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

This table shows the results of adhesion testing of 12 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 below for an explanation of the reporting scale.

	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	1B	0B	0B	5B	5B	0B	0B	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	5B	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)	5B	5B	5B	5B	0B	4B	0B	5B	5B	0B	5B	5B
Polystyrene (DOW Styron 478)	0B	0B	0B	0B	0B	0B	0B	0B	0B	0B	0B	5B
Acrylic (ELF ATOCHEM V825-100)	0B	0B	0B	0B	0B	0B	0B	0B	0B	5B	1B	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%