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AMERICAN SOCIETY FOR TESTING AND MATERIALS
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Standard Test Method for Determination of the Transfer Efficiency Under Production Conditions for Spray Application of Automotive Paints— Weight Basis¹

This standard is issued under the fixed designation D 5066; 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.

^{ε1} NOTE—Unit of measurement statement added editorially in May 1996.

1. Scope

1.1 This test method provides procedures for determination of the transfer efficiency (using a weight method) under production conditions for in-plant spray application of automotive paints as outlined in Section 18 of EPA 450/3-88-018.

1.2 The transfer efficiency is calculated from the weight of the paint solids sprayed and that deposited on the painted part. The recommended approach involves painting the part directly. Also described is an alternative approach for painting parts covered with aluminum foil.

1.3 The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are for information only.

1.4 *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.* Specific hazard statements are given in the note after 10.1.8.

2. Referenced Documents

2.1 ASTM Standards:

D 1475 Test Method for Density of Paint, Varnish, Lacquer, and Related Products²

D 2369 Test Methods for Volatile Content of Coatings²

2.2 USEPA/MVMA (Motor Vehicle Manufacturers Association) Standards:

EPA 450/3-88-018, U.S. Environmental Protection Agency Protocol for Determining the Daily Volatile Organic Compound Emission Rate of Automobile and Light Duty Truck Topcoat Operations,³

¹ This test method is under the jurisdiction of ASTM Committee D-1 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 Annual Book of ASTM Standards, Vol 06.01.

³ Available from Superintendent of Documents, U.S. Government Printing Office, Washington, DC 20402. Refer to EPA 450/3-88-018 dated December 1988. This protocol makes reference to the determination of production spray transfer efficiency.

EPA Federal Reference Method 24—Determination of Volatile Matter Content, Water Content, Density, Volume Solids, and Weight Solids, of Surface Coatings⁴

3. Terminology

3.1 Definitions of Terms Specific to This Standard:

3.1.1 *paint*—the liquid material that is applied onto the part to cover or coat the surfaces.

3.1.2 *transfer efficiency*—the ratio of the weight of paint solids deposited to the total weight of paint solids used during the application process, expressed as a percent.

3.1.3 *paint weight solids content*—the weight of the non-volatile materials in the liquid paint material divided by the total weight of the paint, times 100, determined by Test Method D 2369.

3.1.4 *paint density*—the mass of a unit volume of the liquid paint material at any given temperature, determined by Test Method D 1475.

3.1.5 *satellite paint supply system*—a smaller, paint-circulating system separate from the main production paint-circulating supply system capable of supplying paint under the same conditions.

4. Summary of Test Method

4.1 The weight of the part to be painted is determined before and after the paint application process. The weight of liquid paint used per part is determined from material usage and part processing records. The determined weight solids content of the paint material is determined and used to calculate the paint solids sprayed per part. The transfer efficiency of the process is calculated by dividing the weight of paint solids deposited by the weight of the paint solids sprayed.

5. Significance and Use

5.1 This test method is specifically directed at the spray painting of automobile car and light duty truck bodies. The general principles are applicable to the painting of other automotive parts.

⁴ Available from Superintendent of Documents, U.S. Government Printing Office, Washington, DC 20402. Refer to CFR 40, Part 60, Appendix A.

5.2 This test method may also be used to measure transfer efficiency in full-sized painting facilities simulating production conditions and operations.

6. Interferences

6.1 Limitations include the ability of the weighing device to determine accurately the weight of the paint solids deposited on the part and the capability of accurate measurement of the amount of paint sprayed (see Section 7).

6.2 It may be difficult to cover the surface of complex shaped parts with aluminum foil (see 11.6.11).

7. Apparatus

7.1 *Tension Load Cells*, with upper/lower transition pieces.

7.1.1 1500-lb (682 kg) capacity with 0.05-lb (0.02 kg) precision for weighing automobile body and support frame.

7.1.2 500 to 800-lb (227 to 364-kg) capacity with 0.05-lb (0.02 kg) precision for weighing mix tanks or automobile components.

7.1.3 A safety cable is required for upper to lower transition.

7.2 *Electronic Digitizer/Readout*, readability of 0.05 lb (0.02 kg) and special filtering.

7.2.1 The electronic digitizer/readout shall meet OIML (International Organization of Legalized Metrology) specifications.⁵

7.3 *Voltage Regulator*.

7.4 *Swivel Devices*, as required.

7.5 *Rule and Calipers* for measuring diameter of paint supply tank shaft, etc.

7.6 *Sample Containers*, clean and airtight for paint material.

7.7 *Lifting Device and Support Frame Apparatus* to lift body.

7.7.1 Total weight must not exceed capacity of load cell or scale.

7.8 *Standard Calibration Weight*, approximately 2 lb (0.9 kg).

7.9 *Measure Stick*, Starret precision spring tempered, satin chrome finish, 36 in. (91.4 cm), with 4R graduations, or equivalent.

8. Paint Usage Measurement Procedures

8.1 Transfer efficiency measurement requires that accurate measurements be made of the quantity of paint material used in the application process during the time period associated with the coating of specific vehicles or parts. Two general procedures are applicable for accurately measuring paint usage.

8.1.1 The preferred procedure is to determine the weight of paint used during the application study period. Under typical production conditions, such weighing may be difficult, due to the large number of applicators requiring paint supply from a common tank. If a separate, isolated paint supply tank is used in the test; it is important to control paint viscosity, temperature, and flow rate consistent with the regular production system (see 9.1).

8.1.2 Where direct paint usage measurement by weight is not practical, an alternative procedure for determining paint

usage by volume is suggested. This procedure involves measuring the drop in paint level in the paint supply tank during the test. To provide sufficient accuracy, it may be necessary to paint a “block” (isolated group) of similar vehicles or parts from the paint supply system while usage measurements are taken. Typically, this may require painting approximately 30 vehicles (see 9.2).

9. Paint Usage Determination by Weight Procedure

9.1 This procedure for determining paint usage during the test is preferred when a satellite paint supply system is available for the process to be tested. With this procedure, it is usually easier to isolate paint usage for measurement purposes, and accurate results can be obtained with a smaller number of vehicles or parts (see 9.1.1).

9.1.1 At least 5.0 lb (2.27 kg) of paint material must be used during the test with the specified weighing equipment.

9.2 Before a satellite paint supply system can be used, it must be demonstrated that the system is capable of supplying the paint at sufficient volume and pressure to maintain normal process conditions (fluid deliveries of the spray devices) and that the paint can be maintained at a representative temperature and viscosity for the duration of the test period. These requirements can best be assured by mounting the satellite tank on a load cell or scale and directly piping it into the production supply system of the spraybooth. For this procedure the requirements are as follows:

9.2.1 Level and calibrate a weighing device (see Section 7) for weighing the satellite supply tank.

9.2.2 If an electronic weighing device is used, it must be turned on long enough to achieve stability, following the manufacturer's directions. All weighing devices must be situated to minimize disturbance from vibration or air movement.

9.2.3 Introduce the paint material, reduced to spraying viscosity, into the tank to be weighed. Before the test is conducted, be certain that fluid flows are properly set, that all supply and return lines are filled with the paint, and that no leaks are present in the piping system.

9.2.4 Shut off the agitator to minimize vibration during the weighing of the system.

9.2.5 Calibrate the weighing device in accordance with manufacturer's instructions. Weigh and tare a lifting frame, if used to support the satellite paint supply tank.

9.2.6 Weigh the satellite paint supply tank before the test vehicles or parts are run. Flexible connections are required to minimize strain. Carefully note the configuration of the tank so that the same configuration is used for both initial and the final weighing (that is, hose connections, height, etc.). Weigh the tank until 2 consecutive measurements are obtained within the measurement error of the weighing system ± 0.05 lb (0.02 kg). Average the two readings. The satellite tank may be left on the weighing device during the painting operation to monitor painting usage on a continuous basis.

9.2.7 After painting the test vehicles or parts, reweigh the satellite paint supply tank in accordance with 9.2.5 and 9.2.6.

9.2.8 Obtain representative paint samples immediately after completion of the test for solids and density analysis.

⁵ Electronic digitizer, Model 5322, available from Sterling Scale Co., 20950 Boening, Southfield, MI 48075, has been found suitable for this purpose.