

NAVISTAR, INC.		
Material, Parts, and Process Specifications (MPAPS)		NUMBER: MPAPS G-4517
		Former Designation: <i>TMS-1011 (example)</i>
TITLE: Interior Trim Panels – Wood Grain		CURRENT REV No.: 1608
		DATE: Aug. 2016
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1.0 APPLICATION

This specification covers two types of wood grained plates and strips used in interior trim applications such as dash panels, and switch or instrument backing plates and/or as trim strips in cabs and sleepers. The wood grain pattern is produced by the direct deposition of colored inks onto a prepared metal surface.

2.0 SCOPE

This specification covers film property and performance requirements of the finished panels, plates/strips, and special graphics.

2.1 Description of Types

2.1.1 Type 1

In the Type 1 product, the wood grain appearance is developed with colored inks applied to the surface from a patterned screen or platen.

2.1.2 Type 2

In the Type 2 product, the wood grain appearance is developed from colored inks flowed onto the surface.

2.2 Application of Types

Engineering will specify the product Type on the Engineering drawing(s).

NOTE: On existing Engineering drawings that do not specify a Type; Type 1 product will be supplied.

2.3 Restricted Chemical Substances

Effective January 1, 2007, all product supplied to the requirements of this specification must comply with the requirements of the MPAPS B-50 specification.

3.0 REFERENCE DOCUMENTS

Unless otherwise specified, the latest issue of all referenced standards shall apply. The following Specifications, Standards, and Regulations are referenced in this specification.

Quality System Standard ISO 9001 or TS-16949	NAVISTAR MPAPS B-50	ASTM D3363
CFR Title 29, Part 1910	MPAPS GT-Paint	ASTM D4060
CFR 49, Part 571.302	MPAPS GT – 31	SAE J1847
NAVISTAR Supplier Packing and Shipping Std. D-13	MPAPS P-9544	ASTM D523
NAVISTAR Engineering Design Std A-16	ASTM D3359	

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4.0 REQUIREMENTS

The type and thickness of the substrate used for trim panels, trim plates/strips shall be specified on the engineering drawing. Steel substrates shall have either a paint or galvanized coating on the back surface to provide corrosion protection against humidity and condensation. The back faces of aluminum or plastic substrates may be in a bare condition.

4.1 Finish

The finish on the front decorative surfaces shall be produced by depositing an approved wood grain pattern on substrates that have been suitably pretreated with a conversion coating and painted to provide the required adhesion to the substrate. A clear organic coating shall be deposited on top of the wood grained film to provide the required abrasion resistance and satisfy appearance requirements.

4.1.1 Finish Appearance

The film should be uniform and must conform to color, texture, and/or printed pattern of the master samples of the pre-production material that was originally approved and is on file in the Industrial Design Group.

4.1.2 Finish Performance

Finished parts must meet performance requirements. If parts are blanked/stamped from sheet stock that areas the desired wood grain film, blanked edges that are visible after installation shall be coated or painted brown with an approved air drying paint or topcoat. The dried paint film will exhibit a minimum 'F' hardness. Edge paint "wrap-around" shall not exceed 0.050 inch on the exposed face. Edge paint damage/chipping may be repaired using an approved brown touch-up paint.

4.2 Film Property and Performance Requirements

4.2.1 Finish Hardness

The film will exhibit a minimum pencil hardness of F when tested as per ASTM D3363.

4.2.2 Gloss

Initial gloss at 60° shall be 85 ±5 when tested as per ASTM D523, unless otherwise specified on the drawing.

4.2.3 Abrasion Resistance

500 cycles with 500 gram load using CS-10 wheels as per ASTM D 4060 or SAE J 1847. Test samples of the film shall be mounted on the appropriate substrate.

4.2.3.1 Required:

There shall be no significant visible loss of the pattern. Weight loss shall not exceed 0.025 grams.

4.2.4 Humidity

Shall pass 100 hours humidity exposure when tested as per MPAPS GT-Paint, 7E. The film shall exhibit no blistering, loss of color, pattern, or loss of adhesion to the substrate.

4.2.5 Adhesion

Adhesion of the woodgrain film and the edge paint shall be 100% after testing as per ASTM D3359 method B. Tests shall be performed before and after humidity exposure.

4.2.6 Weathering Resistance

Test panels shall pass six months South Florida exposure as per MPAPS GT-Paint, 7F. Conditional approval may be based upon 240 hours QUV-B testing using the Q Panel QUV test cabinet. The QUV test cycle is indicated below:

4.2.6.1 QUV-B Testing Cycle - 240 Hours

8 Hours Ultraviolet Light	60° C (140° F)
4 Hours Condensation	50° C (122° F)

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