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Adhesion Testing of Hauthane Polyurethane Dispersions (pigmented) on Various Substrates

The following tables show the results of the adhesion testing of 12 pigmented (16% PVC) Hauthane Polyurethane Dispersions on 8 substrates. Coatings were applied to IPA wiped substrate via #100 WWR, followed by 30 minutes drying time at 180°F (82°C). Adhesion was tested on cooled panels via the cross-hatch test (ASTM D3359, Method B). Results are reported on a scale of 0B to 5B in accordance with the ASTM method. See legend attached for an explanation of the reporting scale.

A. Dry Adhesion Testing

	HD-2007	HD-2101	HD-2107	HD-2015	HD-2113	HD-2139	HD-2209	HD-3011	HD-2314	HD-4664	HD-4669	HD-5002
ABS (Magnum 344 HP)	5B	5B	5B	0B	0B	5B	5B	0B	0B	5B	0B	5B
Polyphenylene -oxide (PPO) (GE Noryl PX 0844-780)	0B	0B	0B	0B	0B	0B	0B	0B	0B	0B	0B	5B
Polycarbonate (GE Lexan EM 1210)	5B	5B	5B	0B	0B	0B	5B	0B	0B	5B	0B	5B
Polypropylene (Mytex AX03B)	0B	0B	0B	0B	0B	0B	0B	0B	0B	0B	0B	0B
Polypropylene (Montell Profax)	0B	0B	0B	0B	0B	0B	0B	0B	0B	0B	0B	0B
PPO/Nylon Alloy (GE Noryl GTX 910 71653)	3B	0B	0B	0B	0B	5B	0B	5B	5B	2B	5B	5B
Polystyrene (Dow Styron 478)	0B	0B	0B	0B	0B	0B	0B	0B	0B	0B	0B	5B
Acrylic (Elf Atochem V825- 100)	5B	3B	0B	0B	0B	5B	0B	0B	4B	4B	4B	5B

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Adhesion Testing of Hauthane Polyurethane Dispersions (pigmented) – Contd.

B. Wet Adhesion Testing

Wet adhesion testing was performed on the same coated substrate after soaking for at least 12 hours. Coatings were not tested (NT), if coating failed (OB) dry adhesion testing.

	HD-2007	HD-2101	HD-2107	HD-2015	HD-2113	HD-2139	HD-2209	HD-3011	HD-2314	HD-4664	HD-4669	HD-5002
ABS (Magnum 344 HP)	5B	5B	5B	NT	NT	5B	5B	NT	NT	5B	NT	5B
Polyphenylene-oxide (PPO) (GE Noryl PX 0844-780)	NT	NT	NT	NT	NT	NT	NT	NT	NT	NT	NT	5B
Polycarbonate (GE Lexan EM 1210)	5B	5B	5B	NT	NT	NT	5B	NT	NT	5B	NT	5B
Polypropylene (Mytex AX03B)	NT	NT	NT	NT	NT	NT	NT	NT	NT	NT	NT	NT
Polypropylene (Montell Profax)	NT	NT	NT	NT	NT	NT	NT	NT	NT	NT	NT	NT
PPO/Nylon Alloy (GE Noryl GTX 910 71653)	4B	NT	NT	NT	NT	0B	NT	5B	5B	NT	5B	0B
Polystyrene (Dow Styron 478)	NT	NT	NT	NT	NT	NT	NT	NT	NT	NT	NT	5B
Acrylic (Elf Atochem V825-100)	5B	0B	NT	NT	NT	5B	NT	NT	4B	3B	5B	5B

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Classification	Approximate percentage of cross cut area from which flaking has occurred
5B	0%
4B	<10%
3B	10-20%
2B	20-40%
1B	40-65%
0B	>65%