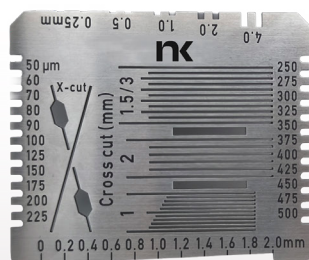


ADHESION

CC2400 MULTIFUNCTION PLATE

Tool for adhesion testing using the cross-hatch or Saint Andrew's cross method.



STANDARDS

ISO 2409 · ISO 2808 · ASTM D3359 · DAIMLER DBL 5417 · 7384

The multifunction plate or comb is a very practical tool for inspectors, applicators and painting professionals in the field. It is also suitable for use in the automotive sector, the coatings industry, construction, maintenance, galvanising, laboratories, painting, the property sector, the shipbuilding industry and steel protection

APPLICATION

This pocket-sized device enables the following tests to be carried out:

- Cross-hatch adhesion testing, with the option to make cuts of 1, 1.5, 2 and 3 mm.
- Measurement of the thickness of fresh coatings from 50 to 500 microns. ISO 2808.
- Progressive applicator from 0 to 2000 microns.
- Flatness test, which provides an indication of the coating's viscosity.
- Cross-hatch or St Andrew's cross scratching for adhesion and corrosion testing.

GENERAL FEATURES

Multifunctional stainless steel measuring tool. Enables on-site testing, assessment or measurement of: paint adhesion testing at 1, 2 and 3 mm, Saint Andrew's cross (X-cut), measurement of wet film thickness from 50 to 225 µm, checking for correct edge coverage, film application from 250 to 500 µm, as well as an indication of coating levelling. The kit includes tape for carrying out the test in accordance with ISO 2409.

This pocket-sized device allows the following tests to be carried out:

- Cross-cut adhesion test with the option of making cuts at 1, 1.5, 2 and 3 mm.
- Measurement of the thickness of fresh coatings from 50 to 500 micrometres. ISO 2808.
- Progressive application from 0 to 2000 microns.
- Flatness test, which provides an indication of the coating's viscosity.
- Cross-hatch or St Andrew's cross scratching for adhesion and corrosion testing.

In accordance with ISO 2409: 1 mm for coatings up to 60 µ, 2 mm for coatings up to 120 µ, 3 mm for coatings from 120 µ to 250 µ, and 1.5 mm for special applications. For coatings thicker than 250 µ, make a cross-cut.

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INSTRUCTIONS FOR USE

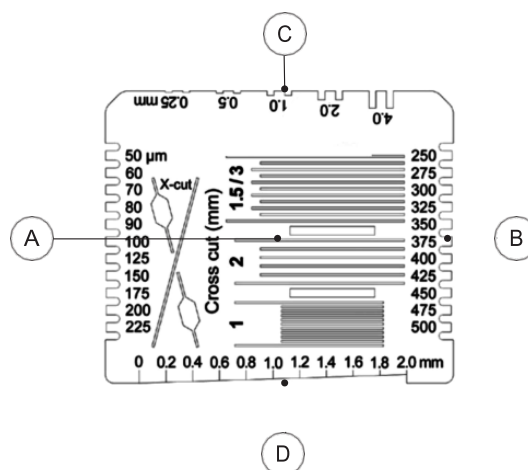
A) Central area: Adhesion test using a grid cut and a cross-cut or St Andrew's cross cut.

Parallel blade guide slots of 6 x 1 and 6 x 1.5 mm. Cut through the coating only down to the substrate. According to ISO 2409, 1 mm for coatings up to 60 µ, 2 mm for coatings up to 120 µ, 3 mm for coatings from 120 µ to 250 µ and 1.5 mm for special applications. For coatings thicker than 250 µ, perform the cross-cut.

B) Side areas: thickness in fresh coatings

C) Top area: Levelling

D) Lower area: Progressive applicator



Classification of results according to ISO 2409:

Table 1 – Classification of test results

Category	Description	Appearance of the surface of the grid area with flaking* (example for six parallel incisions)
0	The edges of the incisions are perfectly smooth; no squares in the grid have come away.	
1	Slight flaking of the coating is observed at the intersections of the incisions. The affected area of the grid is less than 5 per cent.	
2	Peeling of the coating is observed at the edges and/or at the intersections of the incisions. The affected grid area is more than 5 per cent, but less than 15 per cent.	
3	The coating has flaked off partially or completely in large strips along the edges of the incisions and/or has flaked off partially or completely in various parts of the squares. The affected area of the grid is more than 15 per cent but less than 35 per cent.	
4	The coating has flaked off in large strips along the edges of the incisions and/or some squares have become partially or completely detached. The affected area of the latticework is more than 35 per cent but less than 65 per cent.	
5	A higher degree of flaking is observed than in category 4.	-

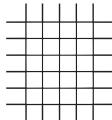
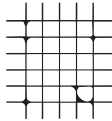
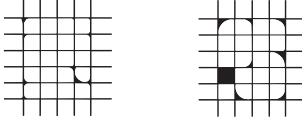
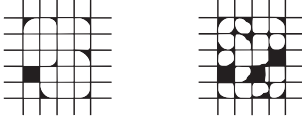
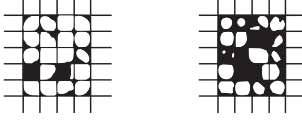
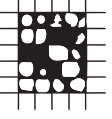
* The figures are examples of a grid within each category. The percentages shown are based on the visual impression conveyed by the images, and these same percentages will not necessarily be reproducible using digital images.

ADHESION

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Classification of results according to ASTM D3359:

Table 1 – Classification of test results

Classification	Percentage of detached area	Appearance of the grid-patterned cut area with delamination for six parallel cuts and adhesion range by percentage
5B	0 % (None)	
4B	Less than 5%	
3B	5–15 %	
2B	15–35 %	
1B	35–65 %	
0B	Over 65%	

MODELS

Code	Description
NK-CC2400	CC2400 Multifunction plate, cross-cut tester CC2000, X-cut, includes tape to ISO 2409

The supply includes: metal plate or gauge, cutter, 5 spare blades, wet thickness gauge, Plate, Cross-cut, X-cut or Saint Andrew cut, leveller, progressive applicator in accordance with ISO 2409, ASTM 3359, DAIMLER DBL 5416 and 7384. ISO 2409 tape, carry case, manual.



ACCESSORIES

Standardised adhesive tapes available in accordance with ISO 2409 or manufacturers' specifications (FORD, Renault, Opel, Volkswagen).

Code	Description
NK-CC2409	Adhesive tape in accordance with ISO 2409
NK-CC2401	Cutter