

MATERIALS / PAINTS

FNHA-2-J-001.33

PRIMER - TOPCOAT COMPATIBILITY**1. SCOPE**

This test is used to measure the effect on paint finish appearance using a wet on wet primer / topcoat application.

2. REFERENCE

86507638(FNHA-2-J-001.03) - Gloss
86507641(FNHA-2-J-001.06) - Dry Film Thickness
86507657(FNHA-2-J-001.22) - Application

3. MATERIALS and EQUIPMENT

3.1 Quantity of flash primer and topcoat to be evaluated.

3.2 Production paint application equipment or lab equipment simulating production conditions per 86507657 (FNHA-2-J-001.22).

3.3 Paint film thickness gage meeting requirements of 86507641 (FNHA-2-J-001.06).

3.4 Production oven or recirculating lab oven capable of maintaining $82^{\circ} \pm 3^{\circ}\text{C}$. ($180^{\circ} \pm 5^{\circ}\text{F}$)

3.5 Timing device.

3.6 Glossmeter meeting specification 86507638 (FNHA-2-J-001.03).

3.7 Bonderite 1000 panels 4" X 12" X 0.032".

4. PROCEDURE

4.1 Spray one panel with topcoat only and use as the initial gloss control.

4.2 Spray two Bonderite panels with primer to a film build that would be within the specification of 0.8 - 1.2 dry mils. Spray two panels at a film build approximately twice the dry film specification. (1.6 - 2.0 mils.)

NOTE: It may be advantageous to spray a couple panels with primer and oven dry to get a "feel" of the spray gun speed and number of passes required to obtain the desired dry film build.

4.3 Allow the four panels to flash at room temperature ($25^{\circ} \pm 5^{\circ}\text{C}$) for 10 minutes and apply the finish coat at 1.5 - 2.0 mils specification and double the specification. (3.0 - 4.0 mils.)

The panels should have primer and topcoat applied in order to achieve the following

<u>PANEL</u>	<u>PRIMER</u>	<u>TOPCOAT</u>
1	At spec	At spec
2	Double spec	At spec
3	At spec	Double spec
4	Double spec	Double spec

4.4 Flash all four primer / topcoat panels and the one gloss control panel for an additional 15 minutes.

4.5 Place all panels in a recirculating oven at $82^{\circ} \pm 3^{\circ}\text{C}$ ($180^{\circ} \pm 5^{\circ}\text{F}$) for 30 minutes.

4.6 Remove all panels and allow to cool for one hour.

4.7 Record the gloss of the panel without primer and label "gloss control." This panel must be free of any film defects.

					NAME	STD PRIMER TOPCOAT						
					 NEW HOLLAND				ENGINEERING SPECIFICATION			
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4.8 Record the gloss reading of all four of the primer topcoat panels.

5. REPORT

5.1 Report the "control gloss" and the gloss readings of the other four panels.

5.2 Observe and report the gloss readings and film defects visible on any of the panels such as blistering, solvent popping, dulling of film etc..

5.3 The primer/topcoat, wet on wet application is acceptable if there are no visible paint film defects, with the exception of a slight orange peel and the gloss readings on all four panels are within 95% of the "control gloss" or still remain within specification limits.

EXAMPLE:

Control gloss = 98
Primer/topcoat = 91

A gloss reading of 91 is only 93% of the "control gloss" but passes the requirements because it still meets the specified 90 minimum for a high gloss coating.

	NAME			PART NUMBER	
	STD PRIMER TOPCOAT			86507668	
ENGINEERING SPECIFICATION			REV. B	FRAME 2	OF 2