

3.1.2 Dry Film Conductivity (GMW17065). The dry film conductivity of the coating film shall be determined. A coating shall be deemed conductive if a maximum reading of 4 MΩ is obtained.

3.2 Processing Requirements.

3.2.1 Surface Preparation. Power wash per 9984801.

3.2.2 Application. Reduce and apply uniformly to achieve the dry film thickness specified per supplier recommendation. Number of coats and flash time between coats and to oven shall be regulated to avoid popping or other detrimental effects.

3.2.3 Film Build (ISO 2808). Apply uniformly to achieve a film thickness of 5 µm to 15 µm (0.2 mil to 0.6 mil) of adhesion promoter.

3.2.4 Processing. This prep coat is processed using either method 3.2.4.1 or 3.2.4.2.

3.2.4.1 The prep coat is applied and then baked prior to application of an approved topcoat system.

3.2.4.2 The prep coat is applied wet-on-wet and co-baked with an approved topcoat system.

Note: Each type of processing requires separate testing and approval per GMW17105.

3.2.5 Bake. Surface of the part must be within the range of time and temperature per the Primer's Bake Chart on file with Vehicle Systems - Paint Materials and Facilities Engineering. Time in the oven and ambient temperature must be regulated to meet this requirement without exceeding overbake/underbake requirements. For wet-on-wet applications, the surface of the part must be within the range of time and temperature per the Topcoat's Bake Chart on file with Vehicle Systems - Paint Materials and Facilities Engineering.

3.3 Additional Requirements. Product approval is required under established guidelines outlined in ISO/TS 16949. At product approval, the supplier is expected to have reviewed to GM's satisfaction, specific documentation outlined in Advanced Product Quality Plan (APQP). Examples of this documentation are to include Design Failure Mode and Effects Analysis (DFMEA), Process Failure Mode and Effects Analysis (PFMEA), Key Product Characteristic (KPC), Key Control Characteristic (KCC) and Manufacturing Control Plans.

4 Manufacturing Process

All shipments of material or parts under contract or purchase order manufactured to this specification shall be equivalent in every respect to the initial samples approved by Engineering. There shall be no changes in either formulation or manufacturing processes permitted without prior notification and approval by Engineering. Lack of notification by the supplier constitutes grounds for rejection of any shipment. While samples may be taken from incoming shipments and checked for conformance to this specification, the supplier shall accept the responsibility for incoming shipments meeting the specification without dependence upon purchaser's inspection. In addition, the supplier shall be responsible for submitting a Certificate of Analysis with each batch of material arriving at a plant.

5 Rules and Regulations

5.1 Legal Regulations. All materials must satisfy applicable laws, rules, regulations and recommendations valid in the country of usage.

5.2 Language. In the event of conflict between the English and domestic language, the English language shall take precedence.

5.3 Inspection and Rejection. Samples of components or materials released to a GM material specification shall be tested for conformity with the requirements of this material specification and approved by the responsible Engineering department prior to commencement of delivery of bulk supplies.

A new approval must be received for any changes, e.g., properties, manufacturing process, location of manufacture, etc. If not otherwise agreed, all testing and documentation normally required for initial release must be completed.

It is the responsibility of the supplier to inform the customer in a timely manner, without solicitation, and to include documentation of all modifications of materials and/or processes and to apply for a new release.

5.4 Material Safety Data Sheets/Safety Data Sheets (MSDS/SDS). For new product submissions, or when a change in chemical composition of an existing product has occurred, a complete copy of the Material Safety Data Sheet/Safety Data Sheet must be submitted in compliance with the Globally Harmonized System of