



Designation: D1748 – 22

Standard Test Method for Rust Protection by Metal Preservatives in the Humidity Cabinet¹

This standard is issued under the fixed designation D1748; 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 reappraisal. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reappraisal.

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

1. Scope*

1.1 This test method covers the evaluation of the rust-preventive properties of metal preservatives under conditions of high humidity.

1.2 The values stated in SI units are to be regarded as the standard except where the test apparatus or consumable parts are only available in other units. In such cases these will be regarded as 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 consult and establish appropriate safety, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

1.4 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 ASTM Standards:²

[A109/A109M Specification for Steel, Strip, Carbon \(0.25 Maximum Percent\), Cold-Rolled](#)

[D512 Test Methods for Chloride Ion In Water \(Withdrawn 2021\)³](#)

[D516 Test Method for Sulfate Ion in Water](#)

¹ This test method is under the jurisdiction of ASTM Committee D02 on Petroleum Products, Liquid Fuels, and Lubricants and is the direct responsibility of Subcommittee D02.L0.03 on Corrosion Testing of Sheet Metal Processing Fluids.

Current edition approved May 1, 2022. Published May 2022. Originally approved in 1960. Last previous edition approved in 2015 as D1748 – 10 (2015). DOI: 10.1520/D1748-22.

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.

³ The last approved version of this historical standard is referenced on www.astm.org.

[E11 Specification for Woven Wire Test Sieve Cloth and Test Sieves](#)

[E323 Specification for Perforated-Plate Sieves for Testing Purposes](#)

2.2 *Federal Standards:*⁴

[QQ-S-698 Steel Sheet and Strip, Low Carbon](#)

2.3 *Military Standards:*⁵

[MIL-C-5646F Cloth, Airplane](#)

[MIL-C-15074E Corrosive Preventive Compound Finger Print Remover](#)

2.4 *SAE International:*⁶

[SAE 1009C Tee Reducer, Bulkhead on Side, Flareless Tube](#)

3. Summary of Test Method

3.1 Steel panels are prepared to a prescribed surface finish, dipped in the test oil, allowed to drain, and then suspended in a humidity cabinet at 48.9 °C (120 °F) for a specified number of hours. The oil fails or passes the test in accordance with the size and number of rust dots on the test surfaces of the panels.

4. Significance and Use

4.1 This test method is used for measuring the relative abilities of metal preservatives to prevent the rusting of steel panels under conditions of high humidity. It should not be relied upon to predict the effectiveness of a metal preservative in which high humidity is not the principal factor in the rusting.

4.2 Comparisons made by this test method should normally be limited to similar metal preservative combinations designed for similar applications. The test life required for each type of metal preservative and for each intended application should be based on actual experience with that type of preservative in the intended service.

4.3 Since the precision of the test method appears to be less than desired, a number of repeat tests may be necessary to

⁴ Available from U.S. Government Printing Office Superintendent of Documents, 732 N. Capitol St., NW, Mail Stop: SDE, Washington, DC 20401, <http://www.access.gpo.gov>.

⁵ Available from <https://quicksearch.dla.mil/qaSearch.aspx>.

⁶ Available from SAE International (SAE), 400 Commonwealth Dr., Warrendale, PA 15096, <http://www.sae.org>.

*A Summary of Changes section appears at the end of this standard

establish the test life of a given metal preservative, and repeat tests by this test method in more than one cabinet are sometimes desirable.

4.4 The data obtained from this accelerated test is of interest only in eliminating the most unsuitable materials or for indicating a probable relative order of protection against rust under conditions of high humidity. This test method does not prescribe the exposure periods to be used for a specific product, nor the interpretation to be given to the results.

5. Apparatus

5.1 The apparatus shall conform to the details shown in the **Annex A1**.

6. Panel Cleaning Materials

6.1 Aluminum Oxide Cloth, 240 grit.

NOTE 1—Paper-backed abrasives, wet or dry, waterproof, or iron oxide abrasives are prohibited.

6.2 *Silica Sand*, white, dry, sharp, chloride free, or *aluminum oxide*, blasting grade. (The size shall be such that it meets the following sieve requirements of Specifications **E11** and **E323**.

6.2.1 One hundred percent must pass through a No. 10 (2.00 mm) sieve.

6.2.2 Minimum of 90 % must pass through a No. 20 (850 μm) sieve.

6.2.3 Maximum of 10 % permitted to pass through a No. 50 (300 μm) sieve.

6.3 *Cleaners*—Select a cleaning media and method, which is safe, non-chlorinated, non-film forming and which does not in any way attack or etch the surface chemically. In addition, no Class 1 ozone depleting substances conforming to Section 602(a) of the Clean Air Act Amendments of 1990 (42USC7671a) as identified in Section 326 of PL 102-484 should be used. Use a procedure as outlined in Test Method F22 to judge the merit of the selected cleaning technique.

NOTE 2—A typical solvent found acceptable for this purpose is hexane, heptane, or Stoddard solvent.

NOTE 3—The original precision was developed using a combination of petroleum naphtha and methanol. These are no longer used due to toxicity issues.

6.4 *Gauze*, lint free cotton or gauze pads.

7. Humidity Cabinet Operating Conditions

7.1 During evaluation of a sample the cabinet shall be run continuously with the following standard conditions being maintained:

Air temperature:	
Inside the cabinet	48.9 °C ± 1.1 °C (120 °F ± 2.0 °F)
Outside the cabinet	24.1 °C ± 5.5 °C (75.4 °F ± 10.0 °F)
Rate of air to the cabinet	
0.878 m ± 0.028 m ³ /h	(31.0 ft ± 1 ft ³ /h) at 25.0 °C and 760 mm Hg
Water in cabinet:	
Level	203.0 mm ± 6.4 mm (8.0 in. ± ¼ in.)
pH	5.5 to 7.5
Oil content	clear with no evidence of oil
Chlorides	less than 20 ppm (Test Methods D512)
Sulfates and sulfites ^A	less than 20 ppm as sulfate (Test Method D516)

Speed of rotating	0.33 r/min ± 0.03 r/min
Cover	close fitting
Cloth layers in cover	shall not be torn, contaminated, nor contain droplets of water
Cover opening	to a height of 355 mm (14 in.) at the front

^A Boil the water sample with 10 mL of saturated bromine water before making the test for sulfates.

7.2 Rate of air to the cabinet, air temperature, pH, and water level shall be checked and regulated if necessary twice each day, at 7 h to 8 h intervals. Remaining standard conditions shall be closely checked once each week. The pH measurement may be made with wide-range indicator paper.

NOTE 4—Values for pH outside the limits shown indicate contamination that should be investigated and corrected. A persistent low pH along with a positive sulfate test indicates that the air supply is contaminated with sulfur oxides. In this case, the water in the cabinet should be replaced, and a suitable alkali scrubber system installed in the air train.

NOTE 5—Details of the cabinet operation described in 7.1 and 7.2 and the details of panel preparation described in Section 8, must be carefully carried out. Only by such standardization can results be obtained that are significant and comparable to those run at another time or in another laboratory.

8. Panel Preparation

8.1 Remove the protective packaging from all the panels to be used for a particular day and wash away the rust preventive material in a beaker of solvent selected in 6.3 (swabbing is permissible using materials defined in 6.4). Carefully inspect each panel and use only those which comply with requirements given in **A1.10**. Identify each panel by an appropriate number in the right-hand lower corner, outside of the significant area, or by attaching a small metal tag to the outside wire hook after the panel is polished.

8.2 The following are pertinent to the polishing operations:

8.2.1 Do not allow the bare fingers to touch the panel. Tongs, metal hooks, or pieces of lint-free paper are suitable helpers for manipulating and holding the panel.

8.2.2 Always keep the panel on a clean, dry surface.

8.3 *Alternative Surface Finishes—Polishing*:

8.3.1 The amount of polishing of the panel by the operator conducting the humidity cabinet test should only be that required to give it a fresh, clean, and active surface. This requires only a few minutes per panel. A fast-moving belt sander should not be used since the heat of friction may change the surface characteristics of the panel. Surface finish limits for the panel are not defined here. There should be no appreciable change of the finish from the 0.25 μm to 0.51 μm (10 μm to 20 μm) obtained by the original surface grinding **A1.10.1.3**.

8.3.2 Divide the 240 grit aluminum oxide abrasive cloth into convenient size strips for the subsequent polishing operations. Observing the precautions given in 8.2 and 8.3, buff all four of the rounded edges with even strokes in the direction of each edge. Ream out the two holes used for suspension and wipe clean, using gauze wet with solvent selected in 6.3.

8.3.3 While polishing, place the panel on a clean, dry surface with a suitable thickness of clean paper under it to help prevent contamination. The panel may be held by hand, using paper between the fingers and the steel surface. Alternatively it may be held in a special holder such as a wooden block, having

about a 1.6 mm ($\frac{1}{16}$ in.) depression slightly larger in area than the 51 mm by 102 mm (2 in. by 4 in.) dimension of the panel. The abrasive cloth may be held in the palm of the hand with the fingers applying pressure to the panel. Alternatively, the aluminum oxide cloth may be held on a block of size convenient to the hand and convenient for polishing with smooth strokes without marking the ends of the panel.

8.3.4 Polish the unnumbered or leading surface of the panel with careful even strokes, always parallel to the 102 mm (4.0 in.) dimension. Do not scratch the surface by using short or curved strokes. Ensure that the panel is held firmly so that only the abrasive cloth moves. After several polishing strokes, inspect the abrasive cloth and when necessary make another fold to expose a new and effective area. Continue to polish the leading surface until it contains a completely fresh surface. The finish should be within the range from 0.25 μm to 0.51 μm (9.8 $\mu\text{in.}$ to 20.0 $\mu\text{in.}$) (rms). Examine the entire surface, and if scratches or other imperfections are noted, continue polishing until corrected. In the same manner polish the second side of the panel, unless the test specification requires only one polished side per panel.

NOTE 6—It is advisable for each operator to finish several panels to determine exactly what technique is required to attain the correct surface finish using a profilometer or other surface roughness gage. After techniques have been established, the use of visual comparison standards is sufficient as a check on surface roughness.

NOTE 7—Use a polishing load of about 4.5 N to 8.9 N (1.0 lb to 2.0 lb).

8.3.5 Remove the dust from the abrasive operation, using clean gauze wet with solvent selected in 6.3. Finally, wipe with clean surgical gauze until there is no dark stain on a clean section of the gauze. Remove any dust in the holes by use of a pipe cleaner. (This may be followed by an ultrasonic cleaning bath procedure.) Submerge the panel completely in solvent selected in 6.3 at room temperature.

NOTE 8—The following should be carried out periodically as a check on surface cleanliness: Place the cleaned panel directly under a buret on a table free of vibrations and drafts. Place the buret so that its tip is exactly 300 mm above the panel. The buret contains distilled water and shall have a tip of proper dimensions to deliver 0.05 mL \pm 0.01 mL of distilled water per drop. Allow one drop of distilled water to fall onto the panel surface. If the surface is absolutely clean, successive droplets on various parts of the surface will spread out completely in spots of closely reproducible dimensions. A clean panel should give a spread of 21 mm to 23 mm for each 0.05 mL of distilled water. This test is considered necessary and important because of variations found in different abrasive materials and the personal factors involved in the procedure require some method of check on final results. Panels used for this cleanliness check test are not suitable for use in the protection test.

8.3.6 To minimize differences in activity of the steel surfaces as a result of time in various air atmospheres, cleaning and polishing of the panels should be standardized in respect to time. For this reason, carry out the procedure described in 8.3.2 – 8.3.5 one panel at a time, and after each one is prepared, store it immediately in solvent selected in 6.3 at room temperature until all the panels for one day's operations are prepared.

8.3.7 Heat the solvent selected in 6.3 so that the solvent will evaporate from the panels immediately upon withdrawal from the solvent or dry the panels above a heat source so long as evaporation occurs in less than 10 s.

8.3.8 Remove remaining residue by holding the panels in a rack at 20° from the vertical and spraying downward with solvent selected in 6.3.

8.3.9 Spray the test surface, then the back of the panel, and the test surface again.

8.3.10 Rinse the panels in hot solvent selected in 6.3, and store in a desiccator with a humidity of less than 10 % R.H. until cool.

8.3.11 Use panels the same day as prepared.

8.4 *Alternative Surface Finishes—Aluminum Oxide Blasting:*

8.4.1 Blast the edges and lightly blast the backs of the panels with the blasting material.

8.4.2 Blast the unnumbered side, or test surface, of the panels to a fresh, uniformly abraded surface. (Operation 178 N to 356 N of the blasting equipment at 40 lb to 80 lb pressure and holding the workpiece approximately 51 mm to 76 mm (2 in. to 3 in.) from the nozzle.)

8.4.3 Immediately after blasting, place the panels in a beaker of nonreactive solvent or an ultrasonic cleaning bath containing nonreactive solvent.

8.4.4 Heat the solvent selected in 6.3 so that the solvent will evaporate from the panels immediately upon withdrawal from the solvent.

8.4.5 Remove remaining residue by holding the panels in a rack at 20° from the vertical and spraying downward with solvent selected in 6.3.

8.4.6 Spray the test surface, then the back of the panel, and the test surface again.

8.4.7 Rinse the panels in hot solvent selected in 6.3, and store in a desiccator until cool.

8.4.8 Panels are to be used the same day as prepared.

9. Procedure

9.1 Bring the sample oil to a temperature of 23.3 °C \pm 0.5 °C (74.0 °F \pm 1.0 °F) and pour into a clean, dry 400 mL tall-form glass beaker (for example, borosilicate glass) to a height of at least 114 mm (about 375 mL). By use of one clean suspension hook remove a panel from the methanol and hang it in the vapor space above boiling solvent selected in 6.3 for 5 min, ensuring that the panel is completely wet with the refluxing solvent.

NOTE 9—Cleaning the panel with solvent vapors is conveniently done using approximately 100 mL of solvent selected in 6.3 in a 400 mL to 600 mL tall-form beaker. Perform this operation in a well-ventilated hood and make sure there are no sources of ignition in the area. Heat-resistant glass beakers have been used for this purpose, but use of a metal beaker is preferred from the standpoint of possible breakage.

9.2 Then slush the panel for 10 s in a beaker of boiling solvent selected in 6.3. Withdraw it from the solvent and observe for any stains on the surfaces, with attention to any contamination from the holes. If stains are present, repeat the panel preparation beginning at 8.3.2 or 8.4.1. After 10 s to 20 s in the air, place the clean panel in the sample oil and agitate for 10 s while it is submerged in the oil. Withdraw the panel with a continuous motion, drain for 10 s, and replace in the sample oil for 1 min with slight agitation. Remove from the test oil with a continuous motion, taking from 2 s to 4 s. Handle the

panel carefully and do not jar nor shake it. Dip the end of a second clean suspension hook into the sample oil and insert it into the second hole of the panel. Drain the panel suspended by two hooks in the box described in the **Annex A1 (Fig. A1.6)**, at a temperature of $24.1\text{ }^{\circ}\text{C} \pm 3.0\text{ }^{\circ}\text{C}$ ($75.4\text{ }^{\circ}\text{F} \pm 5.0\text{ }^{\circ}\text{F}$) for $2\text{ h} \pm 20\text{ min}$, unless another draining time is specified (see **Note 10**). More than one panel may be dipped in one beaker of the test oil, provided the temperature of the test oil does not rise above $23.8\text{ }^{\circ}\text{C}$ ($74.8\text{ }^{\circ}\text{F}$). If this occurs, then dip subsequent panels in a second beaker of the test oil at $23.3\text{ }^{\circ}\text{C} \pm 0.5\text{ }^{\circ}\text{C}$ ($73.9\text{ }^{\circ}\text{F} \pm 1.0\text{ }^{\circ}\text{F}$).

NOTE 10—Sample holders, rates of removal of panel from the test sample, and draining time for some preservatives may differ from those given above—in accordance with particular specifications. For example, for some of the more highly compounded preservatives that have been cut back with volatile solvents, the panel is removed using two hooks at the rate of 102 mm (4 in.)/min, and a $24\text{ h} \pm 1\text{ h}$ draining period is used.

9.3 At the end of the draining period, suspend the panels in the humidity cabinet described in **Annex A1**, with the “back,” that is, the numbered side of the panel, trailing as the stage rotates. Allow the one or more test panels treated with the sample oil to remain in the humidity cabinet for the number of hours specified. Maintain operating conditions as specified in **Section 7**.

9.4 Open the humidity cabinet twice each day, concurrent with the inspections defined in **7.2** as follows: (1) For a 15 min period during the first inspection, and (2) for a 5 min period during the second inspection. Generally, it will be found convenient to do the inspection of panels during the 15 min opening, and the insertion of new panels during the 5 min opening. To standardize the effect of panel cooling and other variables, keep the cabinet open for the entire 15 min and 5 min periods, even though the time required to inspect or install panels may be less. The front edge of the cover should be propped open to a distance of 356 mm (14 in.) from the top of the cabinet.

9.5 Panels being evaluated against specified times in the cabinet should not be withdrawn, except at the end of the required time. Panels used in hours-to-failure evaluations, such as in developmental studies, should be very carefully withdrawn and inspected one at a time: a panel should not leave the cabinet, except for the actual time each day required for its inspection.

10. Examination

10.1 Remove the panels at the completion of the specified time in the cabinet. Wash them with solvent selected in **6.3**, and within 10 min, examine each one under a fluorescent light for pass or failure as follows:

10.2 Consider the significant area, as indicated in the **Annex A1 (Fig. A1.5)** of each side of each panel as a separate test surface; each panel thus represents two test surfaces. Rate each test surface as follows:

10.2.1 *Pass*—A test surface shall pass if it contains no more than three dots of rust, no one of which is larger than 1 mm in diameter.

10.2.2 *Fail*—A test surface shall fail if it contains one or more dots of rust larger than 1 mm in diameter or if it contains four or more dots of any size.

10.3 Alternately, the panels may be rated for pass or failure in accordance with the criteria stated in the specification or requirement for which the method is being used.

11. Report

11.1 The report shall include the following:

11.1.1 Hours in the humidity cabinet,

11.1.2 Number of test surfaces (or panels),

11.1.3 Number of passing test surfaces (or panels), and

11.1.4 Type of panel preparation (sandblasted, aluminum oxide blasted, or polished).

NOTE 11—This test method is intended as a detailed standardized procedure for running the humidity test. Whether a metal preservative passes or fails the test depends upon the criteria given in the specification or requirement for which the test method is being used.

12. Precision and Bias⁷ (See 4.4)

12.1 This test method is believed to represent the best available practice. Operational procedures that might affect precision have been defined as closely as appears practicable.

12.2 **Table 1** summarizes the effect of panel preparation on the repeatability and reproducibility of Test Method D1748 (95 % confidence level).

13. Keywords

13.1 humidity; humidity cabinet; metal preservatives; rust protection

⁷ Supporting data have been filed at ASTM International Headquarters and may be obtained by requesting Research Report RR:D02-1136. Contact ASTM Customer Service at service@astm.org.

TABLE 1 Panel Preparation

	Sandblasted, % ^A	Al ₂ O ₃ Blasted, %	Polished, %
Repeatability	27.8	46.1	97.3
Reproducibility	141.0	71.2	264.0

^A The sandblasted panels used in obtaining the precision data all came from one source.

ANNEX

(Mandatory Information)

A1. HUMIDITY CABINET APPARATUS

A1.1 Location

A1.1.1 The location of the humidity cabinet shall provide for continuous controlled operation during the test. The humidity cabinet shall be in a room maintained at a temperature between 24.1 °C ± 5.5 °C (75.4 °F ± 10.0 °F). The room shall be free of strong air drafts and of exposure to any acid fumes or gases known to promote corrosion, such as sulfur dioxide, hydrogen sulfide, ammonia, and so forth.

A1.2 Humidity Cabinet

A1.2.1 The equipment used in this test method is the humidity cabinet conforming to Annex A1. The general arrangement of the cabinet components is shown in Fig. A1.1. It consists of a metal-lined cabinet, with the open top equipped with a hinged lid consisting of two thicknesses of desized airplane cloth. The cabinet holds approximately 94.0 L (24.8 gal) of distilled water, up to the prescribed level automatically maintained during operation. The water is heated by means of electric immersion heaters to maintain an air temperature of 48.9 °C ± 1.1 °C (120.0 °F ± 2.0 °F) above the water at operating conditions. The temperature is controlled by means of a thermostat located in the air space and an auxiliary thermostat located under the water level to prevent temperature overshoot. Air is introduced under the water by means of a circular manifold and air-diffuser stones. A rotating stage, from which test panels are suspended, is provided within the air space of the cabinet, and rotates at 0.33 r/min ± 0.03 r/min. A drip pan is provided to prevent contamination of the distilled water by catching the oil and condensed water from the panels.

A1.3 Cabinet Cover

A1.3.1 The cover shall consist of a metal frame on which are tautly secured two thicknesses of desized cotton cloth conforming to Military Specification MIL-C-5646F. The cloth shall have a regular, standard, commercial finish with no added materials that would lessen its wetting-out properties. The double thickness of cloth on the cover serves to permit free exit of air from the cabinet, while preventing drippage of condensed moisture onto the test panels. The cover shall provide a tight seal all the way around the top of the cabinet. If the cover becomes warped, it shall be held down with spring clamps. The

cloth should be changed at six-month intervals, or sooner, if it becomes ripped or soiled.

A1.4 Water Level Control

A1.4.1 The water level is held automatically at the 203.0 mm (8.0 in.) level, which is at the top of the shoulder of the central shaft. The level control provided with the cabinet is satisfactory if a continuous supply of distilled water is available, with the excess not required for makeup being rejected to waste lines. When these conditions do not exist, a level control must be provided so as to operate from carboys of distilled water. Fig. A1.2 shows a satisfactory arrangement.

A1.5 Heaters and Control

A1.5.1 The cabinet is provided with a heater system that will control the air temperature at 48.9 °C ± 1.1 °C (120.0 °F ± 2.0 °F).

NOTE A1.1— An overtemperature controller is provided that will break the heater circuit if the water temperature exceeds the thermostat setting. This thermostat is regulated so as to be within the range from 50.0 °C to 52.1 °C (122.0 °F to 125.8 °F). Breaking of the circuits by the thermostat is indicated by a pilot light, which should be red so as to indicate failure or overshoot.

A1.6 Air Supply and Metering System

A1.6.1 The air supply should deliver a constant flow of air that is free of oil and industrial fumes, particularly gases that promote corrosion, such as compounds containing sulfur, chloride, or nitrogen. The system supplying air to the humidity cabinet shall be capable of maintaining a minimum air pressure of 50 psig (345 kPa).

A1.6.2 The air metering system shall provide means of regulating and filtering the air and shall supply the air at a rate of 0.878 m³/h ± 0.02832 m³/h (31 ft³/h ± 1 ft³/h) at 25 °C and 760 mm.

A1.7 Air Manifold and Diffusers

A1.7.1 The air to the cabinet shall be distributed by means of a ring manifold near the bottom of the cabinet with 20 air diffuser stones spaced equally around the ring as shown in Fig. A1.1. Diffuser stones should be connected to the ring by the

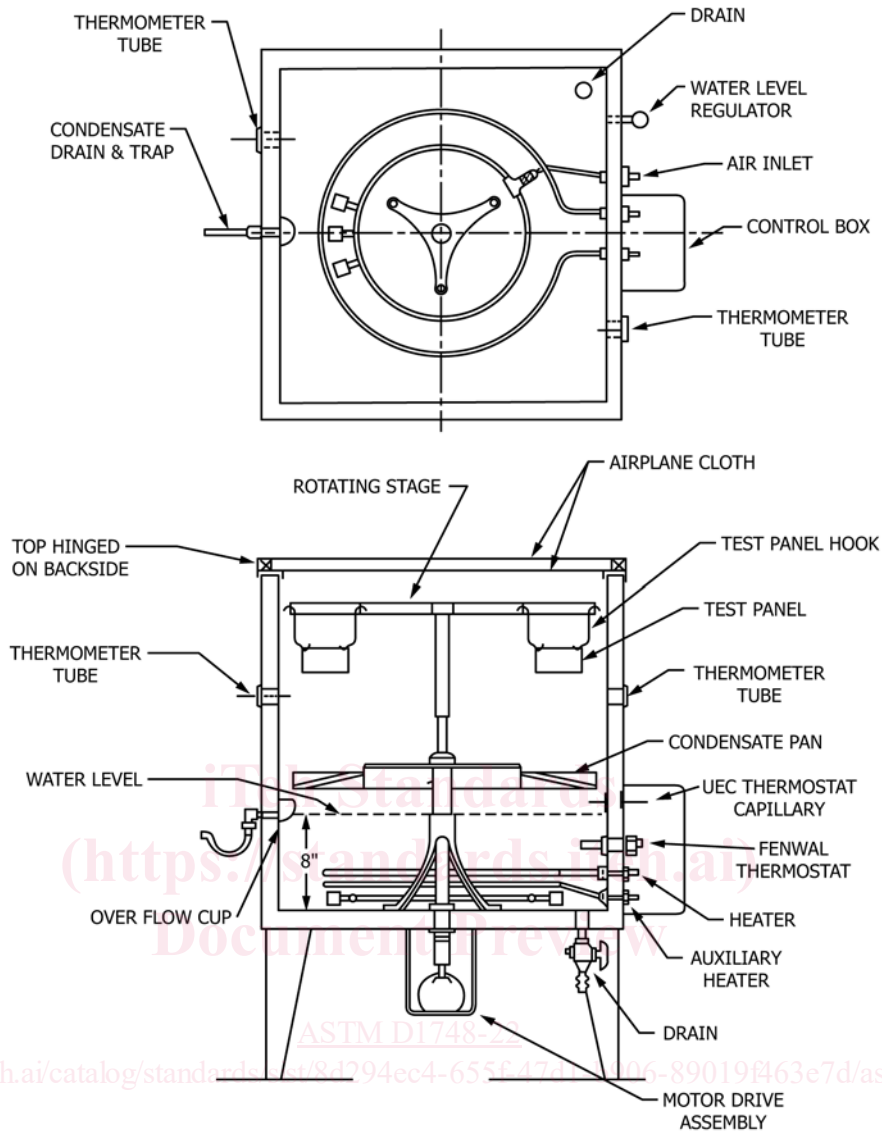


FIG. A1.1 Humidity Cabinet

use of vinyl tubing. These stones should be inspected periodically to detect possible plugging.

A1.8 Rotating Stage

A1.8.1 The steel test panels shall be suspended in the humidity cabinet on the rotating stage as shown in Fig. A1.3. It shall rotate at $0.33 \text{ r/min} \pm 0.03 \text{ r/min}$ by use of an electric motor as shown in Fig. A1.1.

A1.9 Drip Pan

A1.9.1 A circular drip pan shall be mounted under the rotating stage, as shown in Fig. A1.1, to catch any oil and condensed water dripping from the panels. Liquid from the drip pan shall be piped to a drain outside the cabinet.

A1.10 Steel Panels

A1.10.1 Only panels that meet the following manufacturing requirements shall be used:

A1.10.1.1 Dimensions shall be 51.0 mm by 102.0 mm by 3.2 mm (2.0 in. by 4.0 in. by $\frac{1}{8}$ in.) (maximum) with two holes of from 3.2 mm to 2.3 mm ($\frac{1}{8}$ in. to $\frac{3}{32}$ in.) in diameter in the corners along one 102.0 mm (4.0 in.) (maximum) edge. They shall weigh $110 \text{ g} \pm 15 \text{ g}$.

A1.10.1.2 Panels shall be fabricated from openhearth, "killed" type low-carbon, No. 4 soft-temper, cold-rolled sheet or strip steel in accordance with Specification A109/A109M, or Federal Specification QQ-S-698 and SAE 1009C or from Aircraft Steel to BS 5.511. Cold-drawn bar stock is not satisfactory.

A1.10.1.3 All edges of the panel shall be fully rounded. Faces of the test panels must be entirely free of pits, scratches, rust, or other imperfections. They shall be prepared by surface grinding in the direction of the 102 mm (4 in.) dimension to a finish of from 250 nm to 500 nm (10 $\mu\text{in.}$ to 20 $\mu\text{in.}$) (rms). The profilometer reading should be taken across the panel, that is, in a direction parallel to the 51 mm (2 in.) edge.

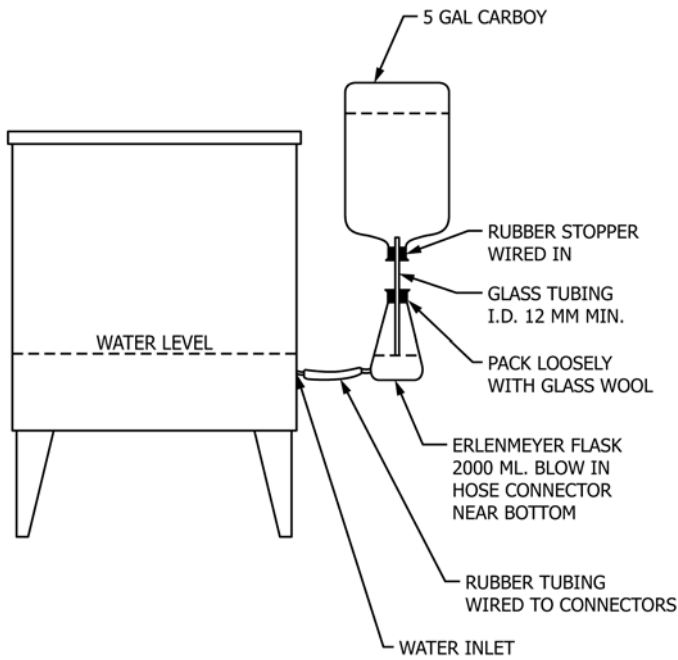


FIG. A1.2 Water Level Regulating System (Alternative)

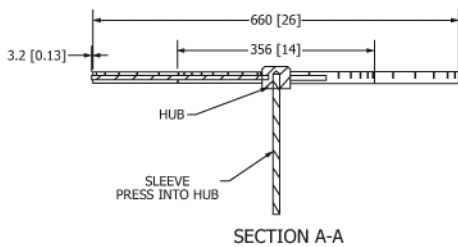
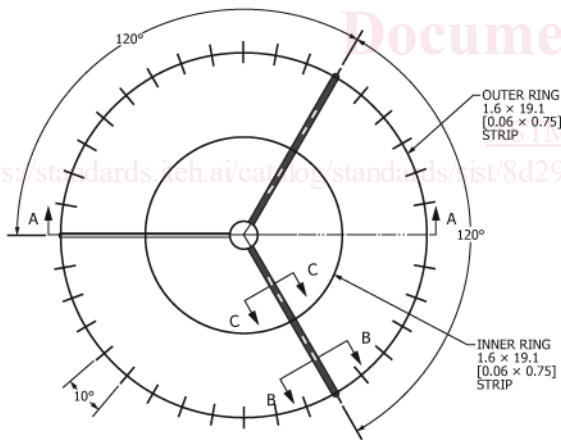
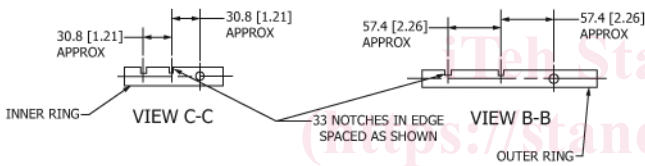


FIG. A1.3 Rotating Stage

A1.10.2 If the finishing operation is done with aqueous coolants, the panels should be treated with a water-displacing compound. If contaminated with fingerprints, these should be

removed from the test panels by use of fingerprint removing compound conforming to Specification MIL-C-15074E.

A1.10.3 Immediately after the panels have been properly finished, the manufacturer shall coat them with nonvolatile, water-insoluble-type rust-preventive material and place them in a moisture-proof package for shipment.

NOTE A1.2—Panels from a previous test run may be used provided they contain only rust stains that are easily removed by abrading with 240 grit aluminum cloth. Do not use panels with rust pits.

A1.11 Dummy Panels

A1.11.1 These panels shall fill spaces on the rotating stage that are not occupied by test panels. They shall also be placed under the three arm supports of the rotating stage. The dummy panels shall be fabricated from stainless steel or poly(methyl methacrylate) (PMMA) and have the same dimensions as the test panels.

A1.12 Suspension Hooks

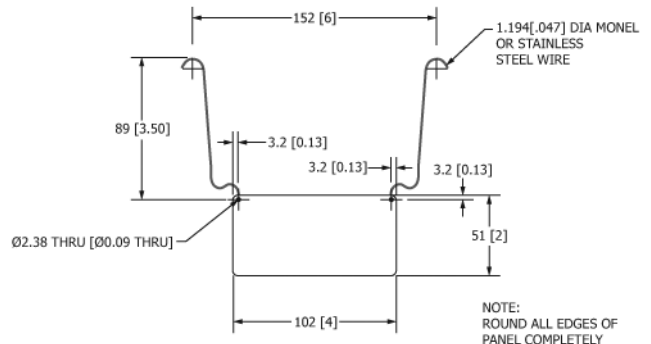
A1.12.1 Test panels shall be suspended by use of hooks made from 1.19 mm (0.047 in.) diameter Monel or stainless-steel wire as shown in Fig. A1.4 (see also Fig. A1.5). They are designed so that water condensed on the hooks and rotating stage will not run down onto the panels, but will drip off the lower bend of the hooks. To insulate the panel from the cabinet, place about 25.0 mm (1.0 in.) of insulating tube over the end of the wire that hangs onto the rotating stage.

A1.13 Chamber For Panel Draining

A1.13.1 After dipping in the test material, the panels shall be drained in a box having details similar to those shown in Fig. A1.6. A removable top of the box shall consist of a frame with two thicknesses of cheesecloth stretched across it to allow for evaporation of solvents from the test material. If the ambient humidity is above 50 %, a tray containing saturated magnesium nitrate solution shall be placed in the bottom of the box.

A1.14 Additional Apparatus

A1.14.1 *Profilometer*, or other suitable means for periodically checking the surface of representative test panels should be available.



WEIGHT OF PANEL: 110±15g[3.88±.53oz]
THICKNESS OF PANEL: 3.2[.13]

FIG. A1.4 Panel and Suspension Hooks