



Paint Compatibility with Purge Solvent

Do Not Use on New Programs; No Replacement

1. SCOPE

This test method evaluates purge solvent compatibility with paint under various process conditions with the aim of determining if mixing, overspraying or underspraying of paint materials with purge solvent causes cratering.

2. PANEL PREPARATION

As nominated in the relevant material specification.

3. APPARATUS

3.1 Mixing container

3.2 Measuring device

3.3 Spray equipment

3.4 Oven - fan forced convection

4. METHOD

4.1 Mixing Compatibility

Reduce a paint sample 25% by volume with the test thinner and spray a standard steel test panel with the paint at specified film build (40 microns +/- 5 microns for primer/surfacer, 20 microns +/- 2 microns for basecoat, 30 microns +/- 5 microns for clearcoat and 35 microns +/- 5 microns for solids). Cure the film at the recommended bake schedule. The standard purge solvent formula is referenced in HN0285 Section 3.5 and is used as a reference for purge compatibility testing.

4.2 Overspray Compatibility

Spray a standard steel test panel with the paint at specified film build (40 microns +/- 5 microns for primer/surfacer, 20 microns +/- 2 microns for basecoat, 30 microns +/- 5 microns for clearcoat and 35 microns +/- 5 microns for solids). Mist coat the wet film with the purge thinner. Cure the film at the recommended bake schedule. The standard purge solvent formula is referenced in HN0285 Section 3.5 and is used as a reference for purge compatibility testing.

4.3 Underspray Compatibility

Mist coat a standard steel test panel with the purge thinner and then spray the panel with paint at specified film build (40 microns +/- 5 microns for primer/surfacer, 20 microns +/- 2 microns for basecoat, 30 microns +/- 5 microns for clearcoat and 35 microns +/- 5 microns for solids). Cure the film at the recommended bake. The standard purge solvent formula is referenced in HN0285 Section 3.5 and is used as a reference for purge compatibility testing.

5. EVALUATION

Examine the surface of the steel panels for defects.

6 Release and Revisions

This standard was originated in September 2000. It was first published in September 2000.

Issue	Publication Date	Description (Organization)
1	SEP 2000	Initial publication.
2	JUN 2008	- Section "4. METHOD", Section "4.1 Mixing Compatibility", "4.2 Overspray Compatibility", "4.3 Underspray Compatibility" - Include information on the standard purge solvent formula and it's use as a reference for testing.
3	FEB 2016	Limited for Current Use. (Materials)