

The field adhesion test procedure presented here is based on the methods published in ASTM D4541 Standard Test Method Pull Off Adhesion Strength of Coatings Using Portable Adhesion Testers. Minimum pull off adhesion strength per AAMA is 16.0psi. Be aware that any failure exhibited when pulled beyond the 16.0 psi requirement is considered acceptable including failure of the underlying substrate.

Tools/Material required (See figure 1):

- 1: **Magnet** (min. 20 lbs. pull) with eye bolt
- 2: **Scale with carabiner or locking clip** (min. 20 lbs. capacity)
 - Ultimate 54 Portable Digital Scale as shown below: https://www.amazon.com/Ultimate54-Portable-Multifunction-Backlight-Capacity/dp/B017PQFXU8/ref=sr_1_2?ie=UTF8&qid=1483546943&sr=8-2&keywords=Ultimate54
- 3: **1" x 1" steel coupon**
 - Near white blast finish (free all visible oil, grease, dust, dirt, mill scale, rust, coating, oxides, corrosion products and other foreign matter).
- 4: **Pecora XL-Flash Liquid Flashing** (20oz sausage)



Fig. 1



Fig. 2



Fig. 3

Field Pull Off Adhesion Strength Test Procedure:

1. Locate a 6" x 6" unobstructed area to perform the adhesion test. Testing should be completed on each type of substrate coated with a Pecora air barrier and/or liquid flashing.
2. Clean the fully cured air barrier/flashing with a solvent wipe (isopropyl or denatured alcohol preferred) and allow to dry.
3. Apply a small dollop of Pecora XL-Flash to the surface that will allow full embedment of the 1"x1" steel coupon.
4. Apply the 1" x 1" steel coupon firmly into the wet XL-Flash allowing for slight squeeze out. Allow for an approximately 1/8" film of adhesive between the substrate and coupon. See figure 2.
5. Allow the XL-Flash to fully cure a minimum 24 - 48 hrs. Low ambient temperatures (<50F) will extend the cure time.
6. Lightly score around the entire perimeter of the steel coupon down to substrate. See figure 3.
 - a. If applied over an exterior grade gypsum sheathing substrate avoid cutting into the gypsum core.
7. Attach the magnet centered on the coupon.
8. Attach the scale to eyelet and begin the test by pulling the scale at a slow and steady rate. See figure 4. When a measurement of ≥ 16.0 psi is achieved you may cease pulling on the fixture as the AAMA minimum requirement has been met and the application is considered acceptable.

Note: Once testing is concluded removal of the coupon is not necessary. Seal the edges of the coupon with XL-Flash, Pecora AVB Silicone, or a detail coat of air barrier coating.



Fig. 4

