

MATERIALS / PAINTS

FNHA-2-J-063.00

POWDER COATING PAINT PERFORMANCE**1. SCOPE**

1.1 The material defined by this specification is a thermosetting powder applied coating paint finish suitable for interior and exterior use on New Holland products.

1.2 This coating must be a polyurethane, polyester, or alternate product of equal performance.

1.3 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 use on ferrous or non-ferrous metal components on tractors, farm implements and industrial products.

3. DESIGNATION

The Engineering drawing shall contain the notations for specification of paint in accordance with standard 86511126(FNHA-3-B-100.00).

4. RELATED STANDARDS

86505483(FNHA-2-J-005.00) - Color Designation

86507635(FNHA-2-J-001.00) - Paint Test

Procedures

86511126(FNHA-3-B-100.00) - Std. Referencing
Std. on Drawings

5. REQUIREMENTS**5.1 PRE-PAINT PREPARATION**

5.1.1 All metal surfaces shall be clean from metal scale such as oxide or rust. All metal surfaces shall also be clean from any oils, or cutting fluid or other compounds which could cause poor paint adhesion.

5.1.2 Ferrous substrates must be prefinished using a minimum iron phosphate system with a DI water rinse final stage. A chromate seal is optional.

5.1.3 All non-ferrous metal such as aluminum must have commercially acceptable cleaning and a chromate conversion or zinc phosphate coating.

5.2 PAINT APPLICATION

5.2.1 The product, properly applied, must be free of any visible film defects including excessive orange peel.

5.2.2 Powder coating paint finishes may be used in conjunction with a compatible primer such as a cathodic epoxy electrocoated primer on substrates where complex shapes inhibit complete powder coating penetration and coverage. A primer coat is necessary to prevent rusting and rust bleeding when inadequate single coat coverage and corrosion resistance is a major issue.

5.2.3 On parts or products where shapes are less complicated and proper coverage can be achieved, a direct-to-metal application of powder coating can be used.

					NAME	STD POWDER PERFORM	
					 NEW HOLLAND	ENGINEERING SPECIFICATION	
ALL	C	JDF	111468	2/17/98		FRAME 1	OF 4
ALL	B	RLF	110255	JUL 97		PART NUMBER	
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FRAME NO.	REV	BY	ECN NO.	DATE			
APP.	DRAWN		KH	JUN 94			
KHH FEB 94	CHECKED						

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For single coat powder applications, a high quality metal preparation must be used. A minimum iron phosphate coating is required. All performance requirements must be met on parts and products with this single coat of powder.

5.2.4 The performance properties are listed in Table I.

6. SUPPLIER RESPONSIBILITY

6.1 Suppliers shall perform the necessary tests for sample approval for initial lots. After this approval, suppliers are not required to perform the specific tests, but to ascertain that their product will conform to the specification limits. These specified requirements will be used to reconcile any disputed values.

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 the making of any changes in the properties, composition, construction, color, dimension, processing, or labeling of the material originally approved under this specification, the supplier shall notify Purchasing and the affected Materials Engineering activity of the proposed changes and obtain the written acknowledgement of the Material Engineering activity. Test data, test samples, and a new identification code are to be submitted with the request.

	NAME				PART NUMBER	
	STD POWDER PERFORM				86511032	
ENGINEERING SPECIFICATION				REV. B	FRAME 2	OF 4