



Designation: D4541 – 22

# Standard Test Method for Pull-Off Strength of Coatings Using Portable Adhesion Testers<sup>1</sup>

This standard is issued under the fixed designation D4541; 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 ( $\epsilon$ ) indicates an editorial change since the last revision or reappraisal.

## 1. Scope\*

1.1 This test method covers a procedure for evaluating the pull-off strength (commonly referred to as adhesion) of a coating system from metal substrates. Pull-off strength of coatings from concrete is described in Test Method D7234. This test offers two test protocols. Protocol 1 (test to fracture) determines the greatest perpendicular force (in tension) that a surface area can bear before a plug of material is detached. Protocol 2 (pass/fail) determines if the coated surface remains intact at a defined load criteria. Fracture will occur along the weakest plane within the system comprised of the test fixture, glue, coating system, and substrate, and will be exposed by the fracture surface. This test method maximizes tensile stress as compared to the shear stress applied by other methods, such as scratch or knife adhesion, and results may not be comparable.

NOTE 1—The procedure in this standard was developed for metal substrates, but may be appropriate for other rigid substrates such as plastic and wood. Factors such as loading rate and flexibility of the substrate must be addressed by the user/specifier.

NOTE 2—The procedure in this standard was developed for use on flat surfaces. The results could have greater variability with lower values and averages for surfaces other than flat.

1.2 Pull-off strength measurements depend upon material, instrumentation and test parameters. Results obtained by each test method may give different results. Results should only be assessed for each test method and not be compared with other instruments. There are five instrument types, identified as Test Methods B-F. It is imperative to identify the test method used when reporting results.

NOTE 3—Method A, which appeared in previous versions of this standard, has been eliminated as its main use is for testing on concrete substrates (see Test Method D7234).

1.3 This test method describes a class of apparatus known as portable pull-off adhesion testers.<sup>2</sup> They are capable of applying a concentric load and counter load to a single surface so

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

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<sup>2</sup> The term adhesion tester may be somewhat of a misnomer, but its adoption by two manufacturers and at least two patents indicates continued usage.

that coatings can be tested even though only one side is accessible. Measurements are limited by the strength of adhesive bonds between the loading fixture and the specimen surface or the cohesive strengths of the glue, coating layers, and substrate.

1.4 This test can be destructive and spot repairs may be necessary.

1.5 The values stated in either SI units or inch-pound units are to be regarded separately as standard. The values stated in each system are not necessarily exact equivalents; therefore, to ensure conformance with the standard, each system shall be used independently of the other, and values from the two systems shall not be combined.

1.6 *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, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

1.7 *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:<sup>3</sup>

- D2651 Guide for Preparation of Metal Surfaces for Adhesive Bonding
- D3933 Guide for Preparation of Aluminum Surfaces for Structural Adhesives Bonding (Phosphoric Acid Anodizing)
- D7234 Test Method for Pull-Off Adhesion Strength of Coatings on Concrete Using Portable Pull-Off Adhesion Testers
- E691 Practice for Conducting an Interlaboratory Study to Determine the Precision of a Test Method

<sup>3</sup> 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.

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

### 3. Summary of Test Method

3.1 The general pull-off test is performed by securing a loading fixture (dolly, stud) normal (perpendicular) to the surface of the coating with a glue. After the glue is cured, a testing apparatus is attached to the loading fixture and aligned to apply tension normal to the test surface. The force applied to the loading fixture is then gradually and uniformly increased and monitored until either the loading fixture is detached, or a specified load value is reached and the test terminated. The two common uses of this test are test to fracture (Protocol 1), and pass/fail testing (Protocol 2). Test to fracture is used to determine a maximum load that can be achieved when a plug of material is detached with the selected testing parameters. Pass/fail is used to verify the results of a testing procedure can meet a minimum load criterion. When the loading fixture is detached, the exposed surface represents the plane of limiting strength within the system. The nature of the plane of fracture is qualified in accordance with the percent of adhesive and cohesive failures, and the actual interfaces and layers involved. The reported load is computed based on the maximum indicated load, the instrument calibration data, and the original surface area stressed. Results obtained using different test devices will vary because the results depend on instrumentation parameters. Variations in results are also expected when tests are performed under different test procedures or environmental conditions (see 4.2).

### 4. Significance and Use

4.1 The pull-off strength of a coating is a performance property that may be referenced in specifications. This test method serves as a means for uniformly preparing and testing coated surfaces, and evaluating and reporting the results. This test method is applicable to any portable apparatus meeting the requirements for determining the pull-off strength of a coating in this standard (see Annex A1 – Annex A5).

4.2 Variations in results with the same coating are likely when any parameter of the test is changed. This includes change in glue, load fixture size, substrate coating cure time, pull rate, environmental conditions, if the coating is scored, or using a different device. Therefore, when a series of results will be compared with one another or used for statistical analysis, the type of apparatus, substrate, test procedures, glue type, and if scoring is used should be the same for the pulls considered.<sup>4</sup> It is recommended that these parameters and the environmental conditions allowed during the test be mutually agreed upon between the interested parties.

4.3 The purchaser or specifier shall designate a specific test method procedure; B, C, D, E, or F and test Protocol; 1, or 2, when calling out this standard. In cases where either the Protocol or a pass/fail criterion is not designated, Protocol 1 shall be used.

<sup>4</sup> Reference to potential variability of the adhesion test has been made in various publications, including the assessment of variability completed for the test method found in ASTM Research Report RR:D01-1147.

### 5. Apparatus

5.1 *Adhesion Tester*, commercially available, or comparable apparatus to the specific examples listed in Annex A1 – Annex A5.

5.1.1 *Loading Fixtures*, having a flat surface on one end that can be adhered to the coating and a means of attachment to the tester on the other end. Optimal size of the loading fixture is determined by the adhesion tester capabilities. The fixture and tester combination should be chosen so that the expected maximum pull load the coating will be subjected to during the test is within the range of the tester.

5.1.2 *Detaching Assembly* (adhesion tester), having a central grip for engaging the fixture.

5.1.3 *Base*, on the detaching assembly, or an annular bearing ring if needed for uniformly pressing against the coating surface around the fixture either directly, or by way of an intermediate bearing ring. A means of aligning the base is needed so that the resultant force is normal to the surface.

5.1.4 Means of moving the grip away from the base to allow the loading of the fixture in as smooth and uniform a manner as possible and so that a torsion free, co-axial (opposing pull of the grip and push of the base along the same axis) force results between them.

5.1.5 *Timer*, or means of limiting the loading rate. A timer is the minimum equipment when used by the operator along with the force indicator in 5.1.6.

5.1.6 *Force Indicator and Calibration Information*, for determining the actual force delivered to the loading fixture.

5.2 *Solvent*, or other means for cleaning the loading fixture surface. Finger prints, moisture, oxides, and dust tend to be the primary contaminants.

5.3 *Sandpaper*, or other means, used to roughen the surfaces for glue application and adherence to the coating. When using sandpaper it is recommended to use 100 grit or finer.

5.4 *Glue*—the material used for securing the loading fixture to the coating. Two component epoxies and cyanoacrylates are two commonly used glues. Select a glue that does not affect the coating properties, flow through the coating or attack the coating.

5.5 *Clamps*, magnetic, mechanical, tape or similar, if needed for holding the fixture in place while the glue cures.

5.6 *Cotton Swabs*, or other means for removing excess glue and defining the adhered area. Any method for removing excess glue that damages the surface, such as scoring (see 6.7), must generally be avoided since induced surface flaws may cause premature failure of the coating.

5.7 *Scoring Tool*, circular hole cutter, or similar tool to score the coating to the substrate around the loading fixture.

### 6. Test Preparation

6.1 The method for selecting the coating sites to be prepared for testing depends upon the objectives of the test and agreements between the contracting parties. There are, however, a few physical restrictions imposed by the general method and apparatus. The following requirements apply to all sites:

6.1.1 The selected test area must be large enough to accommodate the specified number of replicate tests. The surface may have any orientation with reference to gravitational pull. Each loading fixture must be separated by at least the distance needed to accommodate the detaching apparatus. For Protocol 1 or to statistically characterize a test area, three or more replications are required.

6.1.2 The selected test areas must also have enough perpendicular and radial clearance to accommodate the apparatus, be flat enough to permit alignment, and be rigid enough to support the counter force. It should be noted that measurements close to an edge may not be representative of the coating as a whole.

6.2 Since the rigidity of the substrate affects results of the test and is not a controllable test variable in field measurements, some knowledge of the substrate thickness and composition should be reported for subsequent analysis or laboratory comparisons. For example, steel substrate of less than 3.2 mm ( $\frac{1}{8}$  in.) thickness usually reduces test results compared to 6.4 mm ( $\frac{1}{4}$ -in.) thick steel substrates.

6.3 Subject to the requirements of 6.1, select representative test areas and clean the surfaces in a manner that will not affect integrity of the coating or leave a residue. To reduce the risk of glue fracture affecting the test, the surface of the coating can be lightly abraded to promote adhesion of the glue to the surface. If the surface is abraded, care must be taken to prevent significant loss of coating thickness. Clean the area to remove particulates after abrading. Use of a solvent may be necessary to remove all contaminants. If a solvent is required, select one that does not compromise the integrity of the coating.

6.4 Clean the loading fixture surface as indicated by the apparatus manufacturer. Failures at the fixture-glue interface can often be avoided by treating the fixture surfaces in accordance with an appropriate ASTM standard practice for preparing metal surfaces for glue bonding.

NOTE 4—Guides D2651 and D3933 are typical of well-proven methods for improving adhesive bond strengths to metal surfaces.

6.5 Prepare the glue in accordance with the glue manufacturer's recommendations. Apply the glue to the fixture or the surface to be tested, or both, using a method and thickness recommended by the glue manufacturer. Be certain to apply the glue across the entire fixture surface. Position the fixture on the surface to be tested. Carefully remove any excess glue from around the fixture. (**Warning**—Movement, especially twisting, can cause tiny bubbles to coalesce into large holidays that constitute stress discontinuities during testing which may lead to glue fracture.)

6.6 Based on the glue manufacturer's recommendations and the anticipated environmental conditions, allow enough time for the glue to cure. During the glue set and early cure stage, a constant contact pressure should be maintained on the fixture. Magnetic or mechanical clamping systems work well, but systems relying on tack, such as masking tape, should be used with care to ensure that they do not relax with time and allow air to intrude between the fixture and the test area.

6.7 When scoring around the test surface is agreed upon between the purchaser and seller, extreme care is required to

prevent micro-cracking in the coating or glue, since such cracks may cause reduced values. Scored samples constitute a different test procedure, and should be clearly reported with the results. Scoring may be required for thick-film coatings, reinforced coatings and elastomeric coatings. Scoring, if performed, can be completed before or after the load fixture is glued to the coating. When performed, scoring shall be done in a manner that ensures the cut is made normal to the coating surface, in a manner that does not twist or torque the test area or impart the loading fixture, and minimizes heat generation, edge damage, or microcracks to the coating or glue and the substrate. For thick coatings it is recommended to cool the coating and substrate during the cutting process with water lubrication.

NOTE 5—A template made from wood with a hole of the same size as the scoring tool drilled through it and secured to the surface may be an effective method to limit sideways movement of the scoring tool.

NOTE 6—Scoring requirements will vary depending on coating system, chemistry, and thickness. A direct comparison of the unscored result to a scored result is one method to determine if scoring should be performed. Other methods for making this determination may be employed with agreement between the purchaser and seller. Scoring should not be considered for coatings less than 20 mils.

6.8 Note the approximate temperature, relative humidity, and other pertinent environmental conditions during the time of test.

## 7. Test Procedure

7.1 Test Methods:

7.1.1 *Test Method A (discontinued).*

7.1.2 *Test Method B — Fixed Alignment Adhesion Tester Type II:*

7.1.2.1 Operate the instrument in accordance with **Annex A1**.

7.1.3 *Test Method C — Self-Alignment Adhesion Tester Type III:*

7.1.3.1 Operate the instrument in accordance with **Annex A2**.

7.1.4 *Test Method D — Self-Alignment Adhesion Tester Type IV:*

7.1.4.1 Operate the instrument in accordance with **Annex A3**.

7.1.5 *Test Method E — Self-Alignment Adhesion Tester Type V:*

7.1.5.1 Operate the instrument in accordance with **Annex A4**.

7.1.6 *Test Method F — Self-Alignment Adhesion Tester Type VI:*

7.1.6.1 Operate the instrument in accordance with **Annex A5**.

7.2 Select an adhesion-tester with a detaching assembly and loading fixture size that has a force calibration spanning the range of expected values. Mid-range measurements are recommended, but read the manufacturer's operating instructions before proceeding. The adhesion tester shall be calibrated at the lesser of the manufacturer's recommended frequency or every three years.



7.3 If a bearing ring or comparable device (5.1.3) is to be used, place it concentrically around the loading fixture on the coating surface. If shims are required when a bearing ring is employed, place them between the tester base and bearing ring rather than on the coating surface.

7.4 Carefully connect the central grip of the detaching assembly to the loading fixture without bumping, bending, or otherwise prestressing the sample and connect the detaching assembly to its control mechanism, if necessary. For nonhorizontal surfaces, it may be necessary with some devices to support the detaching assembly so that its weight does not impact the loading fixture and contribute to the force exerted in the test. Follow the manufacturer’s recommendations.

7.5 Align the device according to the manufacturer’s instructions and set the force indicator to zero.

NOTE 7—Proper alignment is critical. If alignment of the device is required, use the procedure recommended by the manufacturer of the adhesion tester and report the procedure used.

7.6 Increase the load to the fixture in as smooth, consistent, and uniform a manner and rate as possible. The rate of pull shall be 1 MPa/s (150 psi/s) or less. The rate should be set so that the test is completed in less than 100 seconds. If multiple tests are required, the rate of pull shall be similar for each test.

NOTE 8—A change in load fixture size may result in a change in the rate of pull depending on the equipment used. A change in rate of pull or load fixture size will result in variation of results.

7.7 The test is completed when the fixture is detached from the substrate, pass/fail test criteria is met or maximum pull strength for the instrument is reached. For pass/fail tests, the test may be terminated at any point after the test criterion has been reached.

7.8 Record information required for the Report (see Section 9).

7.9 If a plug of material is detached, label and store the fixture for qualification of the failed surface in accordance with 8.3.

7.10 Report any departures from the procedure such as possible misalignment, hesitations in the force application, etc.

## 8. Calculation or Interpretation of Results

8.1 If instructed by the instrument manufacturer, use the instrument calibration factors to convert the indicated load for each test into the actual load applied.

8.2 Either use the calibration chart supplied by the manufacturer or compute the relative load applied to each coating sample as follows:

$$X = 4F/\pi d^2 \quad (1)$$

where:

$X$  = greatest mean pull-off load applied during a pass/fail test, or the pull-off load achieved at fracture. Both have units of MPa (psi),

$F$  = actual load applied to the test surface as determined in 8.1, and

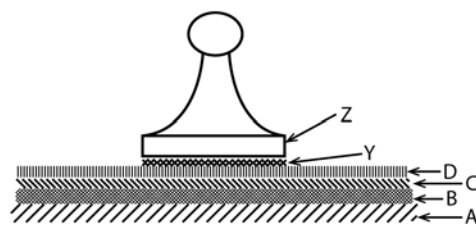


FIG. 1 Specimen Description

$d$  = equivalent diameter of the original surface area stressed having units of millimeters (inches). This is usually equal to the diameter of the loading fixture.

8.3 For tests where the load fixture becomes detached from the tested surface, visually estimate the percent of coating adhesive and cohesive fracture and glue failure in accordance to their respective areas and location within the test system comprised of coating and glue layers. Glue fracture or failure is defined as a visible separation of the glue from itself, the coating or load fixture. A convenient scheme that describes the total test system is outlined in 8.3.1 through 8.3.3.

8.3.1 Describe the specimen as substrate A, upon which successive coating layers B, C, D, etc., have been applied, including the glue, Y, that secures the fixture, Z, to the top coat (Fig. 1).

8.3.2 Designate cohesive fractures by the layers within which they occur as B, C, D, Y, etc., and the visually estimated percent of each.

8.3.3 Designate adhesive fractures and glue failure by the interfaces at which they occur as A/B, B/C, C/D, Y/Z, etc., and the visually estimated percent of each.

8.4 A result that appears to be significantly different from other results (see repeatability limits in 10.1.1) may be caused by a mistake in test procedure performance, recording or calculating. If any of these are not the cause, then examine the experimental circumstances surrounding this run. If an irregular result can be attributed to an experimental cause, drop this result from the analysis. However, do not discard a result unless there are valid nonstatistical reasons for doing so or unless the result is a statistical outlier. Valid nonstatistical reasons for dropping results include alignment of the apparatus that is not normal to the surface, poor definition of the area stressed due to improper application of the glue, poorly defined glue lines and boundaries, holidays in the glue caused by voids or inclusions, improperly prepared surfaces, improperly scored surfaces, varying the rate of loading during the test, varying the rate of loading between tests, and sliding or twisting the fixture during the initial cure. Scratched or scored samples may contain stress concentrations leading to premature fractures.

8.5 Document any test where the load limit of the testing equipment is reached.

8.6 Protocol 1 (Test to fracture) see Fig. 2 Flow Chart.

8.6.1 Unless otherwise agreed to between the purchaser and seller, disregard test results with visually estimated glue fracture greater than 1/4 of the loading area. Use caution when using data from tests that include any visible glue fracture or

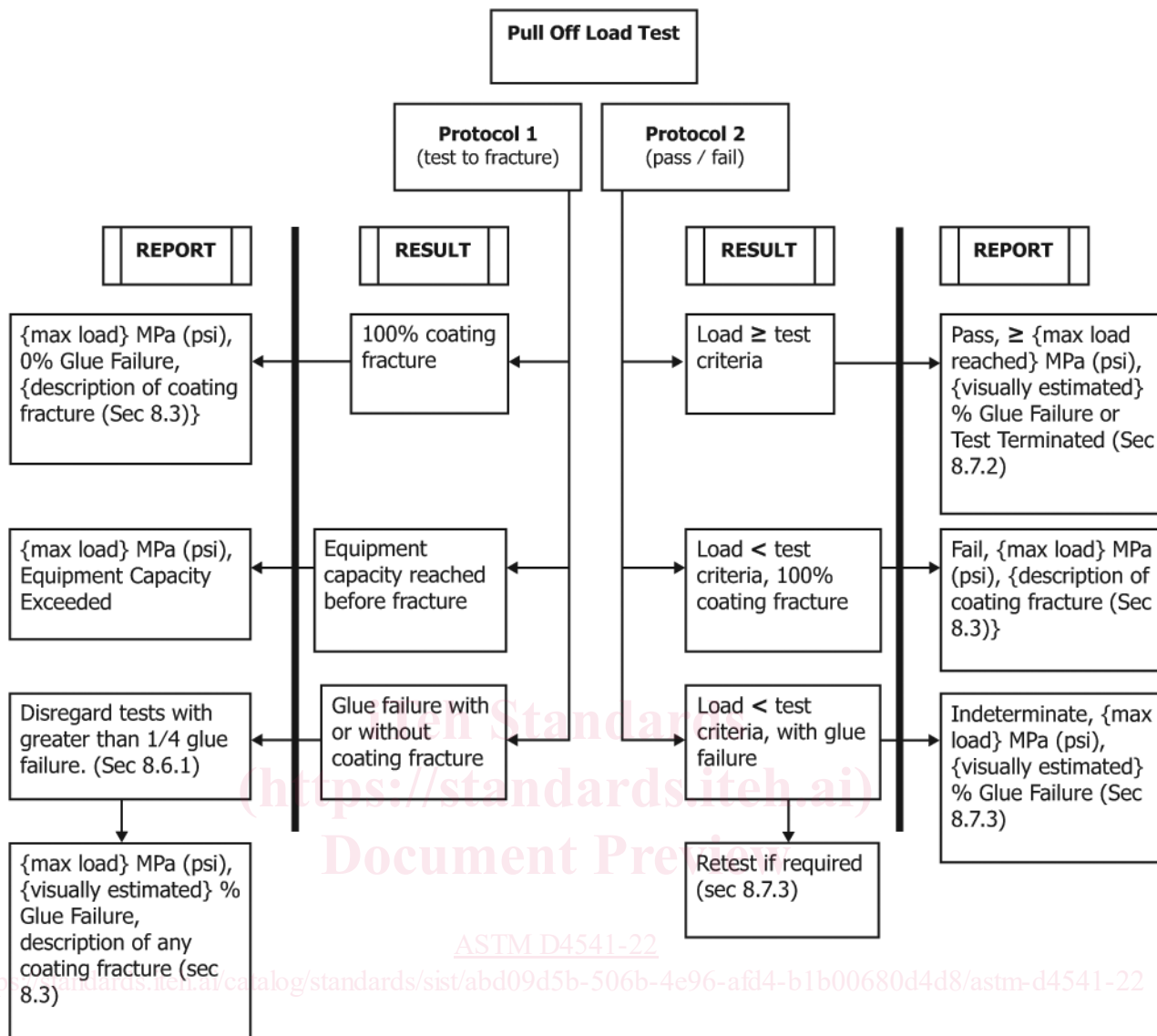


FIG. 2 Flow Chart

where the equipment capacity is exceeded for analysis as the results may not be statistically relevant.

8.7 Protocol 2 (Pass/fail test), see Fig. 2 Flow Chart.

8.7.1 The test can be terminated after the minimum criterion has been met.

8.7.2 A test is passing when the maximum load applied is greater than or equal to the pass/fail criteria.

8.7.3 If the maximum load is less than the pass/fail criteria, the test is either a failing test or an indeterminate test due to glue fracture. A test result is indeterminate when there is a visible amount of glue fracture (visibly detectable glue fracture is defined as glue failure of 5 % or more of the loading area) that occurred during the test and the maximum load is less than the pass/fail criteria. An indeterminate test may be redone to determine a passing or failing result. If the test is redone, and glue fracture persists at a load below the test criteria, review

the test procedure and make adjustments to reduce glue fracture or indicate the test is indeterminate.

NOTE 9—Any amount of glue fracture will result in a reduction of the maximum test load measured by the testing apparatus

NOTE 10—When subjected to pull-off loads, an elastomeric coating may elongate, and if the elongation or strain is sufficient, then the failure can be induced by a simulated peel type load starting at the edges of the scored sample. To reduce this effect proper scoring and test fixture alignment techniques should be employed. As well, low loading rates should be avoided to reduce the time the elastomeric coating is under stress. These factors do not preclude pull-off strength testing of elastomeric materials but should be noted when evaluating results.

## 9. Report

9.1 Report the following information:

9.1.1 Date, test location, testing agent,

9.1.2 Brief description of the general nature of the test, such as, field or laboratory testing, generic type of coating, etc.

9.1.3 Temperature and relative humidity and any other pertinent environmental conditions during the test period.

9.1.4 Description of the apparatus used, including: apparatus manufacturer and model number, last calibration date, loading fixture type and dimensions, and bearing ring type and dimensions.

9.1.5 Description of the test system, if possible, by the indexing scheme outlined in 8.3 including: product identity and generic type for each coat and any other information supplied, and the substrate identity (thickness, type, orientation, etc.).

9.1.6 Glue used and cure time before test.

9.1.7 Method used to secure the loading fixture during glue cure, if any.

9.1.8 Rate of pull.

9.1.9 Test results.

9.1.9.1 Detailed test results as described in Fig. 2, Flow Chart.

NOTE 11—When testing in a specific location, the highest results obtained may be the most representative. The most common errors made during the testing process lead to artificially lower results, typically not higher results. Characterizing a test area based on an apparent low or high individual result should be done with caution.

9.1.9.2 If corrections of the results have been made, or if certain values have been omitted such as the lowest or highest values or others, reasons for the adjustments and criteria used.

9.1.9.3 For any test where scoring was employed, indicate it by placing a footnote superscript beside each data point affected and a footnote to that effect with information of the scoring apparatus used at the bottom of each page on which such data appears.

9.1.9.4 Note any other deviations from the procedure.

NOTE 12—Use caution with statistical analysis of data, such as averaging of results, for test results that include glue failure, termination of the test, or exceeding the capacity of the test equipment. The reported load for these types of test results are not representative of the maximum load capacity of the coating tested.

## 10. Precision and Bias<sup>5</sup>

10.1 The precision of this test method is based on an interlaboratory study of Test Method D4541 conducted in 2006, using the parameters of Test Method D4541 – 09.<sup>6</sup> Analysts from seven laboratories tested six different coatings applied to ¼ in. thick hot-rolled carbon steel plates using five different adhesion testers. Every “test result” represents an individual determination. In order to standardize and balance the data, any pull which exceeded the tester’s upper limit with the available accessories at the time of testing was eliminated from the statistical analysis. Any pull in which there was 50 % or more glue fracture was also eliminated from the statistical analysis. If four valid pulls were obtained from one operator for a given material, the fourth was eliminated and the first three valid replicate test results (from one operator) for each material were included in the statistical analysis. Practice E691

<sup>5</sup> Supporting data have been filed at ASTM International Headquarters and may be obtained by requesting Research Report RR:D01-1147. Contact ASTM Customer Service at service@astm.org.

<sup>6</sup> Scotch Weld 420, available from 3M, Adhesives, Coatings and Sealers Div., 3M Center, St. Paul, MN 55144, was used in the Interlaboratory Study round robin.

TABLE 1 Adhesion Testing Method B, Pull-Off Strength (psi)

Coating	Average	Repeatability	Reproducibility	Repeatability	Reproducibility
		Standard Deviation	Standard Deviation	Limit	Limit
	$\bar{x}$	sr	sR	r	R
B	1195	278	330	777	925
C	549	109	117	305	326
D	1212	412	483	1155	1351
E	1385	192	276	537	774

Coating	Average	Repeatability Limit		Reproducibility Limit	
		$\bar{x}$	r	R	% of average
B	1195	777	69.1	925	77.4
C	549	305	55.6	326	59.0
D	1212	1155	95.3	1351	111.5
E	1385	537	38.8	774	55.9
Avg.			64.7		76.0

was followed for the design and analysis of the data; the details are given in Research Report No. RR:D01-1147.

NOTE 13—The pull-off strength of two of the coatings, identified during the round robin as Coating A and Coating F, exceeded the measurement limits of the testers with the accessories available at the time of testing, and were therefore eliminated from the statistical analysis.

10.1.1 *Repeatability*—Two test results obtained within one laboratory shall be judged not equivalent if they differ by more than the “r” value for that material; “r” is the interval representing the critical difference between two test results for the same material, obtained by the same operator using the same equipment on the same day in the same laboratory.

10.1.1.1 Repeatability limits are listed in Tables 1-5.

10.1.2 *Reproducibility*—Two test results shall be judged not equivalent if they differ by more than the “R” value for that material; “R” is the interval representing the difference between two test results for the same material, obtained by different operators using different equipment in different laboratories.

10.1.2.1 Reproducibility limits are listed in Tables 1-5.

10.1.3 Any judgment in accordance with these two statements would have an approximate 95 % probability of being correct.

10.2 *Bias*—At the time of the study, there was no accepted reference material suitable for determining the bias for this test method, therefore no statement is being made.

10.3 The precision statement was determined through statistical examination of 394 results, produced by analysts from seven laboratories, on four coatings, using five different instruments. Different coatings were used as a means to achieve a range of pull-off strengths covering the operating range of all the instruments.

10.3.1 Results obtained by the same operator using instruments from the same Method should be considered suspect if they differ in percent relative by more than the Intralaboratory values given in Table 6. Triplicate results obtained by different operators using instruments from the same Method should be considered suspect if they differ in percent relative by more than the Interlaboratory values given in Table 6.

## 11. Keywords

11.1 adhesion; coatings; field; metal substrates; paint; portable; pull-off strength; tensile test

**TABLE 2 Adhesion Testing Method C, Pull-Off Strength (*psi*)**

Coating	Average	Repeatability Standard Deviation	Reproducibility Standard Deviation	Repeatability Limit	Reproducibility Limit
	$\bar{x}$	sr	sR	r	R
B	1974	261	324	732	907
C	1221	136	548	382	1535
D	2110	252	316	706	886
E	2012	239	359	669	1004
Coating	Average	Repeatability Limit		Reproducibility Limit	
	$\bar{x}$	r	% of average	R	% of average
B	1974	732	37.1	907	45.9
C	1221	382	31.3	1535	125.7
D	2110	706	33.5	886	42.0
E	2012	669	33.3	1004	49.9
Avg.			30.4		70.5

**TABLE 3 Adhesion Testing Method D, Pull-Off Strength (*psi*)**

Coating	Average	Repeatability Standard Deviation	Reproducibility Standard Deviation	Repeatability Limit	Reproducibility Limit
	$\bar{x}$	sr	sR	r	SR
B	2458	146	270	408	755
C	1232	31	116	87	324
D	2707	155	233	434	651
E	2354	163	273	456	764
Coating	Average	Repeatability Limit		Reproducibility Limit	
	$\bar{x}$	r	% of average	R	% of average
B	2458	408	16.6	755	30.7
C	1232	87	7.1	324	26.3
D	2707	434	16.0	651	24.0
E	2354	456	19.4	764	32.5
Avg.			14.8		28.4

**TABLE 4 Adhesion Testing Method E, Pull-Off Strength (*psi*)**

Coating	Average	Repeatability Standard Deviation	Reproducibility Standard Deviation	Repeatability Limit	Reproducibility Limit
	$\bar{x}$	sr	sR	r	SR
B	2210	173	215	483	601
C	1120	115	155	321	433
D	2481	361	422	1011	1181
E	2449	173	198	485	555
Coating	Average	Repeatability Limit		Reproducibility Limit	
	$\bar{x}$	r	% of average	R	% of average
B	2210	483	21.9	601	27.2
C	1120	321	28.7	433	38.7
D	2481	1011	40.7	1181	47.6
E	2449	485	19.8	555	22.7
Avg.			27.8		34.1