

NAVISTAR, INC.		
TMS (TRUCK MATERIAL SPECIFICATION)		NUMBER: TMS-9000
TITLE: Texture Paint Processing Procedures		CURRENT REV No: 0908
		DATE: August 2009
WRITTEN/EDITED BY: Materials Engineering	APPROVED BY: Materials Engineering	SUPERSEDES: Rev C-1 - August 2001
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<i>This specification may involve hazardous materials, equipment, and procedures. This specification does not purport to address all of the safety issues associated with its use. The user is responsible to consult appropriate safety and health practices and to determine the applicability of regulatory limits prior to use.</i>		
Change Notice: Replaced "International Truck and Engine Corporation" with "Navistar, Inc." per corporate directive; added section 2.1 "Restricted Chemical Substances"; added section 10 "Technical Information"; editorial changes.		
Reference: File 30-13A	Keywords: Texture Paint	

1.0 APPLICATION

This specification covers the procedures for applying a vinyl modified acrylic paint to achieve a special textured finish on fiberglass reinforced polyester (FRP) parts. It can be specified for internal or external applications.

2.0 SCOPE

This specification covers the surface finishing, paint preparation, equipment, application and repair procedures.

2.1 Restricted Chemical Substances

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

3.0 REFERENCE DOCUMENTS

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

Quality System Standard ISO 9001 or TS-16949	TMS-4505
NAVISTAR Manufacturing Standard MS-D-13	CEMS B-50
CFR Title 29, Part 1910	

4.0 REQUIREMENTS

4.1 Surface Finishing

The following basic steps are mandatory. Additional processing may be added if it does not affect the performance or appearance of the texture finish.

1. Scuff sand with 240 grit or finer paper.
2. Solvent wipe with xylol or lacquer thinner.
3. Carefully remove all remaining dirt and dust particles using tack rag or other suitable means.

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4.2 Paint Preparation

The paint, covered in TMS-4505, is a single component system which is used for both the base and top coat as follows:

4.2.1 Base Coat

Reduce paint with toluol, xylol, or SC-100 solvent, depending upon paint area temperatures. Reduction shall be two parts paint to one part solvent. Stir thoroughly before using.

4.2.2 Top Coat

Do not reduce - use as received. Stir thoroughly before using.

4.3 Paint Equipment

The following set-up kits and paint guns shall be used in applying the base and texture coats:

4.3.1 Base Coat

Kit - DeVilbiss 74 x AV-601-F or Binks 63 x 63PB

Gun - DeVilbiss JGA or Binks #62

4.3.2 Texture Coat

Kit - DeVilbiss 704 x AV-15 or Binks 66 x 66PB

Gun - DeVilbiss JGA or Binks #62

4.4 Paint Application

The following steps are mandatory. Additional processing may be added if it does not affect the performance or appearance of the texture finish.

4.4.1 Spray base coat to a dry film thickness of 38 μm (1.5 mil) to obtain complete hiding of the substrate. This will usually require two complete passes. Best results are obtained by painting each pass in opposite directions. Fluid pressure should be 138 kPa (20 psi) or enough to provide 0.65-0.71 liters (22-24 oz) of paint per minute delivery. Use 379-414 kPa (55-60 psi) air atomization pressure.

4.4.2 Let base coat flash dry three minutes or until dull.

4.4.3 Apply a uniform texture top coating over entire surface so that it matches the master sample provided by Navistar. Fluid pressure should be 241-379 kPa (35-55 psi), with air atomization pressure set at 138-207 kPa (20-30 psi). Paint pressure must produce an unbalance of paint versus air to create the heavy texture particles.

4.4.4 Surfaces shall be air dry cured for 60 minutes or force-dried at 52-66°C (125-150°F) for 20 minutes before handling.

4.5 Paint and Substrate Repair

It is desirable to inspect the substrate for defects after the base coat has been applied and flash dried. If repairs are required, the parts shall be dried as indicated under Application 4.4.4, the area repaired and recoated with base coat, and the entire surface cleaned (tack rag). Then the entire part shall be processed with all steps shown under Application. If the texture (top) coat requires repairs after drying, the damaged area shall be sanded with 240 grit or finer paper, being careful not to expose the base coat. After cleaning, recoat the repaired area with texture top coat, blending into the surrounding point. If the base coat is damaged or the laminate exposed, base coat must be reapplied.

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