

EDS

Engineering,
GM DAEWOO Auto & Technology
Standards

PAINT-I/P

EDS-M-8769

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VERSION: 3

1. SCOPE

This specification specifies the general requirements of the paint (main paint and thinner) for the instrument panel (hereinafter called "I/P").

2. GENERAL PROPERTIES OF MATERIAL

2.1. Main paint : Thermosetting paint with thermal-plastic acrylic resin as base

2.2. Thinner : Composite solvent made up of ethyl acetate, butyl acetate, xylene, etc. It is mixed with the main paint to enhance workability.

3. REQUIREMENTS

3.1. Properties of delivered material

3.1.1. Color : According to specification by colors.

3.1.2. Delivery Viscosity : According to specification by colors (ASTM D 1084, ZAHN CUP #4 at 20°C).

3.1.3. Non-volatile : According to specification by colors (EDS-T-7902, 120°C × 2 hours, Undiluted paint).

3.1.4. Specific gravity : According to specification by colors (EDS-T-7786)

3.2. Condition at coating

3.2.1. Dilution viscosity : 15 ~ 17sec (ASTM D 1084, ZAHN CUP #4 at 20°C)

3.2.2. Dilution stability : No precipitation after dilution to the specified viscosity and subsequent exposure to room temperature for 2 hours.

3.2.3. Coating method : Application with a general air spray gun and robot.

3.2.4. Curing condition : 40°C × 30minutes min.

3.3. Composition of test piece

3.3.1. PC-ABS Panel + EDS-M-8769

4. REQUIREMENTS AFTER DRYING

4.1. Appearance : After drying, the coated surface shall show no sign of defects, such as sagging and pinholes.

4.2. Film thickness : 10~15 μm (EDS-T-7782)

4.3. Gloss : 2.0±0.5 (EDS-T-7907, BYK HAZE-Gloss Meter)