



Organic Coating Performance for Underhood and Underbody Components

1 Scope

1.1 Material Description. This standard gives performance requirements for organic coat finishes on the surfaces of underhood and underbody components. It also gives opportunity to specify the type of coating material to be used.

1.2 Symbols. Not applicable.

1.3 Typical Applications. These coatings are typically used on chassis components, as well as other underhood and underbody components.

1.4 Remarks. This specification applies in two different ways. Either it can be used for paint materials that have been approved to other appropriate GM specifications (e.g., 9900000; these materials will show as APPROVED in the GM MATSPEC database), or it is applicable for materials that have not been approved by GM. Depending on the material qualification status, the Xs in Table A1 indicate the tests to be performed.

The usage of non-approved paint materials is only permitted through the calendar year 2011.

Seven "types" of paint are covered by this specification: Types A and B are both cathodic e-coats in two different thickness ranges. Type C is dip primer other than cathodic e-coat. Type D is powder coating. If Type E is specified, the applicator is free to choose Type A, B, C, or D, but they must stay with this choice. Type F is to be further specified on the drawing using notes or a paint material specification. Type G is solvent or water-based spray-applied paint.

2 References

Note: Only the latest approved standards are applicable unless otherwise specified.

2.1 External Standards/Specifications.

None

2.2 GM Standards/Specifications.

9904120	GMW14700
9904123	GMW14729
EMS 9309574	GMW14829
GM6094M	GMW14872

GMEL0004
GMW3001
GMW3059
GMW3206
GMW14333

GMW15282
GMW15357
GMW15487
GMW15891

2.3 Additional References. Not applicable.

3 Requirements

3.1 Requirements on Test Specimens. Not applicable.

3.2 General.

3.2.1 Coatings shall be free of Chrome VI.

3.2.2 Chrome VI used as an adhesion promoter is impermeable.

3.2.3 Post-treatment, if performed, shall be Chrome VI free.

3.3 Coating Thickness. If parts have cavities that are prone to corrosion (e.g., cradle), a coating type must be selected which is able to protect the cavity areas with a minimum coating thickness of 10 µm. Types A, B, and C are usually chosen for this type of application, or Type F is called out along with a specific paint material specification.

3.3.1 Type A. Cathodic e-coat, coating thickness: 16 to 22 µm.

3.3.2 Type B. Cathodic e-coat, coating thickness: 23 to 35 µm.

3.3.3 Type C. Dip primer (except cathodic e-coat), coating thickness: ≥ 30 µm.

3.3.4 Type D. Powder coating, coating thickness: ≥ 40 µm.

3.3.5 Type E. Coating thickness to be as specified for Type A, B, C or D, whichever has been chosen for the application.

3.3.6 Type F. For this type the thickness shall be defined on the drawing or in the specified paint material standard.

3.3.7 Type G. Spray paint (e.g., electrostatic application of solvent based paints or water based paints). Coating thickness: ≥ 40 µm.

3.4 Cross Hatch Test. Paint adhesion shall be tested according to GMW14829 – Rating 0 or 1 at

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