

RECOATING OF FINISHES

1. SCOPE

This procedure is used to evaluate the repair and touch-up ability of a paint by application of a second wet coat over a dried paint film of the same coating material. The applied second coat over a sanded and unsanded paint surface will define the time frames for acceptable recoating.

2. REFERENCE STANDARDS

86507641(FNHA-2-J-001.06) - Dry Film Thickness

3. MATERIALS AND EQUIPMENT

3.1 Paint application equipment to duplicate production conditions.

3.2 Circulating laboratory oven capable of maintaining $82^{\circ} \pm 3^{\circ}\text{C}$ ($180^{\circ} \pm 5^{\circ}\text{F}$).

3.3 Dry film thickness gauge meeting 86507641 (FNHA-2-J-001.06) Eddy current type.

3.4 Supply of 4"x12"x.032" Bonderite 1000 panels.

3.5 Clean, dry, lint-free rag.

3.6 Sandpaper, 150 grit.

4. PROCEDURE

4.1 Paint four Bonderite 1000 panels per 3.4 with top coat only at a film build within specification of 1.5-2.0 dry mils.

4.2 Paint four Bonderite 1000 panels per 3.4 with top coat only at about twice the specified film build or 3.0-4.0 mils.

4.3 Force dry all panels for 30 minutes at $82^{\circ} \pm 3^{\circ}\text{C}$ ($180^{\circ} \pm 5^{\circ}\text{F}$), allowing a 15 minute room temperature flash-off between spray application and oven drying.

4.4 Remove panels from oven and allow them to cool to room temperature, $25^{\circ} \pm 5^{\circ}\text{C}$.

4.5 At intervals of 2, 4, 8, and 24 hours, select one panel each of in specification film build and heavy film build. Scuff sand half of each panel and wipe surface to remove any dirt or sanding residue. Apply a second coat of paint at 1.5-2.0 dry mils over entire surface of each panel.

4.6 Allow all panels painted at each time interval to air dry at room temperature for 24 hours following the recoating process.

5. REPORT

5.1 Record the condition of the paint surface on all panels on both sanded and unsanded portions. See FIGURE 1.

5.2 The sanded and unsanded surface must be free of any paint imperfections including lifting, blistering on both panels (in specification and twice specification) that were aged for 24 hours prior to recoating. NOTE: It is advantageous for all panels to be defect-free after each of the recoat intervals, but not mandatory.

					NAME	STD RECOATING	
					 NEW HOLLAND		ENGINEERING SPECIFICATION
ALL	C	JDF	111883	4/23/98			FRAME 1
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5.3 The paint passes the recoat test if one of the following is met:

All recoated panels are defect-free.

The two panels (in specification and twice specification film build), aged 24 hours, are defect-free and there is a clear definition of the time interval ("window") that recoat application will produce defect-free results if some panels showed defects at the 2, 4, or 8 hour intervals.

FIGURE 1

PANEL	PREPARATION	AFTER 2 HOURS	4 HOURS	8 HOURS	24 HOURS
IN-SPEC FILM BUILD	UNSANDED				
	SANDED				
TWICE SPECIFIED FILM BUILD	UNSANDED				
	SANDED				

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