

Supplier Painting Process Quality

1. SCOPE

1.1 The process defined in the specification shall establish a method of review of painted surfaces for New Holland identified components painted outside a specific New Holland's manufacturing facilities.

1.2 This specification may involve hazardous materials, procedures and apparatus. This specification does not address the health and safety problems associated with its application or use. It is the specification user's responsibility to follow appropriate health or safety practices and determine the application or regulatory limitation before use.

2. APPLICATION

This specification was originally released to define a process in establishing a review of parts or components painted by a supplier who is processing to the New Holland specifications.

It is assumed that the paint used by the supplier has been approved by New Holland Materials Engineering and appears on the Approved Supplier and Paint Product List, 86571352 (FNHA-2-J-099.00).

3. RELATED SPECIFICATIONS

86509537 (FNHA-2-J-061.00)—Standard Performance Paint Coating
 86511034 (FNHA-2-J-062.00)—Premium Performance Paint Coating
 86511032 (FNHA-2-J-063.00)—Powder Coating Paint Performance
 86507637 (FNHA-2-J-001.02)—Color
 86507638 (FNHA-2-J-001.03)—Initial Gloss

86507645 (FNHA-2-J-001.10)—Adhesion (Room Temperature)

86507648 (FNHA-2-J-001.13)—Salt Spray
 86507635 (FNHA-2-J-001.00)—Paint Test
 86571352 (FNHA-2-J-099.00)—Approved Supplier and Paint Product List

4.0 REQUIREMENTS

New Holland tests product by performing specific physical test to determine the quality of the paint. In addition New Holland requires that this quality level is also related to the production environment

4.1 COLOR VERIFICATION

The paint shall be checked on a production parts / components to verify the color match. A test panel representative of the surface of the production part maybe used. The color check would be best done by the use of a color spectrometer reading the L,a,b values and the delta E value from a given color chip. If this equipment is not available, a color match by viewing the painted parts / components with a color chip in daylight (not in direct sun light) and assuring there is no color difference. The actual values from the color spectrometer shall be reported. If visual examination is performed a pass / fail value shall be reported. Reference standard 86507636 (FNHA-2-J-001.02)

4.2 INITIAL GLOSS

The initial gloss shall be measured by using a gloss meter. This gloss level shall be taken on a production sample or a test panel representative of the surface of production parts. The actual gloss reading shall be reported. Reference standard 86507638 (FNHA-2-J-001.03).

					NAME	STD SUP PAINT QLTY		
					 NEW HOLLAND	ENGINEERING SPECIFICATION		
ALL	D	NE	113173	3/99		THE INFORMATION HEREON IS THE CONFIDENTIAL AND PROPRIETARY PROPERTY OF NEW HOLLAND N. V. AND/OR ITS SUBSIDIARIES. ANY USE, EXCEPT THAT FOR WHICH IT MAY BE LOANED, IS PROHIBITED.	FRAME 1	OF 4
ALL	C	RLF	110244	7/97			PART NUMBER	
ALL	B	RLF	108931	7/1/97				
ALL	A	REI	108573	12/9/96				
FRAME NO.	REV	BY	ECN NO.	DATE				
APP.	DRAWN		I EKIS	OCT 96				
KHH Dec 96	CHECKED							

4.3 ADHESION

A sample part or a test panel representative of a surface equal to production parts shall be prepared. This sample shall be pretreated in the same manner as typical production, then primed and top coated with the specified coatings. The adhesion test shall be conducted as per the process described in the New Holland standard 86507645 (FNHA-2-J-001.10) for room temperature. The rating shall be noted as described in the procedure and reported. Reference standard 86507645 (FNHA-2-J-001.10).

4.4 SALT SPRAY

The test shall be conducted with a part or production representative surface test sample. These samples shall be pretreated in the same manner as the production parts. These parts shall be salt spray tested for the minimum hours in salt spray which follows the New Holland standard 86507648 (FNHA-2-J-001.13). The items requiring reporting shall be film thickness, (typical expected film thickness for liquid shall be 1.0 mils. primer and 2.0 mils. top coat, and for powder, the coating shall be 3.0 mils.) and a pass / fail for the minimum hours specified in the paint performance specification. Reference standard 86507648 (FNHA-2-J-001.13).

5. SUPPLIER RESPONSIBILITY

5.1 The supplier shall perform or have the above mentioned test performed and any addition required tests performed to assure that the required process quality level are obtained. This information shall appear on a New Holland Initial Sample Review (ISR). Thus the SUPPLIER IS REQUIRED to have the attached form in this specification filed out and submitted with the appropriate ISR documentation.

5.2 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. The supplier shall not change processes once the initial sample approval has been granted. If there are process changes then the supplier shall submit in writing the changes to Materials Engineering or New Holland Supplier Quality Assistance Personnel for written approval. Once this approval has been granted the supplier shall submit another initial sample approval with the above requirements.

	NAME				PART NUMBER	
	STD SUP PAINT QLTY				86541552	
ENGINEERING SPECIFICATION				REV. D	FRAME 2	OF 4