

**HOLDEN**

Holden Limited
Engineering Department

MATERIAL SPECIFICATION

NUMBER : HN 1656
SHEET : 1 of 6
RELEASE : August, 1982
REVISION :

NAME: EXTERIOR COLOUR LACQUER - HIGH BAKE

1. SCOPE

This specification covers the requirements for an exterior colour solution lacquer. Specified herein are the painted product, process, laboratory performance and paint material requirements. This finish is intended for use in non-critical exterior exposure areas that are designated to be colour coated to match exterior body colour. The finish is applied over set baked primer surfacer in the engine compartment etc,

2 PRODUCT REQUIREMENTS

After final bake, the following requirements shall be met on all critical surfaces of the article or as designated by the applicable Product Engineering documents.

2.1 Appearance

Inspection of the appearance parameters shall be performed in a well-lit area to insure max/mum appearance on visible areas.

- 2.1.1 The finished coating shall present a uniform, continuous appearance with the colour on all surfaces of the assembled unit a close match to the approved master standard.

NOTE: A sufficient amount of the colour coat, consistent with requirements, must be applied to develop complete coverage and meet surface appearance specifications regardless of the minimum film thickness requirements.

- 2.1.2 Acceptability of tolerances of any visual defect shall be established as required to insure appearance without loss of durability due to serious repair. (Any repair involving removal of the basic coating system to bare metal).

2 Test Requirements

- 2.2.1 Film thickness, Lacquer 30-50 μm .
See Paint Instruction Drawings for defined areas.

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3. PROCESS REQUIREMENTS.

3.1 Application:-

Applied by manual air spray to set baked primer surfacer conforming to HN1635 (10 minutes x 120°C nominal set bake).

3.2 Bake:-

Co-baked with primer surfacer HN1635, 30 minutes x 150°C nominal bake.

3.3 Wet Sanding:-

The oversprayed material shall be capable of being wet sanded on visible exterior surfaces to produce an acceptable appearance after topcoat lacquer application.

3.4 Compatibility:-

The material shall be compatible with the dip primer flash primer primer surfacer and topcoat lacquer used in the plant for which it is supplied.

3.5 Toxicity:-

The material shall be non-toxic and have no objectionable odour.

3.6 Colour, Viscosity, Thinners, etc. :-

Shall be fixed at time of approval and listed on the approved sources sheets for each vendor (refer Appendix).

3.7 Manufacturing Trial:-

A manufacturing trial is required to establish the material performance to the above requirements.

4. PERFORMANCE REQUIREMENTS.

4.1 Test Panel Preparation

4.1.1 Substrate:

Laboratory standard steel test panel phosphated with Parker EPI or equivalent.

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