

MATERIALS / PAINTS

FNHA-2-J-001.27

DECAL ACCEPTANCE

1. SCOPE

This procedure is used to evaluate the adhesion of pressure sensitive markings to dry paint coatings. It is also used to determine the mar resistance of the paint during and after production decal application and the paint coatings resistance to decal premask adhesives.

2. REFERENCE

86509253(FNHA-3-A-070.00) - Decal and Marking Specification

86509253(FNHA-2-J-001.01) - Part or Panel Preparation

3. MATERIALS AND EQUIPMENT

3.1 Assorted prespaced, diecut pressure sensitive markings and patch type markings meeting New Holland Decal and Marking Specification 86509253 (FNHA-3-A-070.00).

3.2 Polyethylene decal squeegee approximately 3" X 4" with smooth, straight application edge.

3.3 Several painted production panels prepared according to 86507636 (FNHA-2-J-001.01). Decals must be applied to panels at room temperature ($25^{\circ} \pm 5^{\circ}\text{C}$) between 1 and 2 hours after removing panels from oven.

4. PROCEDURE

4.1 Apply sections of several diecut, pressure sensitive markings and patch type markings to test panels. Apply sufficient pressure using a back and forth motion with the decal squeegee to ensure total contact of all decal and premask surfaces to the test panels.

4.2 Allow the premask on the prespaced die cut markings to remain on the painted surface for 15 minutes.

4.3 Remove the premask and inspect the painted surface for any film defects or blemishes.

4.4 If any paint film defects are noted recheck the surface after 24 hours at room temperature. ($25^{\circ} \pm 5^{\circ}\text{C}$)

4.5 After aging all the applied pressure sensitive markings for 14 days at room temperature ($25^{\circ} \pm 5^{\circ}\text{C}$) try to remove each by prying up a corner and pulling back.

4.6 All markings must exhibit excellent adhesion and not be able to be removed in one piece. The substrate must be marred to the degree that it was evident that a marking was removed.

5. REPORT

5.1 Record any paint defects or film abnormalities that occurred from the premask after removal in procedure steps 4.3 and 4.4.

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5.2 Report the condition of the paint film and the pressure sensitive marking following the removal procedure in 4.6.

5.3 The paint is acceptable if no permanent film defects from the premask or from the application using the plastic squeegee are evident and the markings meet the adhesion removal requirements.

NOTE: In the event that new paint coatings, are introduced with durability upgrades it may be necessary to improve the adhesive used on FNHA markings.

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