



Standard Test Method for Evaluating Adhesion by Knife¹

This standard is issued under the fixed designation D 6677; 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.

1. Scope

1.1 This test method covers the procedure for assessing the adhesion of coating films to substrate by using a knife.

1.2 This test method is used to establish whether the adhesion of a coating to a substrate or to another coating (in multi-coat systems) is at a generally adequate level.

NOTE 1—The term “substrate” relates to the basic surface on which a coating adheres (may be steel, concrete, etc. or other coating).

1.3 This method can be used in the laboratory and field.

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

1.5 *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:

D 2197 Test Methods for Adhesion of Organic Coatings by Scrape Adhesion.²

D 3359 Test Methods for Measuring Adhesion by Tape Test.²

D 4541 Test Method for Pull-Off Strength of Coatings Using Portable Adhesion Testers.³

3. Summary of Test Method

3.1 Adhesion is determined by making an “X” cut into the coating film to the substrate and by lifting the coating with a knife. Adhesion is evaluated qualitatively on a 0 to 10 scale.

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 as a simple means of assessing the adhesion of coatings. Although this method is a qualitative and a subjective test it has been used in industry for many years and can provide valuable information.

4.2 Other adhesion test methods may be useful in obtaining quantitative results. See D 2197, D 3359 and D 4541.

4.3 The Performance Evaluation Scale (see 7.4, Table 1) is based on both the degree of difficulty to remove the coating from the substrate and the size of removed coating.

4.4 This test method does not have a known correlation to other adhesion test methods (pull-off, tape, etc.).

4.5 A coating that has a high degree of cohesive strength may appear to have worse adhesion than one that is brittle and hence fractures easily when probed.

5. Apparatus and Materials

5.1 *Cutting Tool*—Sharp utility knife.

5.2 *Cutting Guide*—Steel or other hard metal straight edge to ensure straight cuts.

6. Test Specimen

6.1 When this test method is used in the field, the specimen is the coated substrate on which the adhesion is to be evaluated.

6.2 For laboratory use, apply the materials to be tested to panels of the composition and surface conditions on which it is desired to determine adhesion.

NOTE 2—If desired or specified, the coated test panels may be subjected to a preliminary exposure such as water immersion, salt spray, or high humidity before conducting the knife adhesion test.

7. Procedure

7.1 Select an area free of blemishes and surface imperfections.

7.2 Using a sharp knife and cutting guide, make two cuts into the coating with a 30 to 45 ° angle between legs and down to the substrate which intersects to form an “X”. Make each leg of the angle a minimum of 38.1 mm (1 ½ in.) in length. Disregard coating removed during cutting process.

7.3 Employing the point of the knife and beginning at the vertex of the angle, attempt to lift up the coating from the substrate or from the coating below. Rate according to Table 1.

7.4 Repeat the test in two other locations on each test panel. For large structures make sufficient tests to ensure that the adhesion evaluation is representative of the whole surface.

7.5 After making several cuts examine the cutting edge and, if necessary, replace the blade.

8. Report

8.1 Report the following information:

¹ This test method is under the jurisdiction of ASTM Committee D01 on Paint and Related Coatings, and Applications and is the direct responsibility of Subcommittee D01.46 on Industrial Protective Coatings.

Current edition approved May 10, 2001. Published July 2001.

² *Annual Book of ASTM Standards*, Vol 06.01.

³ *Annual Book of ASTM Standards*, Vol 06.02.

TABLE 1 Rating System

Rating	Description
10	Coating is extremely difficult to remove; fragments no larger than approximately 0.8 by 0.8 mm ($\frac{1}{32}$ in. by $\frac{1}{32}$ in.) removed with great difficulty.
8	Coating is difficult to remove; chips ranging from approximately 1.6 by 1.6 mm ($\frac{1}{16}$ by $\frac{1}{16}$ in.) to 3.2 by 3.2 mm ($\frac{1}{8}$ by $\frac{1}{8}$ in.) can be removed with difficulty.
6	Coating is somewhat difficult to remove; chips ranging from approximately 3.2 by 3.2 mm ($\frac{1}{8}$ by $\frac{1}{8}$ in.) to 6.3 by 6.3 mm ($\frac{1}{4}$ by $\frac{1}{4}$ in.) can be removed with slight difficulty.
4	Coating is somewhat difficult to remove; chips in excess of 6.3 by 6.3 mm ($\frac{1}{4}$ by $\frac{1}{4}$ in.) can be removed by exerting light pressure with the knife blade.
2	Coating is easily removed; once started with the knife blade, the coating can be grasped with ones fingers and easily peeled to a length of at least 6.3 mm ($\frac{1}{4}$ in.).
0	Coating can be easily peeled from the substrate to a length greater than 6.3 mm ($\frac{1}{4}$ in.).

8.1.1 Report the number of tests, their mean and range, and where the failure (if any) occurred (between first coat and substrate, between first and second coat, or within the coating, etc.).

8.1.2 For field test, report the structure or article tested, the location and the environmental conditions at the time of testing.

8.1.3 For test panels, report the substrate employed, the type of coatings, the dry film thickness and cure of each coat, and the environmental conditions at the time of testing.

9. Precision and Bias

9.1 No precision statement has been established for this test method due to its subjective character.

10. Keywords

10.1 adhesion; coating; intercoat adhesion; knife adhesion; paint; wet adhesion

The American Society for Testing and Materials takes no position respecting the validity of any patent rights asserted in connection with any item mentioned in this standard. Users of this standard are expressly advised that determination of the validity of any such patent rights, and the risk of infringement of such rights, are entirely their own responsibility.

This standard is subject to revision at any time by the responsible technical committee and must be reviewed every five years and if not revised, either reapproved or withdrawn. Your comments are invited either for revision of this standard or for additional standards and should be addressed to ASTM Headquarters. Your comments will receive careful consideration at a meeting of the responsible technical committee, which you may attend. If you feel that your comments have not received a fair hearing you should make your views known to the ASTM Committee on Standards, at the address shown below.

This standard is copyrighted by ASTM, 100 Barr Harbor Drive, PO Box C700, West Conshohocken, PA 19428-2959, United States. Individual reprints (single or multiple copies) of this standard may be obtained by contacting ASTM at the above address or at 610-832-9585 (phone), 610-832-9555 (fax), or service@astm.org (e-mail); or through the ASTM website (www.astm.org).