



Paint Shop General Purpose Glove

1 Scope

This specification details the requirements for general purpose gloves to be used in the GM paint shop in preparation of the body for phosphate, electrocoat (e-coat or ELPO), primer and top coat.

1.1 Material Description. White gloves generally made from polyester and or nylon material, worn by operators to prevent contamination of painted surfaces.

1.2 Symbols. Not applicable.

1.3 Applicability. Gloves used in the GM paint shop.

1.4 Remarks. Not applicable.

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

GMW16546

GMW16656

2.3 Additional References.

Safety and Industrial Hygiene (S&IH) Technical Standard (TS), S&IH TS 3.4-160-02 (available at www.gmsupplypower.covisint.com)

3 Requirements

Specific glove requirements and appropriate test methods.

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 gloves.

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. See Table 1. For test method descriptions, see Appendix A.

Table 1: Test Method and Specification for Particulate Conditions

Test Methodology	Specification
Readily Releasable (IES-RP-CCOO4.2 see 5.1)	$\leq 250\ 000$ particles/m ²
Bidirectional Shake (IES-RP-CCOO4.2 see 5.2)	$\leq 1\ 300\ 000$ particles/m ²
Snag	≤ 200
Haden Tube	$\leq 25\ 000$ particles/m ²

3.1.2 Mechanical Requirements. Not applicable.

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

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

- Material
- Size/Dimensional Consistency
- Laundered
- For a Check of Possible Free Fibers

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. Gloves must be compatible with all painting processes. GM Engineering, not the supplier, will determine the disposition (pass or reject) based on the results obtained during the production test.

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

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

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

3.2.4.4 Paint Compatibility. Gloves 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, GM North American Paint Engineering approved, laboratory.

3.2.4.5 Gloves must not have any adverse effects on the top coat. See Table 2. For test method descriptions, see Appendix A.

Table 2: Test Method and Specification for Paint Compatibility

Test Methodology	Specification
Telegraphing (Dry, IPA) Isopropyl Alcohol (IPA)	≤ 1
Telegraphing (Dry, Naptha)	≤ 1
Wipe Mark (GM) (Dry, IPA)	≤ 4
Wipe Mark (GM) (Dry, Naptha)	≤ 4
Stove Pipe (GM) (Count)	≤ 40 particles
Haden Crater	≤ 0

3.3 Performance Requirements. The gloves 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. Not applicable.

3.3.4 Additional Requirements. Not applicable.

3.4 Requirements on other Stages during Life Cycle.

3.4.1 Chemical Requirements. Not applicable.