

KES

Specification of Out Pannel and Inner Pannel for Painting Shop

KES B-L012

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Contents

1. Scope of Application
2. Kind and Symbol
3. Quality
4. General Condition of Testing
5. Testing Method
6. Inspection
7. Alteration of Specification



1. Scope of Application

This standard specifies the burn hardening type painting sealer, of which the major ingredient is chloride vinyl, and is used for water and dust proofing of the inside and outside of paint coated automobiles.

2. Kind and Symbol

The kind and symbol of paint sealer shall conform to Table 1.

Table 1

Kind	Material symbol	MC comparable symbol	Location of application	Remarks
Kind 1	A-SB01	S-S58	Inner plate	Painting sealer used in adhesion surfaces of observable locations such as the floor
Kind 2	A-SB11	S-S59	Outer plate	Painting sealer used in adhesion surfaces in the hemming of the rain rail

3. Quality

3.1 General Condition

- (1) Physical appearance: Painting sealer shall not have traces of foreign matters such as partial condensation of moisture.
- (2) Workability: Painting sealer shall not affect the flow out performance of certain spray guns, and shall not flow on the panel surface.
- (3) Adaptation character to painting: Painting sealer shall not disperse or flow out during the painting process, and after burning the paint, it shall not have any abnormal condition on panel surface such as irregularities or cracks.
- (4) Storage stability: After kept in a sealed container for 3 months under direct sun light, the painting sealer shall not have separation, formation of gel or other changes.
- (5) Toxic character: Painting sealer shall not contain any toxic ingredients specified by law, and shall not be harmful during normal operation.

3.2 Performance

Performance of the painting sealer shall satisfy the specification in Table 2 when tested by testing method of 6.

Table 2. Performance

Testing items				Required performance		Testing method
				A-SB01	A-SB11	
Physical appearance				Uniform paste with no traces of foreign matter or formation of gel	Uniform white paste with no traces of foreign matter or formation of gel	5.1
Specific gravity				1.7 or less		5.2
Non volatile ingredient %				97 or more		5.3
Pressure viscosity				Report		5.4
Revolving viscosity P/20°C				530 - 900	350 - 700	5.5
Storage stability				Within 100%		5.6
Volume change ratio %				0 - 2		5.7
Fluidity	Physical appearance			Report		5.8
	Flow of painting sealer	30°C 48Hr	Within 30mm			
		150°C± 30 min	Within 30mm			
Tensile strength kgf/cm ²				6.0 or more		5.9
Elongation %				50 or more		
Shear adhesion strength kgf/cm ²	Condition			6.0 or more		5.10
	Heat resistance aging character			6.0 or more		
	Moisture resistance character			6.0 or more		
Hardness	120°C			30 - 60		5.11
	140°C			50 - 70		5.12
Moisture absorbing character %				Within 2		
Low temperature irregularity				No cracks or abnormalities		5.13
Performance of paint film	Condition	2 Coat	Physical appearance	—	No pin holes, cracks, or contamination on the paint surface	5.14.1
			Physical adherence	—	No peel offs of the paint film	
		3 Coat	Physical appearance	—	Same as above	
			Adherence	—	Same as above	
	Heat aging character	2 Coat	Physical appearance	—	Same as above	5.14.2
			Adherence	—	Same as above	
		3 Coat	Physical appearance	—	Same as above	
			Adherence	—	Same as above	