

# ADHESION



• Adhesion (ASTM D3359), is a test method to analyze whether a coating has adhered to a metal substrate. Cerakote™ H-146 was applied to a set of steel panels and a crosshatch pattern is made through the coating to the substrate. Pressure-sensitive tape is applied over the crosshatch cut and then the tape is smoothed into place over the area of the incisions. The tape is then removed by pulling it off rapidly back over itself as close to an angle of 180° and the adhesion of the coating to the steel is assessed on a 0B to 5B scale (shown). Cerakote™ H-146 Finished Strong with a 5B adhesion rating, the highest adhesion rating possible.

Classification of Adhesion Test Results		
Classification	Percent Area Removed	Surface of Cross-Cut Area From Which Flaking has Occured for Six Parallel Cuts and Adhesion Range by Percent.
<b>5B</b>	<b>0% None</b>	
<b>4B</b>	<b>Less Than 5%</b>	
<b>3B</b>	<b>4-5%</b>	
<b>2B</b>	<b>15-35%</b>	
<b>1B</b>	<b>35-65%</b>	
<b>0B</b>	<b>Greater Than 65%</b>	

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