Project Title: Salt spray test supplied bolts from Al Rashed	**Date:** 16/01/18
LWR Reference: 12706	**Customer:** Al Rashed Fasteners
System: Xylar 2 & Xylan 1070	**Coating Application:Spray**
Authors: AS	**Copy List:**

Background and Objectives

Samples received from Al Rashed for salt spray testing. DFT, adhesion and cure to be tested prior to salt spray.

Conclusions and Recommendations

All parts cured, passing test with minimal colour transfer (TM115B).

All parts showed optimal adhesion results after cross-hatch adhesion testing (TM132C, ASTM 5).

DFT analysis showed part was within recommended specification (Measured:40 micron, Recommended: 45 micron).

Parts have completed 10000 hours salt spray testing (ASTM B117) with approximately 12% red rust on both bolt.

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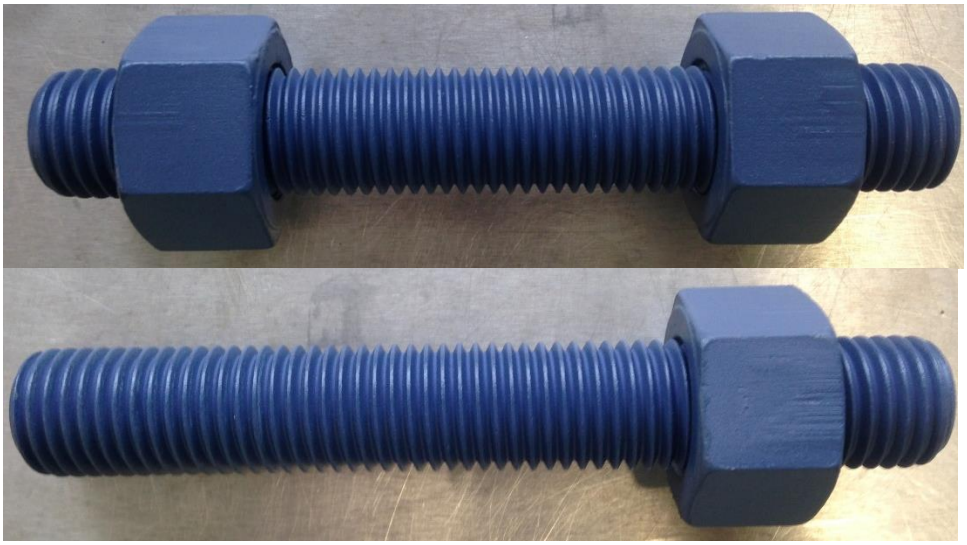
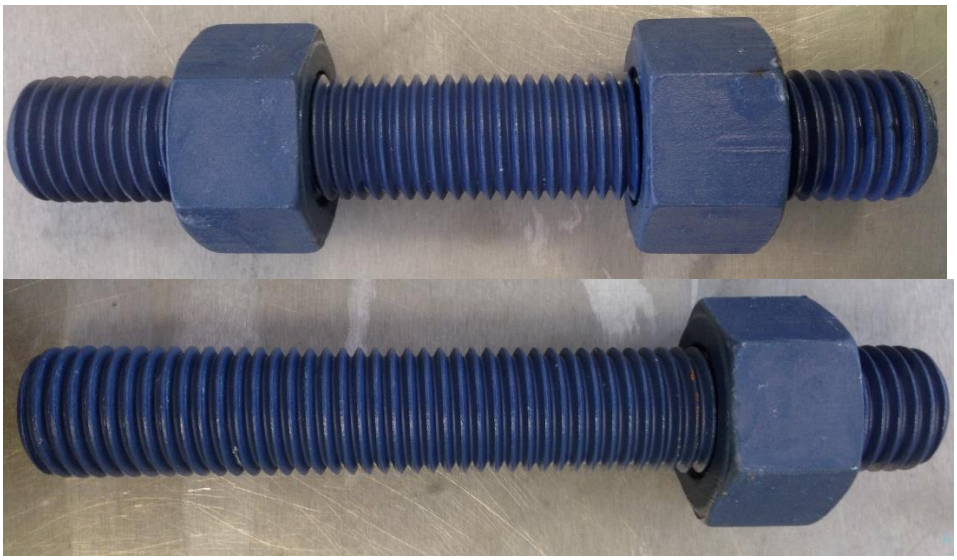
Results and Discussion

Parts passed cure test, with minimal colour transfer. (TM115B)
Parts achieved optimal results from a cross-hatch adhesion test (TM 132C), ranking ASTM 5.
DFT analysis showed part was within recommended specification (Measured:40 micron, Recommended: 45 micron).

0 hours



600 hours



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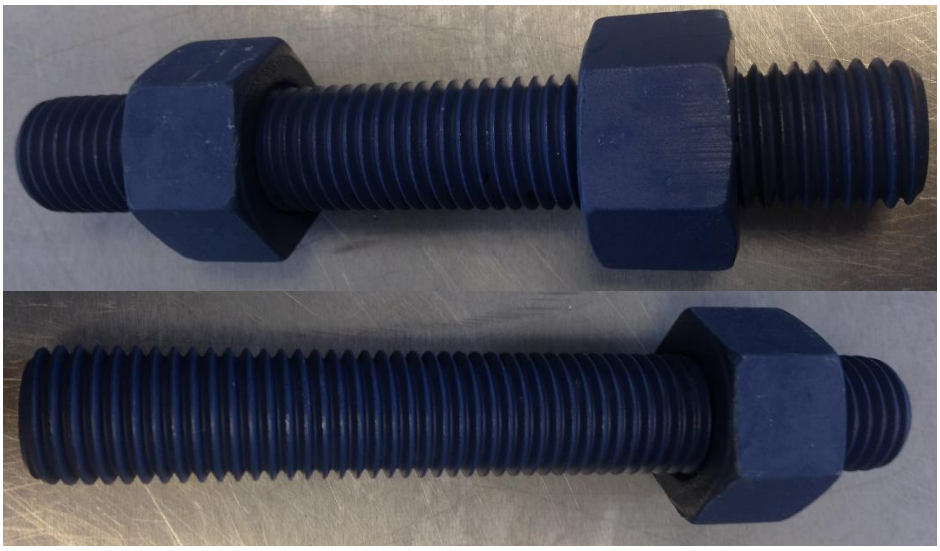
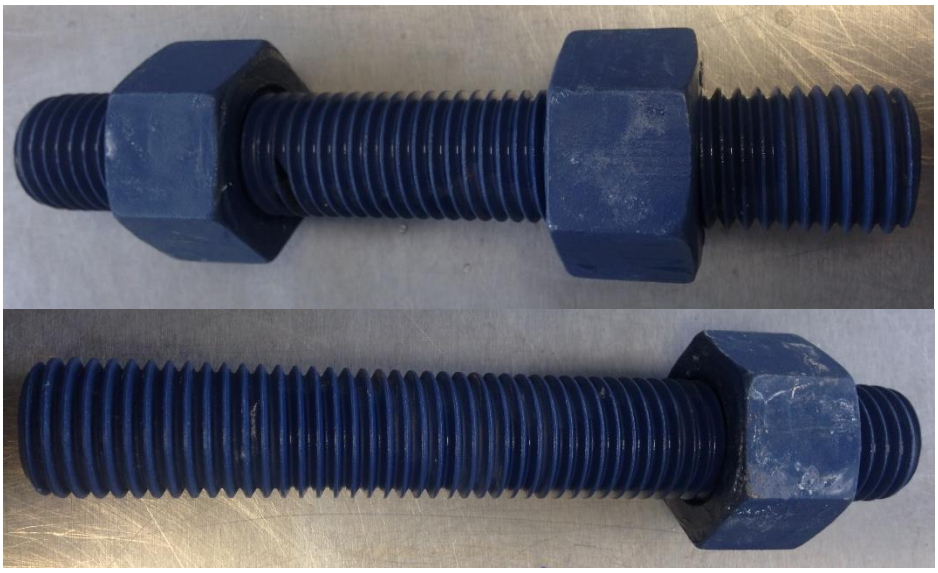
936 hours



1656 hours



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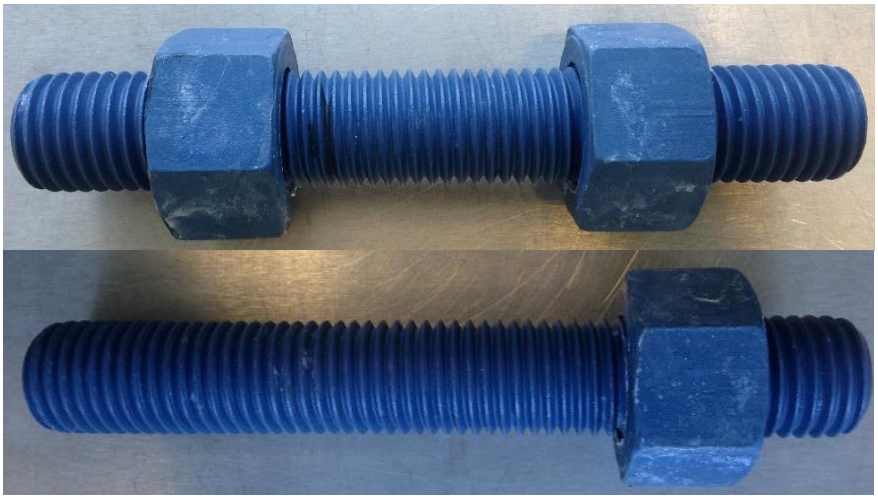
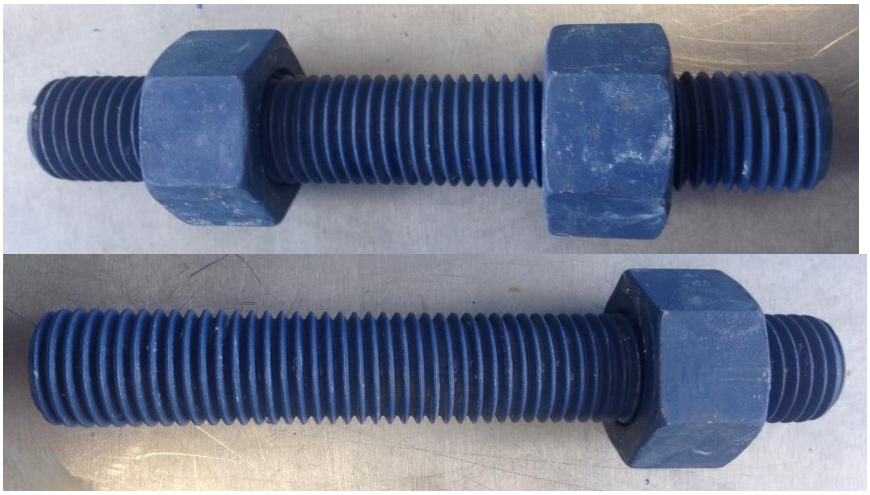
1992 hours



3000 hours



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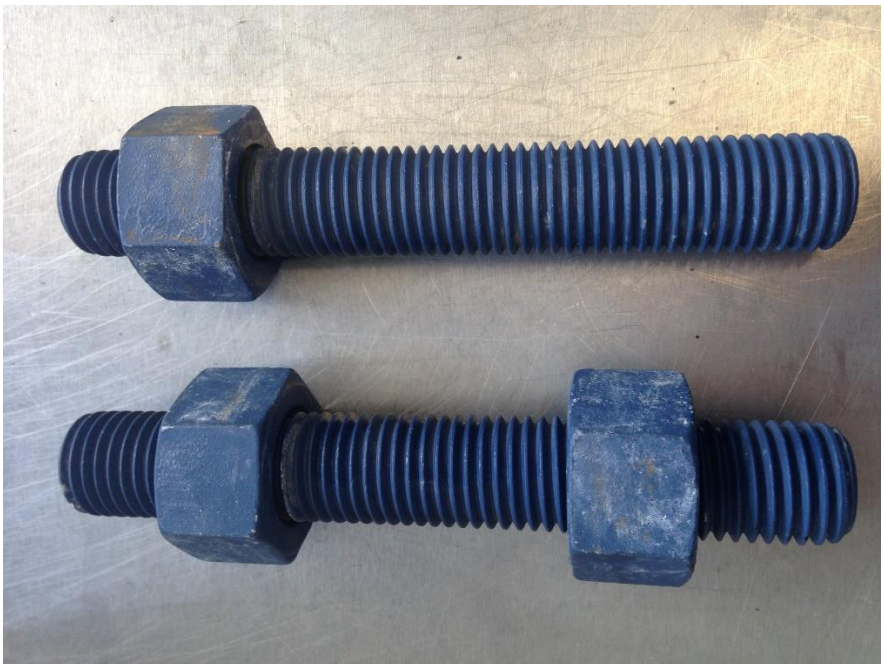
4008 hours

5016 hours



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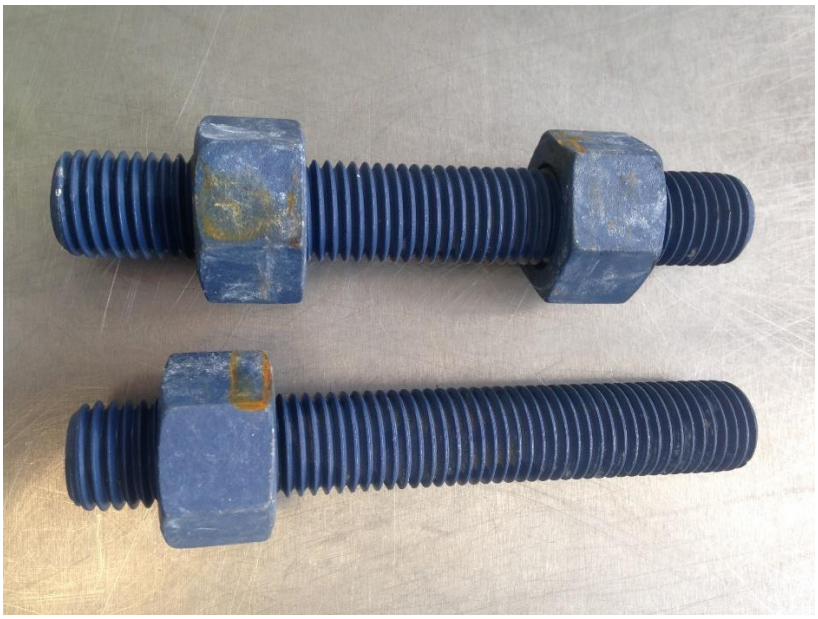
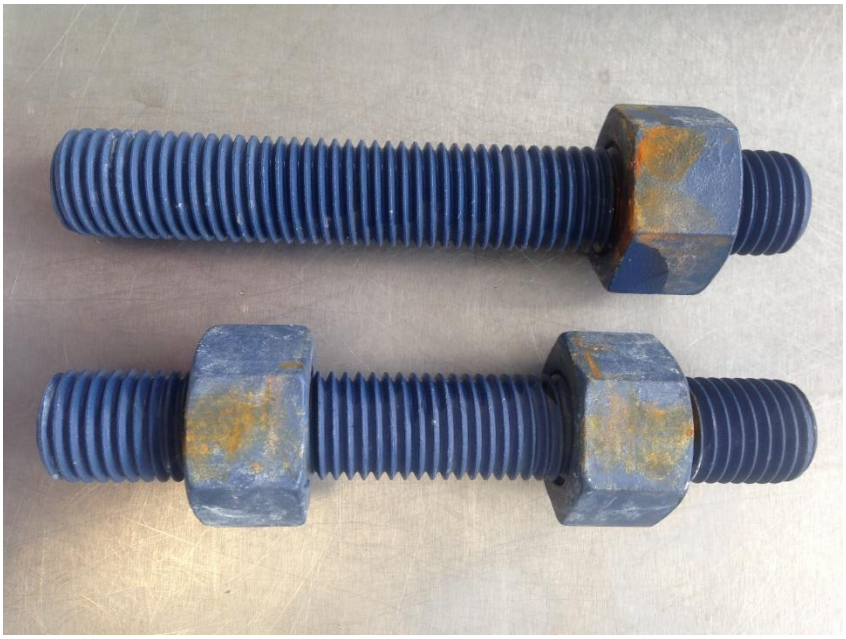
6024 hours



7032 hours



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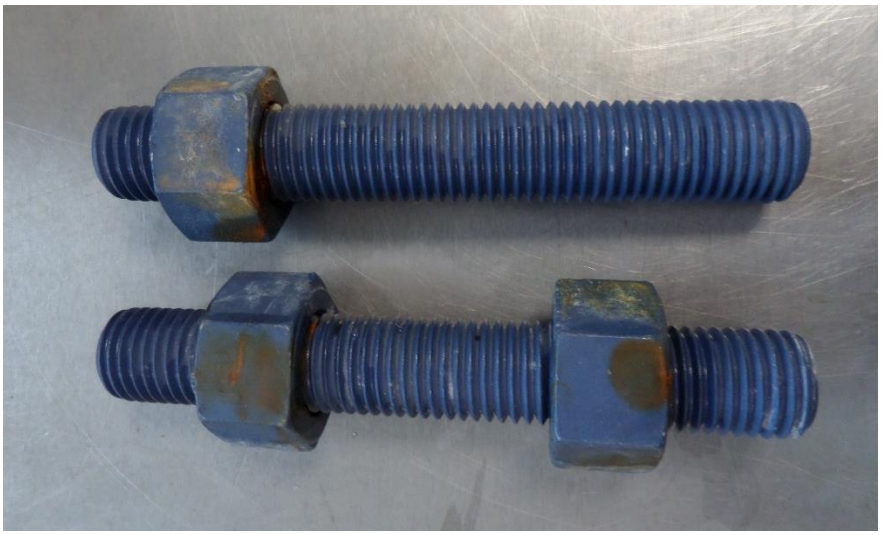
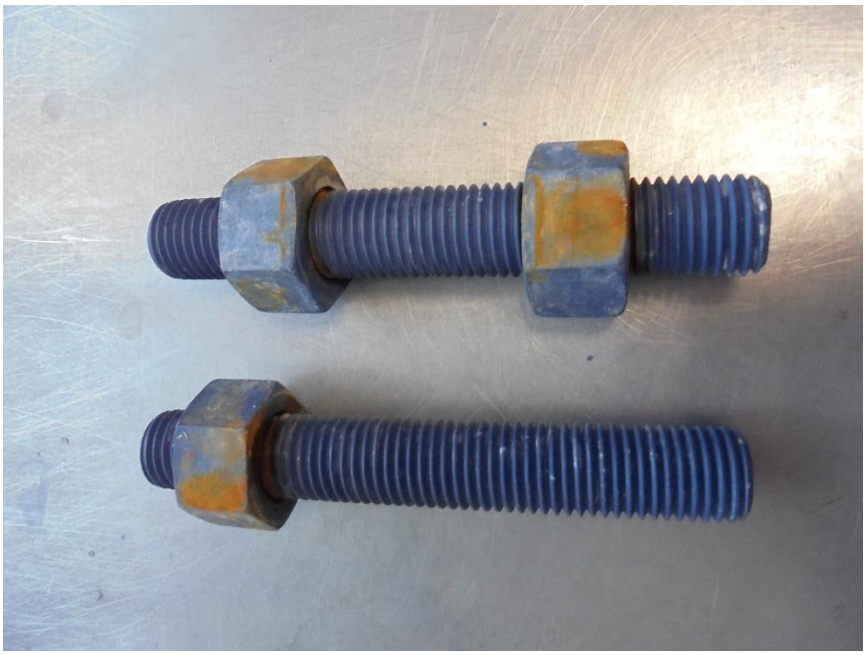
8040 hours



9000 hours



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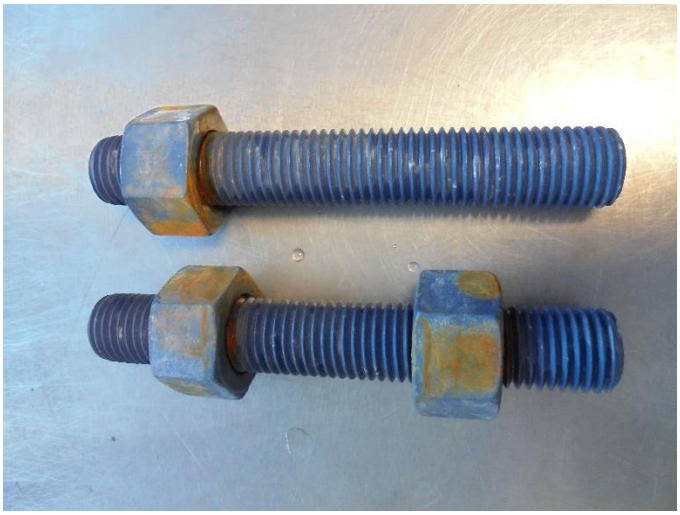
10000 hours



Hours	Observations	
0	Ok	Ok
96	<1% WR	<1% WR
264	<1% WR	<1% WR
432	1% WR	1% WR
600	1% WR	1% WR, 1st RR, <1% RR
768	1% WR	1% WR, 1% RR
936	1% WR	1% WR, 1% RR
1440	1% WR	1% WR, 1% RR
1656	2% WR	3% WR, 1% RR
1824	2% WR	3% WR, 1% RR
1992	4% WR	3% WR, 1% RR
2160	4% WR	3% WR, 1% RR
2328	4% WR	3% WR, 1% RR
2496	4% WR	3% WR, 1% RR
2664	4% WR	3% WR, 1% RR
2832	4% WR	3% WR, 1% RR
3000	4% WR	3% WR, 1% RR
3168	4% WR	3% WR, 1% RR
3336	4% WR	3% WR, 1% RR
3504	4% WR	3% WR, 1% RR
3672	4% WR	3% WR, 1% RR
3840	4% WR	3% WR, 1% RR
4008	4% WR	3% WR, 1% RR
4176	4% WR	3% WR, 1% RR
4344	4% WR	3% WR, 1% RR
4512	4% WR	3% WR, 1% RR

WR= White rust
RR= Red rust
Values give percentage surface coverage

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4680	4% WR	3% WR, 1% RR
4848	4% WR	3% WR, 1% RR
5016	4% WR	3% WR, 1% RR
5184	4% WR	3% WR, 1% RR
5352	4% WR	3% WR, 1% RR
5520	4% WR	3% WR, 1% RR
5688	4% WR	3% WR, 1% RR
5856	4% WR	3% WR, 1% RR
6024	4% WR	3% WR, 1% RR
6192	4% WR	3% WR, 1% RR
6360	4% WR	4% WR, 1% RR
6528	4% WR	4% WR, 1% RR
6696	4% WR	4% WR, 1% RR
6864	4% WR	4% WR, 1% RR
7032	5% RR	5% RR
7200	6% RR	6% RR
7368	6% RR	6% RR
7536	7% RR	6% RR
7704	7% RR	7% RR
7872	7% RR	7% RR
8040	7% RR	7% RR
8208	7% RR	7% RR
8376	8% RR	8% RR
8544	9% RR	9% RR
8712	9% RR	9% RR
8880	10% RR	10% RR
9048	10% RR	10% RR
9216	11% RR	10% RR
9384	11% RR	11% RR
9552	11% RR	11% RR
9720	12% RR	11% RR
9888	12% RR	12% RR
10056	12% RR	12% RR

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