



1. SCOPE:

This standard is applicable to all Ford Motor Company locations in North America for color coding during new construction, renovation, and maintenance. This standard is mandatory for marking physical hazards, safety signs, and piping identification as defined in ANSI Z535.1-1991, ANSI Z535.2-1991, and ASME/ANSI A13.1. Additional color coding and identification measures are referenced in Section 4, "Equipment," Section 6 "Building Interiors," and Section 7 "Building Exteriors." Additional color coding and identification methods may be used to increase efficiency consistent with the Ford Production System visual factory standards.

The intent of this standard is to provide a uniform method of identifying potential hazards within the organization. Where facilities have previously established color coding and identification standards and the application of the local standard is consistent, a deviation may be approved, provided:

- 1.1 The color coding and identification standard is reviewed with employees and contractors working in the facility on at least an annual basis.
- 1.2 The color coding and identification standard is consistent with all local governmental regulations.

2. MATERIAL CODE:

Many of the Ford Manufacturing Standards material specifications (M-numbers) referenced in previous versions of this standard are obsolete. For identification purposes, M-number references have been included in Appendix 1 with the understanding that replacement paints may be used to match colors or formulations.

The application of colors for identification purposes is based on ANSI 535.1-1991. The selection of an oil-base or water-base paint formulation should be based on the use, exposure, and substrate of the paint application.

3. SAFETY:

- 3.1 GENERAL INSTRUCTIONS: Personnel involved in the painting of Company facilities shall comply with all of the Company's Health and Safety procedures.



3.2

COLORS AND APPLICATION: (Adapted from ANSI Z535.1-1991)

COLOR	DESIGNATION	APPLICATION
Safety Yellow	Safety Yellow shall be the color for designating caution. Solid yellow, yellow and black stripes.	Traffic markings (prohibitive corner markings, exposed areas) edges, platforms, etc., aisle and road markings. Caution and physical hazards. Crane blocks and lower pulley blocks, hand and guard rails, pillars, posts and columns which may be struck, caution signs, alarm buttons. Alternate stripes in proportion to area being painted. Corners, low conveyor guards, doorways, low clearance areas, overhead rolling service doors, railroad clearances, etc.
Safety Orange	Safety Orange shall be the color for designating dangerous parts of machines or energized equipment.	Physical hazards, inside surfaces of guarding mechanical motion. Dangerous parts of machines or energized equipment which may cut, crush, shock, or otherwise injure and to emphasize such hazards when guards or enclosures are open or removed.
Safety Green	Safety Green shall be the color for designating safety and the location of first aid and safety equipment.	Safety bulletin boards, safety instruction signs, railroad car brakes, locations of first aid kits, emergency eyewashes and showers, stretchers, medical locations.
Safety Blue	Safety Blue shall be the color for designating information such as informational signs and bulletin boards (not safety related). Safety Blue also has specific applications in the railroad area to designate warnings against the starting, use of, or movement of equipment that is under repair or being worked upon.	Background on informational signs (see Section 9.0).
Safety Purple	Color meanings have not been assigned to this color.	Not used.
Safety Black, Safety White	Safety Black, Safety White, Safety Yellow or combinations of these colors shall be the designation of traffic and house-keeping markings.	Traffic markings designating road- ways, speed limits.
Safety Gray	Color meanings have not been assigned to this color.	Not Used.
Safety Red	Safety Red shall be the color for the identification of (1) Danger; (2) Stop.	Danger. Safety cans and other portable containers of flammable liquids, danger signs, emergency stopping devices, sirens, fire and emergency exits.



4. EQUIPMENT:

4.1 GENERAL:

The paint application and color standards for production machinery and equipment are intended to establish a uniform method in the identification and preservation of plant facilities and equipment for new construction, renovation, and maintenance. Current government rules and regulations have requirements for safety identification by color to mark physical hazards. Existing machinery and equipment may be repainted to match the present color. This revised standard shall be used only if the existing machinery and equipment can be repainted without creating confusion. Some modifications to the standard were included to provide a choice of better quality paint, necessary to extend the useful life, even in severe operating conditions.

Where safety color is specified, such as Safety Red, Safety Orange, Safety Yellow, Safety Green and Safety Blue, Safety Color Code, ANSI Z535.1-1991 shall be complied with, unless existing colors are to be used. This revised standard can be used on new or existing machinery and equipment to establish uniformity throughout the plant, while meeting the safety color code required by government rules and regulations.

COLORS AND APPLICATION
GENERAL MACHINERY AND EQUIPMENT

COLOR	BASIC IDENTIFICATION	APPLICATION
Gray, Green, Brown, Buff	Oil-proof machinery enamel.	Dry operations, at or near ambient (room temperature) conditions.
Any color from above	Two-component epoxy coating - Dehart 9342 epi-coat finish Tox #028424 Part A, Tox #028466 Part B.	For wet machining operations protection from cutting oils. Use Dehart 9351 epi-coat epoxy metal primer on new machines only. For wet machining operations protection from cutting oils. Use Dehart 9351 epi-coat epoxy metal primer on new machines only.



COLORS AND APPLICATION
GENERAL MACHINERY AND EQUIPMENT

EQUIPMENT	COLOR	DESCRIPTION
Spray booth	Aluminum	Medium heat resistant aluminum paint
Welding booth	Brown	Exterior enamel
	Black	Interior, flat black enamel
Cranes, inside building	Safety Blue or Safety Yellow	Precaution Blue or Target Yellow enamel
Cranes, outside building	Safety Black	Interior black enamel
Cranes, hooks, railings, ladders, steps, etc.	Safety Yellow	Target Yellow enamel
Hoists	Brown or Safety Yellow	Target Yellow enamel
Ovens, temperature up to 260 C	Aluminum	Medium heat resistant aluminum paint, apply thin coats
Ovens, temperatures 260 - 538 C	Aluminum	High temperature resistant aluminum paint, apply thin coats
Dust collector, inside building	Brown	Identify with interior black enamel
Dust collector, outside building	Architect approved	Consult with PEO, FLDC

4.2 FIRE FIGHTING EQUIPMENT

Do not paint chrome, fittings, or polished extinguishers.

Identify the location of fire extinguishers, hose reels or alarm boxes on columns, partitions, or walls as follows:

- 4.2.1 Band building columns with a 16" (40 cm) high Safety Red band located to give maximum visibility. (This is usually two to three feet (0.6 - 0.9 m) below the roof truss line, or roof line where there is no truss.)
- 4.2.2 Walls and partitions should have an identifying Safety Red rectangle, 16" high by 24" (40 x 60 cm) wide, located directly above the fire equipment.