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SHEET

1 OF 3

ENGINEERING SPECIFICATIONS OR INSTRUCTIONS

ESN-0049

REV:

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TITLE:

CHINA CAB PAINT PROCEDURE/中国驾驶室涂装工艺流程

CHINA CAB PAINT PROCEDURE

SURFACE PREPARATION

1. Clean all surfaces with Dupont cleaning solvent 3608S or 3920S degreaser.
2. Abrasive blast all surfaces using an abrasive blast along with compressed air. Use blast material: G-40 steel grit, S-230 steel shot, Clemtex #3, 30/60 mesh silica sand, or Black Beauty BB-50 or BB 2040. Removes all dirt, dust, mill scale, and rust to obtain a near white metal condition. Surface should have a gray-white metallic color.
3. Blow clean removing any dust or other material from surface using compressed air.
4. Wipe clean all surfaces with Dupont cleaner solvent 3608S or 3920S.
5. Preheat all metal components in a pre-heated booth to 20-22C temperature.

FIRST PRIMING

6. Use Dupont Corlar 2.1 Primer or P6 Primer, and stir evenly.
7. Prepare Corlar 2.1 or P6 Epoxy Primer, for spray to the following mix ratio, and stir evenly.
Corlar 2.1 : VF-525 : Y-32035/T-8054 = 1 : 1 : 0-15% (volume ratio)
P6 : P62 : P610 = 3.5 : 1 : 1 (volume ratio)
8. Apply Corlar 2.1 or P6 Epoxy Primer tack coat to parts surface obtaining a film thickness of 30-40um.
9. Allow to flash for 15 mins. Bake Epoxy Primer for 60 mins @ 60°C (ambient temperature), then natural cool for 60 mins.
10. Detail sand and dry burnish the surface with P400-P600 sand paper.
11. Remove any oil from surfaces with Dupont cleaning solvent 3920S degreaser. Blow clean removing any dust or other material from surface using compressed air.
12. Wipe all surfaces with dry cloth, in preparation for next primer.

SECOND PRIMING

13. Use Dupont Corlar 2.1 Primer or P6 Primer, and stir evenly.
14. Prepare Corlar 2.1 or P6 Epoxy Primer, for spray to the following mix ratio, and stir evenly.
Corlar 2.1 : VF-525 : Y-32035/T-8054 = 1 : 1 : 0-15% (volume ratio)
P6 : P62 : P610 = 3.5 : 1 : 1 (volume ratio)
15. Apply Corlar 2.1 or P6 Epoxy Primer to parts surface obtaining a film thickness of 40-50 um.
16. Allow to flash for 15 mins. Bake Epoxy Primer for 60 mins @ 60°C, then natural cool for 60 mins.
17. Detail sand and dry burnish the surface with P400-P600 sand paper.
18. Remove any oil from surfaces with Dupont cleaning solvent 3920S. Blow clean removing any dust with compressed air.
19. Wipe all surfaces with dry cloth, in prepare for next working procedure.

TOPCOAT

20. Prepare Imron 700 Topcoat, for spray to the following ratio mix, and stir evenly.
Imron 700 : AU270 : AU370 = 4 : 1 : 0-15% (volume ratio)
21. Apply in two spray steps Imron 700 to surface obtaining a film thickness of 40-50 um or per Paint Manufacturer Specifications, whichever is greater. (See [*Kalmar Paint No*](#), please click left button to see the file). Ensure break between two steps. Allow first spray to flash for 5 min-10 mins before final spray.
22. Allow final spray to flash for 10 min-15 mins before bake.
23. Bake for 30 mins @ 80°C. Or bake for 45 mins @ 70°C, or 60 mins @ 60°C.
24. Allow to Natural cool to normal temperature for 12 hours, in prepare for next working procedure.
25. Desire total film thickness obtained is 110-130 um per Paint Manufacturer Specifications, whichever is greater. (See [*Kalmar Paint No*](#), please click left button to see the file).

Materials required:

Type	Name
Cleaning Solvent	3608S
	3920S
Epoxy Primer	Corlar 2.1
	P6
Topcoat	Imron 700

中国驾驶室涂装工艺流程

表面处理

1. 用杜邦 3608S 或 3920S 清洁剂将需要喷涂的金属表面清洗干净。
2. 对部件表面进行喷砂处理,所用的喷砂材料如下:G-40 钢砂、S-230 钢丸、Clemtex #30、30/60 目硅砂或 Black Beauty BB-50 或 BB 2040。清除所有的泥土、灰尘、磨粒、铁锈达到近白金属状态, 部件表面应具有灰白色的金属色彩。
3. 用压缩空气吹干净表面的灰尘及其他杂质。
4. 用杜邦 3608S 或 3920S 清洁剂清洁金属表面。
5. 将金属部件置于预热房中, 预热至 20-22 摄氏度。

第一道底漆喷涂

6. 将杜邦 Corlar2.1 或 P6 充分搅拌均匀。
7. Corlar2.1 或 P6 环氧底漆准备: 按如下比例调配底漆, 并搅拌均匀。
Corlar2.1 : VF-525 : Y-32035/T-8054 = 1 : 1 : 0-15% (体积比)
P6 : P62 : P610 = 3.5 : 1 : 1 (体积比)
8. 喷涂调配好的 Corlar2.1 或 P6 底漆, 喷涂膜厚 30-40 微米。

CHINA CAB PAINT PROCEDURE/驾驶室涂装工艺流程

10. 用 400 – 600 目干砂纸对部件表面进行干磨处理。
11. 用杜邦 3920S 清洁剂清洁金属表面，去除油污，并用压缩空气将表面的灰尘及其他杂质吹干净。
12. 粘尘布擦拭物件，准备下道工艺。

第二道底漆喷涂

13. 将 Corlar2.1 或 P6 充分搅拌均匀。
14. Corlar2.1 或 P6 环氧底漆准备：按如下比例调配底漆，并搅拌均匀。
Corlar2.1 : VF-525 : Y-32035/T-8054 = 1 : 1 : 0-15% (体积比)
P6 : P62 : P610 = 3.5 : 1 : 1 (体积比)
15. 喷涂调配好的 Corlar2.1 或 P6 底漆，喷涂膜厚 40-50 微米。
16. 闪干 15 分钟, 60 摄氏度烘烤 60 分钟，然后自然冷却 60 分钟。
17. 用 400 – 600 目干砂纸对部件表面进行干磨处理。
18. 用杜邦 3920S 清洁剂清洁物件，去除油污，并用压缩空气将表面的灰尘及其他杂质吹干净。
19. 粘尘布擦拭物件，准备下道工艺。

面漆喷涂

20. Imron700 面漆准备：按如下要求调配面漆，并搅拌均匀
Imron700 : AU270 : AU370 = 4 : 1 : 0.5-1 (体积比)
21. 喷涂 2 道已调配好的 Imron700 面漆，每道面漆间闪干 5-10 分钟，喷涂膜厚 40-50 微米或者是油漆供应商针对特定的颜色指定的厚度(参看*[Kalmar Paint No](#)*,请点击鼠标左键查看文件)。
22. 喷完放置闪干 10-15 分钟。
23. 80 摄氏度烘烤 30 分钟，或 70 摄氏度烘烤 45 分钟，或 60 摄氏度烘烤 60 分钟。
24. 自然冷却至室温，室温下放置 12 小时，准备下道工序。
25. 检查整个油膜的厚度，要求达到 110-130 微米或者是油漆供应商针对特定的颜色指定的厚度(参看*[Kalmar Paint No](#)*,请点击鼠标左键查看文件)。

材料要求:

分类	
清洁剂	3608S
	3920S
环氧底漆	Corlar 2.1
	P6
面漆	Imron 700