

MATERIALS / PAINTS

FNHA-2-J-303.00

TWO COMPONENT EPOXY PRIMER - WINNIPEG PLANT**1. SCOPE**

1.1 The material defined by this specification is a conventional solids, two component epoxy primer suitable for topcoating with finish coat enamels used on NEW HOLLAND products.

1.2 This specification may involve hazardous materials, apparatus and procedures. This specification does not address the health and safety problems, if any, associated with its use or application. It is the specification user's responsibility to follow appropriate safety or health practices, and determine the applicability of regulatory limitations prior to use.

2. APPLICATION

This specification was released originally for material used as the undercoat on tractors or implements and their parts. It shall be satisfactory for use under all two component weatherable epoxies or urethane high performance topcoats.

3. RELATED STANDARDS

86050309(FNHA-2-J-304.00) - Epoxy Activator
86505483(FNHA-2-J-005.00) - Color Designation
86507635(FNHA-2-J-001.00) - Test Procedures
86511034(FNHA-2-J-062.00) - Premium
Performance Paints

4. DESIGNATION

This specification is intended to identify a specific paint for supplier purposes. This specification designation shall not appear on Engineering drawings.

5. REQUIREMENTS

5.1 The specific paint shall meet the PERFORMANCE REQUIREMENTS as listed on Table 1 and WET REQUIREMENTS on Table 2. Performance requirements are after blending proper proportions of primer and activator. Blended material must have a minimum useable pot life of 2 hours at room temperature. (25° ± 5°C)

5.2 COMPOSITION**5.2.1 VEHICLE**

The vehicle shall be the activator for a two component epoxy polyamide resin to meet the physical requirements. The volatility of the solvents is to be balanced so that a spray coat will give a dried film of 0.0008 - 0.0012 in. (20 - 30 microns) without sagging and with satisfactory freedom from roughness or dry spray.

5.2.2 STABILITY

The material shall not gel, liver, or exhibit hard setting upon standing.

5.3 FLASHING CHARACTERISTICS

There shall be no sags or runs after application of the primer on a vertical surface. Following a 5-minute flash period and after applying the color topcoat and oven drying, there shall be no "strike-in", discoloration or bleeding.

6. SUPPLIER RESPONSIBILITY

6.1 Suppliers shall perform the necessary tests for sample approval when required. After this approval, suppliers are not required to perform the specific test procedures listed unless requested by NHA. Suppliers are responsible for insuring that their product will conform to the specification limits

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					 NEW HOLLAND			ENGINEERING SPECIFICATION			
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when tested by the specified methods. The specified methods will be used to reconcile disputed values. All test designations are latest issue unless otherwise specified.

6.2 All materials supplied to this specification shall be equivalent in all characteristics to the material upon which approval was originally granted. Prior to making any changes in the properties, composition, construction, color,

processing or labeling of the material originally approved under this specification, whether or not such changes affect the material's ability to meet the specification requires written notification to Purchasing and the other affected Materials Engineering activity. Test data, test samples and a new code identification are to be submitted with the request. Supplier must have the written acknowledgement and approval of the Materials Engineering activity prior to initiating any changes.

TABLE 1 - Performance Requirements After Blending

PROPERTIES	UNITS	SPECIFICATION HIGH SOLIDS ALKYD	TEST METHODS
TEST PANEL PREPARATION	NONE	MATCH PRODUCTION	86507636
COLOR	D E	5.0 MAX	86507637
INITIAL GLOSS	UNITS	5 - 25	86507638
FILM THICKNESS	MILS	0.8 - 1.2	86507641
HARDNESS	PENCIL	HB INITIAL/2H FINAL	86507643
IMPACT-TOUGHNESS	POUNDS	20 DIRECT & REVERSE	86507644
ADHESION	PERCENT	95	86507645
WRINKLE RESISTANCE	NONE	NO DEFECTS	86507646
OVERBAKE	D E	NA	86507647
SALT SPRAY	HOURS	336	86507648
HUMIDITY RESISTANCE	HOURS	240	86507649
CHEMICAL EXPOSURE	NONE	NA	86507650
WATER SPOT RESISTANCE	NONE	NA	86507651
RECOATING OF FINISHES	NONE	NO LIFTING	86507652
EXPOSURE - GLOSS RETENTION COLOR RETENTION	UNITS D E	NA NA	86507653
DRYING	NONE	MATCH PRODUCTION	86507656
APPLICATION	NONE	MEET PROD. REQMTS.	86507657
DECAL ACCEPTANCE	NONE	NA	86507662
ACCELERATED WEATHERING (340 BULB) - GLOSS RETENTION COLOR RETENTION	UNITS D E	NA NA	86507663
DEW POINT DULLING	NONE	NA	86507664
FREEZE-THAW RESISTANCE	CYCLES	10	86507666
MANURE RESISTANCE	DAYS	NA	86507667
PRIMER-TOPCOAT COMPATIBILITY	NONE	NO LIFTING OR LOSS OF GLOSS	86507668
WATER IMMERSION (AFTER TOPCOATING)	HOURS	240	86507670

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