



Paint Shop, Polish Wiper

1 Scope

This specification details requirements for the polish wiper; to be used in the GM paint shop, in preparation of the body, for primer and top coat.

1.1 Material Description. Non-woven wiper. The material must not adversely affect those personnel handling it.

1.2 Symbols. Not applicable.

1.3 Applicability. Used on all horizontal and vertical visible surfaces after electrocoat (e-coat) bake, primer surface bake, and topcoat bake.

1.4 Remarks. Safety personnel conducting validation testing of these wipers, are expected to use appropriate Personal Protective Equipment (PPE) and safety procedures.

2 References

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

2.1 External Standards/Specifications.

IES-RP-CCOO4.2

2.2 GM Standards/Specifications.

GMW3059

GMW14270

2.3 Additional References.

None.

3 Requirements

3.1 All materials supplied to this standard must comply with GMW3059, **Restricted and Reportable Substances**, including the requirement to submit a full material composition disclosure to GM via the International Material Data System (IMDS) or via a completed GMW3059 report form.

3.2 Chemical Requirements. No chemical that could be detrimental to the paint or personnel handling this wipe should be used.

3.2.1 Chemical Composition. No silicone or lanolin compound, of any kind, is allowed in/on the wiper.

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

3.2.3 Particulate Generation/Release. The test method requirements must be less than or equal to the numbers given in Table 1.

Table 1: Particulate Generation/Release Requirement

Test Method	Requirement
Readily Releasable (see Appendix A, A1.1) (IES-RP-CCOO4.2, see section 5.1)	$\leq 600\,000$ particles/m ²
Bi-directional Shake (see Appendix A, A1.2) (IES-RP-CCOO4.2, see section 5.2)	$\leq 2\,500\,000$ particles/m ²
Snag (see Appendix A, A1.3)	≤ 200
Haden Tube (see Appendix A, A1.4)	$\leq 50\,000$ particles/m ²

3.3 Mechanical Requirements. Not applicable.

3.4 Physical Requirements. The wipers must be dirt/fiber free and compatible with paint shop materials. The wipers must be capable of being used in the paint system without loss of physical properties such as fraying, shredding, or tearing.

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

- Material that the wiper is constructed from.
- Size/Dimensional Consistency.
- Laundered (Third party wash service, or washed in plant where applicable).

3.5 Processing Requirements.

3.5.1 Paint Compatibility. Wipers must be compatible with all painting processes. GM Engineering, not the supplier, will determine the disposition (pass or reject) based on the test results obtained in a, GMNA Paint Engineering approved, laboratory.

3.5.2 Wipers must not have any adverse effects on the top coat. The test method requirement must be less than or equal to the number given in Table 2.

Table 2: Paint Compatibility Test Requirements

Test Method	Requirement
Telegraphing (Dry, Isopropyl Alcohol (IPA)) (see Appendix A, A1.5)	≤ 1
Telegraphing (Dry, Naptha) (see Appendix A, A1.5)	≤ 1
Wipe Mark (GM) (Dry, IPA) (see Appendix A, A1.6)	≤ 3.5
Wipe Mark (GM) (Dry, Naptha) (see Appendix A, A1.6)	≤ 3.0
Haden Crater (see Appendix A, A1.7)	≤ 0

3.5.3 Waste Treatment. The supplier will be responsible to make known the processing procedures for any component of the wipers for which the waste treatability is in question.

3.6 Performance Requirements. The wipers cannot contain any material that will be detrimental to the applied paint system.

3.7 Additional Requirements.

3.7.1 Shipment Responsibilities. All wipers should be shipped in lint-free packaging. It will also be the responsibility of the supplier to insure that the wipers are not exposed to contamination during shipment which would cause the wipers to fail to meet any of the requirements of this specification.