the Department of Defense.

1. Scope

1.1 This test method covers the determination of the adhesion of organic coatings such as paint, varnish, and lacquer when applied to smooth, flat (planar) panel surfaces.

1.2 The values stated in SI units are to be regarded as the standard. The values given in parentheses are for information only.

1.3 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 *ASTM Standards:*²

[D609 Practice for Preparation of Cold-Rolled Steel Panels for Testing Paint, Varnish, Conversion Coatings, and Related Coating Products](#)

[D823 Practices for Producing Films of Uniform Thickness of Paint, Varnish, and Related Products on Test Panels](#)

[D1005 Test Method for Measurement of Dry-Film Thickness of Organic Coatings Using Micrometers](#)

[D7091 Practice for Nondestructive Measurement of Dry Film Thickness of Nonmagnetic Coatings Applied to Ferrous Metals and Nonmagnetic, Nonconductive Coatings Applied to Non-Ferrous Metals](#)

3. Summary of Test Method

3.1 The materials under test are applied at uniform thickness to flat panels, usually sheet metal of uniform surface texture. After drying, the adhesion is determined by pushing the panels

beneath a rounded stylus or loop that is loaded in increasing amounts until the coating is removed from the substrate surface.

4. Significance and Use

4.1 Coatings to perform satisfactorily must adhere to the substrates on which they are applied. This test method has been found useful in differentiating the degree of adhesion of coatings to substrates. It is most useful in providing relative ratings for a series of coated panels exhibiting significant differences in adhesion.

4.2 Studies performed in a laboratory using the loop stylus specified in the previous edition showed meaningful adhesion data were impossible when loads of 10 to 20 kg were required to break the surface of a solvent based coating. The chrome plated loop stylus chattered and skipped across the coating surface when loads of this magnitude were required. Similar meaningless data were obtained when powder coatings were tested that required more than 10 kg to break the surface. Therefore, testing under these conditions is not applicable.

5. Apparatus

5.1 *Application Equipment*, as described in Practices [D823](#).

5.2 *Film-Thickness Measuring Apparatus*, as described in Test Method [D1005](#) or Practice [D7091](#).

5.3 *Balanced Beam, Scrape Adhesion Tester* ([Figs. 1 and 2](#)), consisting of a balanced beam to which is secured a platform for supporting weights, and a rod at an angle of 45° that holds the scraping loop. The rod shall be set so that the scraping loop contacts test surfaces directly below the weights. The loop shall be 1.6-mm ($1/16$ -in.) diameter rod, bent into a “U” shape with an outside radius of 3.25 ± 0.05 mm (0.128 ± 0.002 in.) and hardened to Rockwell HRC 56 to 58, and shall be a smooth finish. The loop can be either chromium plated, nickel plated, or heat treated polished steel, as agreed upon between the purchaser and the supplier. These testers are adjustable to accommodate flat, metallic, and nonmetallic specimens to 12-mm (0.5-in.) thick and 100 to 400 mm (4 to 16 in.) wide and long; the specimen should be at least 12-mm ($1/2$ -in.) wide.

¹ This test method is under the jurisdiction of ASTM Committee [D01](#) on Paint and Related Coatings, Materials, and Applications and is the direct responsibility of Subcommittee [D01.23](#) on Physical Properties of Applied Paint Films.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

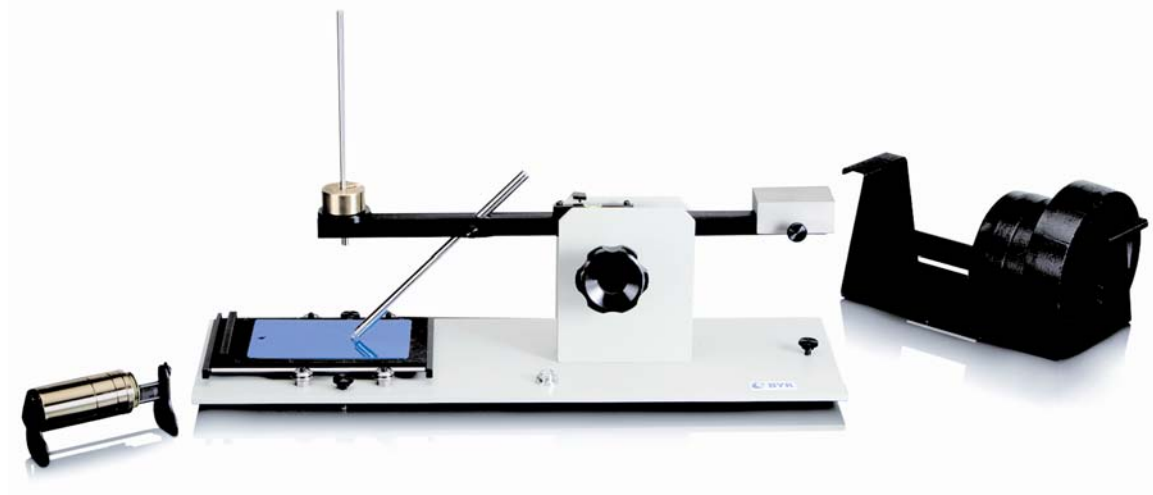


FIG. 1 Balanced-Beam Scrape-Adhesion Tester

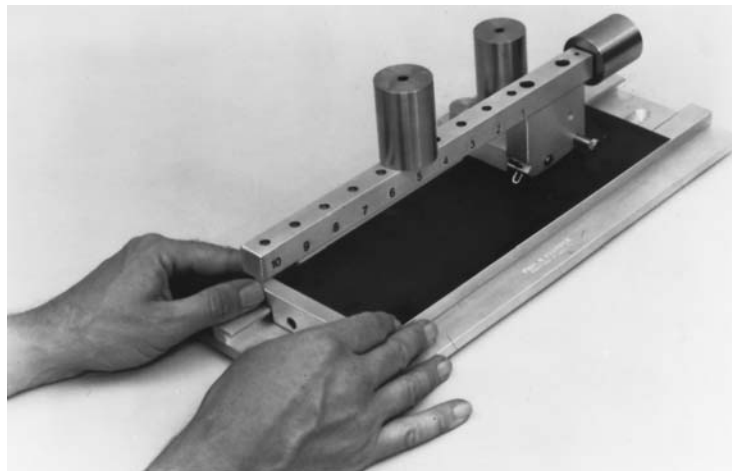


FIG. 2 Balanced Beam Scrape Adhesion and Mar Tester

6. Preparation of Specimens

6.1 Apply the materials under test to panels of the composition and surface condition on which it is desired to determine adhesion. The panel material (6.1.1), surface preparation, thickness, and number of coats shall be specified or agreed upon by the seller and the purchaser. Apply uniform coatings and air dry or bake under conditions of humidity and temperature mutually agreeable to the seller and purchaser. Either mask the panel or remove material after application, so that 13 mm (½ in.) at one end of the panel is uncoated.

6.1.1 The surface of the panel must be hard enough that it will not be damaged by the scraping loop. If no panel material is specified, use 0.8-mm (0.032-in.) cold-rolled carbon steel prepared in accordance with Methods B or C of Practice D609.

7. Conditioning and Number of Tests

7.1 Condition the test panels for at least 48 h at $23 \pm 2^\circ\text{C}$ ($73.5 \pm 3.5^\circ\text{F}$) and $50 \pm 5\%$ relative humidity, and test in the same environment, or immediately on removal therefrom, unless otherwise specified or agreed by the seller and the purchaser. Test at least two replicate specimens of each material.

8. Procedure

8.1 When using the instrument shown in Fig. 1, level the base plate of the apparatus and place it so that the weight holder is toward the operator. This places the beam release on the operator's right and allows freedom to move the test specimen manually under the weighted scraping element (loop). Adjust the main bearing support so that the beam is balanced in the horizontal plane when the loop is just touching the specimen surface.

8.2 Raise the beam and lock it. Wipe the loop with clean cloth or chamois. Place a test panel on the sliding platform so that it may be moved away from the operator and the uncoated portion is toward the main beam support. Place weights on the weight support using an initial amount that is estimated to be appropriate for the particular coating. Carefully lower the beam until the loop rests on the uncoated portion of the test specimen and the full load is applied, then slowly (1 to 2 s/in.) push the sliding platform away from the operator for a distance of at least 75 mm (3 in.). If the coating is removed, continue the testing, using successively smaller loads (0.5-kg increments) until the coating is not removed. If the coating is not removed

by the initial scrape, continue the testing, using successively larger loads (0.5-kg increments) until the coating is removed or until the maximum load of 10 kg has been applied. Use a new area of the test surface each time a scrape is made.

8.3 When the critical load has been approximately located, repeat the test five times at each of three loadings: above, below, and at the load determined in the first trial. Use the replicate specimen to apply different loads in random fashion so the same load is not made in succession.

8.3.1 Periodically examine the loop to ensure that the original smooth surface is intact. If the contacting surface is worn, reverse the loop. When both sides are worn, replace with a new loop.

8.4 For each applied load, tabulate the number of times the coating was removed or adhered. The load where the scrape results change from mainly adhering to mainly removed, ignoring the first 13 mm (½ in.) of the scratch if the coating was removed, is the adhesion failure end point.

9. Report

9.1 Report the following information:

- 9.1.1 Load in kilograms at the adhesion failure end point,
- 9.1.2 Panel material and surface preparation,

9.1.3 “U” shape loop surface finish,

9.1.4 Dry-film thickness, and

9.1.5 Any deviation from the specified procedure.

10. Precision

10.1 *Correlation*—This method was developed when correlation with other methods of assessing adhesion was considered to be of equal importance to the agreement between results obtained in the same or different laboratories. It was established that when materials differing widely in hardness and adhesion were evaluated by a number of experienced personnel in several laboratories, the adhesion results obtained using this method correlated well with those obtained with several other methods.

10.2 *Precision*—If sufficient cooperators can be obtained, an interlaboratory study will be conducted to establish precision.

10.3 *Bias*—No information can be provided on the bias of this test method for measuring adhesion because no material having an accepted reference value is available.

11. Keywords

11.1 adhesion; balanced-beam scrape adhesion tester; scrape

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