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GJL 11-22-02

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SHEET
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ENGINEERING SPECIFICATIONS OR INSTRUCTIONS

ESN- 0034

TITLE:

CHASSIS PAINT SPECIFICATION

CHASSIS PAINT PROCEDURE

Note: This procedure also applies to Ottawa produced brackets and structures that bolt to the frame during production.

Overview – The frame is painted with paint compatible TGIC powder and then topcoated with a polyurethane liquid paint for additional corrosion protection and gloss retention. Reference ESN-0030.

Parts are loaded onto the powder paint monorail.

Parts are shot blasted to remove mill scale and to provide a clean, paint ready surface. Shot is #230 (0.0300" dia) steel pellets at 100+% coverage.

Parts are blown off using compressed air to remove dust and residual shot pellets that may have accumulated.

Parts are transferred into the powder booth and painted. Paint thickness on finished parts to be 1.5-2.0mils.

Parts are transferred into the curing oven where the surface temperature is brought to 400°F for at least 10 minutes.

After cooling, parts are removed from the monorail.

FINAL PAINT – CHASSIS

The partially assembled chassis is scuffed, wiped, and tacked off before entering the on-line paint booth. A topcoat of polyurethane liquid paint is applied for sealing, additional corrosion resistance, and gloss retention.