



Paint Shop Tack Cloth

1 Scope

This specification details the requirements for the paint shop tack cloths to be used in GM paint shops in preparation of the body for primer and top coat.

1.1 Material Description. Non-woven cotton material saturated with tack resin.

1.2 Symbols. Not applicable.

1.3 Applicability. Used to remove debris from exterior surfaces prior to prime and topcoat applications.

1.4 Remarks. The paint shop tack cloths must not have any adverse effects on the GM standards in 2.2. Additionally, the paint shop tack cloths must not have any adverse effects on the 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

2.3 Additional References. None.

3 Requirements

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 or on the paint shop tack cloths.

3.1.1.2 Emission. Containers of paint shop tack cloths 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. See the specifications in Table 1.

Table 1: Particulate Generation/Release Specification

Test Methodology	Specification
Readily Releasable (IES-RP-CC004.2 See 5.1)	$\leq 300\ 000$ particles/m ²
Tack Transfer	≤ 15 mg/m ²
Snag	≤ 150
Haden Tube	$\leq 5\ 500$ particles/m ²

3.1.2 Mechanical Requirements. Not applicable.

3.1.3 Physical Requirements. The paint shop tack cloths must be dirt and fiber free and compatible with paint shop materials. The paint shop tack cloths must be capable of being used in the paint system without a loss of physical properties.

3.1.4 Additional Requirements. Completed copies of the drawings or equivalent paint shop tack cloths dimensions must be included with any new submission.

3.1.4.1 Visual Inspection. The paint shop tack cloths must visually conform to the manufacturer's description; e.g., Material, etc.

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. The paint shop tack cloths 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 Primer Surfacers Compatibility. The paint shop tack cloths must not have any adverse effects on the primer surfacer coat.

3.2.4.2 Paint Compatibility. See the specifications in Table 2.

Table 2: Paint Compatibility Specification

Test Methodology	Specification
Telegraphing (Tack, Sanddrift)	≤1
Stove Pipe (GM) (Count)	≤30 particles
Haden Crater	≤0

3.3 Performance Requirements. The paint shop tack cloths cannot contain any material that will be detrimental to the applied paint system.

3.3.1 Chemical Requirements. Not applicable.

3.3.2 Mechanical Requirements. Not applicable.

3.3.3 Physical Requirements.

3.3.3.1 Functionality. The paint shop tack cloth must meet the specifications given in Table 3.

Table 3: Functionality Specifications

Test Methodology	Specification
Dirt Holding Capacity	≥100 g/m ²
Dirt Holding Capacity (6 h exposure)	≤90 g/m ²

3.3.4 Additional Requirements. Not applicable.

3.4 Requirements on other Stages during Life Cycle.

3.4.1 Chemical Requirements. Not applicable.

3.4.2 Mechanical Requirements. Not applicable.

3.4.3 Physical Requirements. Not applicable.

3.4.4 Additional Requirements. See Appendix A.

3.4.4.1 Waste Treatment. The supplier will be responsible to make known the processing procedures for any component of the paint shop tack cloths for which the waste treatability is in question.