

Preprimed Steel

1. SCOPE

1.1 The material defined by this specification is preprimed steel coil, or sheet stock. Its use is primarily limited to #20, #18, and #16 gauge steel, but it could be expanded to include heavier material.

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

1.3 Preprimed steel must be compatible with FNHA finish coats and must pass performance specifications for all primer/topcoat requirements in 86628044 (MAT0103).

1.4 The material must also pass all forming requirements and weldability tests including strength and amount of repetitive welds.

1.5 This specification is intended to designate a specific paint(s) for supplier purposes and for use by approved primer (coil) applicators.

1.6 This specification was primarily released for use on light gauge steel generally associated with shielding and guarding used on NH implement and tractor parts. Preprimed paint is to be applied on coil stock by a coil coater.

2. DESIGNATION

2.1 CR Sheet ASTM A1008 CS type B—Preprimed (formerly A366 Preprimed).

2.2 This standard (86511415) replaces all existing #20 and #18 gauge drawings which specify CR Sheet ASTM A366. Existing drawings will **not** be changed to reflect use of preprimed material unless drawings require revision for other reasons. All future drawings utilizing #20 and #18 gauge cold rolled material will be preprimed as specified in this standard.

2.3 This standard (86511415) replaces **all** existing #16 gauge drawings used in **pick up bands** which specify CR Sheet ASTM A366 or ASTM A1008 CS type B. Existing drawings will **not** be changed to reflect use of preprimed material unless drawings require revision for other reasons. All future drawings utilizing #16 gauge cold rolled material, for **pick up bands only**, will be preprimed as specified in this standard.

3. RELATED STANDARDS

86628044 (MAT0103)—Paint Material and Finished Part Performance Requirements
 865057635 (FNHA-2-J-001.00)—Applicable tests listed in Table 3 from Paint Test
 86050094 (FNHA-2-A-051.00)—Cold Rolled Sheet (ASTM A1008 CS type B)
 86513728 (FNHA-4-B-010.00)—Shop Practice Guide MN1
 86572868 (FNHA-2-A-0050.01)—Materials List 86511415

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4. REQUIREMENTS

4.1 The total performance requirements of the finished preprimed steel is shared three ways; by the paint supplier, coil coater, and NH (4.2, 4.3, 4.4).

4.2 The specific paint shall meet the Wet Requirements in Table 2 (paint supplier responsibility). Certification from paint supplier to coil coater is required.

4.2.1 All steel coils, prior to the priming operation, must meet the requirements of the applicator for proper thickness, uniformity, flatness, etc. The coil must be cleaned and iron phosphated prior to priming. After priming the coil shall meet the Performance Requirements in Table 3.

NOTE: Many of the performance requirements are contained in the paint suppliers Product Data Sheet, but the responsibility for verifying and meeting the performance specifications is that of the paint applicator.

4.2.2 All finished coils of preprimed steel must include certification from the coil coater that the product meets the requirements in Table 3 prior to, or upon delivery of, the coil(s) to NH. A copy of the certification of the wet paint from the paint supplier (5.2) must accompany the performance certification.

4.2.3 Surfaces (except edges) of finished preprimed coils, or purchased preprimed sheet, will be 100% covered with primer. Any portion of a coil or sheet not covered with primer makes that coil or sheet rejectable back to supplier.

4.2.4 A sample of each coil, or a representative sample of a coil shipment, shall be cut from the coil and sheared into twelve (12) 4" X 12" panels. Samples will be delivered to NH for testing prior to, or upon delivery of, preprimed samples.

4.3 MECHANICAL REQUIREMENTS

4.3.1 Bend Test

The primed material shall be capable of being bent, at room temperature, in any direction through 180° flat on itself without peeling the coating.

4.3.2 Spot Weld Testing

When spot welding on the preprimed material the frequency of dressing tips should exceed 1000 welds. Welds must also pass the standard peel test (86513728 (FNHA-4-B-010.00), Standard Shop Practice Guide MN1-7.1).

4.4 The top coated parts made from coated coil shall meet the requirements for preprimed steel in Table 4 which are the applicable tests for preprimed steel taken from 86509537 (FNHA-2-J-061.00). The tests are the responsibility of NH.

4.5 COMPOSITION

4.5.1 Vehicle

The vehicle shall be a thermoset baking primer formulated to give a dry paint film thickness of .0001" – .0002" when applied to steel coil. The film must be continuous and free from imperfections such as roughness, cracking, etc.

4.5.2 Pigment—The primer shall be formulated with the proper balance of pigments to give proper corrosion protection, formability, and spot welding characteristics.

5.0 SUPPLIER RESPONSIBILITY

5.1 Suppliers shall perform the necessary tests for sample approval when required. Suppliers are responsible for ensuring that their product will conform to the specification limits when tested by the specified methods. The specified methods will be used to reconcile disputed values. All test designations are latest issue unless otherwise stated.

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