



Paint Shop Dry Wiper

1 Scope

This specification details the requirements for dry wipers to be used in GM paint shops in preparation of the body for phosphate, Electrocoating (ELPO), primer, and top coat.

1.1 Material Description. Specialty material/cloth defined as "dry wipers" that are lint free, etc.

1.2 Symbols. Not applicable.

1.3 Applicability. All material/cloth used to wipe automotive body/parts prior to phosphate, ELPO, primer, and top coat.

1.4 Remarks. These wipers must not have any adverse effects on the GM standards specified herein. They must also not have any adverse effects on the phosphate, ELPO, and paint systems at the various assembly plants.

2 References

Note: Only the latest approved standards are applicable unless otherwise specified.

2.1 External Standards/Specifications.

IES-RP-CC004.2

2.2 GM Standards/Specifications.

GMW3059

GMW14270

GMW16546

GMW16656

2.3 Additional References.

Approval Process Information Packet from GM Paint

3 Requirements

Specific wiper requirements and appropriate test methods are listed.

3.1 Requirements on Delivery.

3.1.1 Chemical Requirements. No chemical that could be detrimental to the paint should be used.

3.1.1.1 Chemical Composition. Silicone or lanolin compound of any kind is not allowed in/on the wiper.

3.1.1.2 Emission. Containers of wipers should not emit any chemical vapors or particles that may become airborne and detrimental to the applied paint coatings.

3.1.1.3 Particulate Generation/Release. The following conditions must be less than or equal to the given number in Table 1.

Table 1: Particulate Generation/Release Conditions

Test Methodology	Specification
Readily Releasable (IES-RP-CC004.2, see Section 5.1)	$\leq 100\,000$ particles/m ²
Bidirectional Shake (IES-RP-CC004.2, see Section 5.2)	$\leq 900\,000$ particles/m ²
Snag	≤ 200 See Appendix A for definition
Haden Tube	$\leq 25\,000$ particles/m ²

3.1.2 Mechanical Requirements. Not applicable.

3.1.3 Physical Requirements. The wipers must be dirt/fiber free and compatible with paint shop materials. The wipers must be capable of being used in phosphate, ELPO, and paint system without loss of physical properties.

3.1.4 Additional Requirements. Completed copies of the drawings or equivalent wiper dimensions must be included with any new submission.

3.1.4.1 Visual Inspection. The wipers must visually conform to the manufacturer's description, such as:

- Material
- Size/Dimensional Consistency
- Laundered

3.2 Processing Requirements.

3.2.1 Chemical Requirements. Not applicable.

3.2.2 Mechanical Requirements. Not applicable.

3.2.3 Physical Requirements. Not applicable.

3.2.4 Additional Requirements. Wipers must be compatible with all painting processes. GM Engineering, not the supplier, will determine the disposition (pass or reject) based on the results obtained by a GM North America paint engineering approved lab.

3.2.4.1 Phosphate System Compatibility (GMW16546). Wipers must not have any adverse effects on the phosphate coat.

3.2.4.2 ELPO Primer Compatibility (GMW16656). Wipers must not have any adverse effects on the ELPO primer coat.

3.2.4.3 Primer Surfacer Compatibility. Wipers must not have any adverse effects on the primer surfacer coat.

3.2.4.4 Paint Compatibility. The following conditions must be less than or equal to the given number in Table 2.

Table 2: Paint Compatibility Conditions

Test Methodology	Specification
Telegraphing (Dry - Isopropyl Alcohol (IPA))	≤ 1
Telegraphing (Dry, Naptha)	≤ 1
Wipemark (GM) (Dry, IPA)	≤ 3.5
Wipemark (GM) (Dry, Naptha)	≤ 3.0
Stove Pipe (GM) (Count)	≤ 40 particles
Haden Crater	≤ 0