



Designation: D3260 – 01 (Reapproved 2005)

Standard Test Method for Acid and Mortar Resistance of Factory-Applied Clear Coatings on Extruded Aluminum Products¹

This standard is issued under the fixed designation D3260; 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 evaluation of the mortar and acid resistance of clear protective coating factory applied to extruded aluminum substrates.

1.2 The values stated in SI units are to be regarded as the 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 establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 *ASTM Standards:*²

[C207 Specification for Hydrated Lime for Masonry Purposes](#)

[D823 Practices for Producing Films of Uniform Thickness of Paint, Varnish, and Related Products on Test Panels](#)

3. Summary of Test Method

3.1 Panels that have been buffed, cleaned, neutralized, and coated with the material being evaluated are exposed to freshly prepared mortar and to a hydrochloric acid solution.

4. Significance and Use

4.1 This test method will provide differentiation between types of coatings for acid and motor resistance providing the coating is applied in a uniform continuous film with a specified film thickness.

¹ 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 D01.55 on Factory Applied Coatings on Preformed Products.

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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.

5. Reagents

5.1 *Acid*—Ten volume percent solution of commercial grade hydrochloric acid (31.4 to 31.8 % HCl, 20°Bé) in distilled water.

5.2 *Cleaning Solution*—An alkaline cleaner³ in the concentration recommended by the manufacturer, usually 45 to 60 g/L (6 to 8 oz/gal) of water. The pH of the solution should be between 11.4 and 12.2.

5.3 *Lime*—Building lime complying with Specification [C207](#).

5.4 *Neutralizing Solution*—Prepare from a stable free-flowing, granular material having a chromate base⁴ as recommended by the supplier, usually at a concentration of 90 to 120 g/L (12 to 16 oz/gal) of water.

5.5 *Sand*—Dry sand capable of passing through a 10-mesh wire screen.

6. Test Panels

6.1 Panels of extruded aluminum alloy No. 6063-T5 with dimensions 150 by 75 by 6.3 mm (6 by 3 by ¼ in.) shall be used for the test.

7. Procedure

7.1 *Preparation of Test Panels:*

7.1.1 Buff the aluminum panels and remove the buffing compound with an organic solvent.

7.1.2 Immerse the panels in cleaning solution (5.2) for 1 h at a temperature of 93°C (200°F).

7.1.3 Rinse the panels in tap water having a pH of 6.5 to 7.5 until the surface is free of water break. Use reagent water for rinsing if the pH of the tap water is outside the specified limits. The panels shall be free from evidence of corrosion or surface attack.

7.1.4 Immerse the panels in neutralizing solution (5.4) at 24 ± 1°C (75 ± 2°F) for 30 s to neutralize any retained alkalinity and to promote adhesion of the applied coatings.

³ Diversey No. 808 has been found satisfactory for this purpose.

⁴ Diversey No. 814 has been found satisfactory for this purpose.