

Cross-Cut Tester Kit

Crosshatch Adhesion Kit

This method is used for determining the parallel groove paint adhesion of one or many layers on a substrate, generally a metal panel. Cross-Cut Tester Kits are available in 2 different crosscut blade versions, one is a multi-cut blade with 6 cutting edges, the other version has one cutting edge. The Cross Cut blades are made of hardened steel alloy and are designed for retaining a sharp cutting edge to reduce the frequency of blade replacement.

ASTM method D3359 requires 11 cut lines for 1 mm cutter:

1 mm cutter for films up to 50 µm (2 mils) thick

2 mm cutter for films between 50-125 µm (2 - 5 mils) thick

ISO standards prescribe that the number of cuts shall be 6, and that the cut in each direction must be according to the film thickness and type of coating used as shown below:

0 - 60 µm 1 mm space for hard substrates (metal)

0 - 60 µm 2 mm space for soft substrates (plastic)

61 - 120 µm 2 mm space for hard or soft substrates

121 - 250 µm 3 mm space for hard or soft substrates



Standards

ASTM D 3002, D 3359

Method B

ISO 2409

DIN 927-3

Ordering Information

Cat. No.	Description
5120	Cross-Cut Kit 6, 6-edges 1 mm
5122	Cross-Cut Kit 6, 6-edges 2 mm
5125	Cross-Cut Kit 6, 1-edge 1 mm
5126	Cross-Cut Kit 6, 1-edge 2 mm
5128	Cross-Cut Kit 6, 1-edge 3 mm
5123	Cross-Cut Kit 11, 1-edge 1 mm
5127	Cross-Cut Kit 11, 1-edge 1.5 mm
5121	Cross-Cut Kit 11, 6-edges 1.5 mm
5124	Cross-Cut Kit 6, 1-edge 2 mm

Comes complete with:

Cross-Cut Tester kit with blade

Hex wrench for changing blades

Magnifier

Cleaning brush

Plastic carrying case

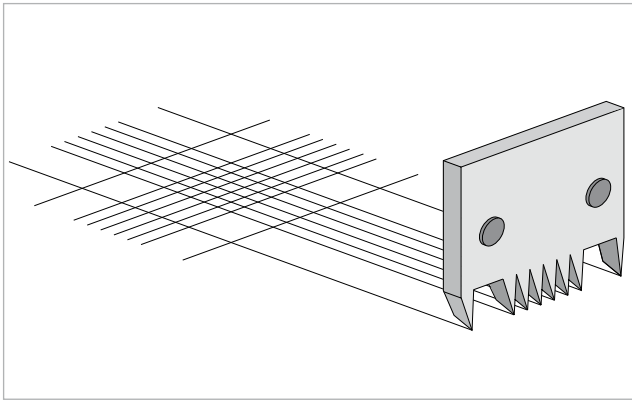
Operating instructions

One roll of adhesive tape in accordance with the standard

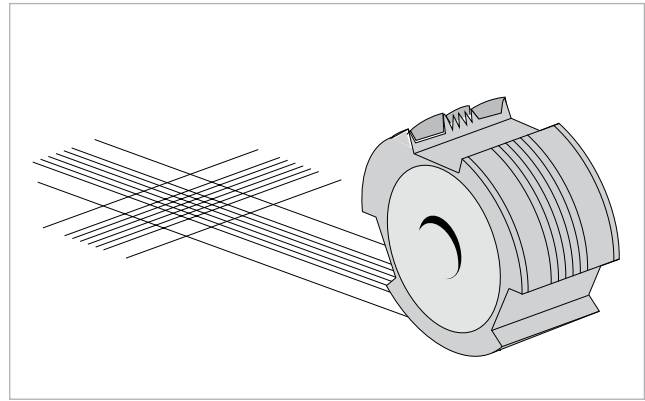
Technical Specifications

Standard	No. Of Teeth	No. Of Cutting Edges	Cutter Spacing	Hex Wrench included
DIN / ISO	6	6	1 mm (0.04 in)	--
DIN / ISO	6	6	2 mm (0.08 in)	--
DIN / ISO	6	1	1 mm (0.04 in)	yes
DIN / ISO	6	1	2 mm (0.08 in)	yes
DIN / ISO	6	1	3 mm (0.12 in)	yes
ASTM	11	1	1 mm (0.04 in)	yes
ASTM	11	1	1.5 mm (0.06 in)	yes
ASTM	11	6	1.5 mm (0.06 in)	--
ASTM	6	1	2 mm (0.08 in)	yes

Cross-Cut Tester Kit made of high alloy steel



1 cutting edge



6 cutting edges

Ordering Information

Cat. No.	Description
5132	Cross-Cut Blade 6, 6-edges 1 mm
5134	Cross-Cut Blade 6, 6-edges 2 mm
3425	Cross-Cut Blade 6, 1-edge 1 mm
5129	Cross-Cut Blade 6, 1-edge 3 mm
3426	Cross-Cut Blade 6, 1-edge 2 mm
3429	Cross-Cut Blade 11, 1-edge 1 mm
3424	Cross-Cut Blade 11, 1-edge 1.5 mm
5133	Cross-Cut Blade 11, 6-edges 1.5 mm
5135	Brush
5136	Magnifier
5137	Adhesive Tape for DIN/ISO
8660	Adhesive Tape for ASTM

Accessories

for Cat. No.	Standard	No. Of Cutting Teeth	No. Of Cutting Edges	Cutter Spacing
5120	DIN / ISO	6	6	1 mm (0.04 in)
5122	DIN / ISO	6	6	2 mm (0.08 in)
5125	DIN / ISO	6	1	1 mm (0.04 in)
5128	DIN / ISO	6	1	3 mm (0.12 in)
5126	DIN / ISO	6	1	2 mm (0.08 in)
5124	ASTM			
5123	ASTM	11	1	1 mm (0.04 in)
5127	ASTM	11	1	1.5 mm (0.06 in)
5121	ASTM	11	6	1.5 mm (0.06 in)

Spare brush for cross-cut tester kits

Spare magnifier for cross-cut tester kits, 3x - 6x magnification

Tesapack 4124, 50 mm x 66 m

IPG 51596, 1 in x 72 yds



Info!

Universal paint inspection:
 – Film thickness
 – Indentation hardness
 – Adhesion
 see byko-cut universal in Film Thickness section



Info!

For more information about how to evaluate test results with the new Digital Pocket Microscope, see DPM 300 in the Microscope section