

ORIGINATOR:

**Randy Xu**

CHECKED:

**Wenxin Han**

APPROVAL:



550 Xin Yuan South Road  
Nan Hui District  
Shanghai P.R. China 201306  
PHONE: 86 21 6118 4800

SHEET

**1 OF 3**

**ENGINEERING SPECIFICATIONS OR INSTRUCTIONS**

**ESN-0066**

REV:

**01**

TITLE:

## **CHINA TT PARTS PAINT PROCEDURE – AXALTA PAINT**

### **CHINA TT PARTS PAINT PROCEDURE**

#### **SURFACE PREPARATION**

1. Clean all surfaces with Axalta cleaning solvent IM9T-571, wipe wet and dry.
2. Abrasive blast all surfaces using an abrasive blast along with compressed air. Use blast material: S-230 steel shot. 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. Keep the treated parts in dry environment, apply primer ASAP.

#### **PRIMER 1**

5. Use Axalta Primer 825P68121, and stir evenly.
6. Prepare 825P68121 epoxy primer, VF-68619 hardener, VT600 thinner.
7. Mix ratio, 825P68121:VF-68619:VT600=5:1:5-10% (by weight) (thinner ratio may need verify if the weather change a lot).
8. Mix the primer evenly, suggested application parameter: viscosity: 28-30S, DIN 4 cup, 20 °C; DFT 50-60 μm with 1-2 wet coat; flash 10-15min between coat; air dry(25°C) for more than 12h.
9. Spray nozzle 1.7-2.0mm · pressure 3-5bar, distance 15-25mm, vertical, speed 900-1200m, 50%-66% overcoat.
10. Sanding, avoid sand too hard to reveal any metal.
11. Blow clean removing any dust or other material from surface using compressed air, clean with Axalta IM9T-571.
12. Wipe all surfaces with dry cloth, in preparation for next primer.

#### **PRIMER 2**

13. Repeat process 10-12 to apply the second layer primer.

#### **TOPCOAT**

14. Use Axalta topcoat TF620, and stir evenly.
15. Prepare TF620 topcoat, VF-710 hardener, VT603/605/607 thinner.
16. Mix ratio: TF620: VF-710 :VT603/605/607=4:1:10-20% (by weight) (thinner ratio may need verify if the weather change a lot).
17. Mix the topcoat evenly, suggested application parameter: viscosity: 18-22S, DIN 4 cup, 20 °C; DFT 40-60 μm with 2 wet coat; flash 10-15min between coat; air dry(25°C) for more than 12h.

ORIGINATOR:

Randy Xu

CHECKED:

Wenxin Han

APPROVAL:



SHEET

2 OF 3

ENGINEERING SPECIFICATIONS OR INSTRUCTIONS

ESN- 0066

TITLE:

## CHINA TT PARTS PAINT PROCEDURE – AXALTA PAINT

18. Spray nozzle 1.7mm, pressure 3-5bar, distance 15-25mm, vertical, speed 900-1200mm, 50%-66% overcoat.

### Materials required:

Type	Name
Cleaning Solvent	IM9T-571
Epoxy Primer	825P68121
Topcoat	TF620

## 码头牵引车零部件涂装工艺流程

### 表面处理

1. 用艾仕得 IM9T-571 清洁剂将需要喷涂的金属表面清洗干净。保持更换擦拭布和干湿两种擦拭布同时使用，要避免脏的擦拭布造成二次污染。
2. 对工件表面进行喷丸处理，使用喷丸材料如下 S-230 钢丸。清除所有的泥土，灰尘，磨粒，铁锈达到近白金属状态，部件表面具有灰白的金属色彩。
3. 用压缩空气吹干净表面的灰尘及其它杂物。
4. 冲砂完成的工件需放置在干燥的环境中，并尽快喷涂底漆。

### 底漆 1 喷涂

5. 将艾仕得 825P68121 环氧底漆充分搅拌均匀。
6. 环氧底漆为 825P68121 固化剂为 VF-68619 稀释剂为 VT600。
7. 底漆的配比重量比 5: 1: 5-10% (根据不同的温度添加不同的稀释剂及用量)。
8. 调配底漆 (搅拌 5 分钟后用粘度杯进行检测) DLN4 杯, 粘度约为 28-30 秒 (20℃)。喷涂膜厚 50-60um, 喷涂 1-2 遍每遍约 20-30um, 层间闪干 10-15 分钟。自干 25℃ 12 小时。
9. 喷枪口径 1.7-2.0mm, 气压 3-5bar, 距离 15-25mm, 角度 90℃, 速度 900-1200mm, 重叠 1/2 或 2/3。
10. 打磨环氧底漆时不允许见到金属表面。
11. 用压缩空气将打磨面的灰尘吹干净, 用艾仕得 IM9T-571 清洁剂将需要喷涂的金属表面清洗干净。保持更换擦拭布和干湿两种擦拭布同时使用, 要避免脏的擦拭布造成二次污染。
12. 粘尘布擦拭工件, 准备下道工序。

ORIGINATOR:

**Randy Xu**

CHECKED:

**Wenxin Han**

APPROVAL:



SHEET

**3 OF 3****ENGINEERING SPECIFICATIONS OR INSTRUCTIONS****ESN- 0066**

TITLE:

**CHINA TT PARTS PAINT PROCEDURE – AXALTA PAINT****底漆 2 喷涂**

13. 重复步骤 10-12, 喷涂第二道底漆。

**面漆喷涂**

14. 将艾仕得 TF620 双组份面漆充分搅拌均匀。

15. 面漆为 TF620, 固化剂为 VH710, 稀释剂为 VT603, VT605, VT607。

16. 面漆的配比重量比 4: 1: 10-20% (根据不同的温度添加不同的稀释剂及用量)。

17. 调配面漆 (搅拌 5 分钟后用粘度杯进行检测) DLN4 杯, 粘度为 18-22 秒 (20℃)。喷涂膜厚 40-60um, 喷涂 2 遍  
每遍约 20-30um, 层间闪干 10-15 分钟。自干 25℃ 12 小时。

18. 喷枪口径 1.7mm, 气压 3-5bar, 距离 15-25mm, 角度 90℃, 速度 900-1200mm, 重叠 1/2 或 2/3。

**材料清单:**

分类	牌号
清洁剂	IM9T-571
环氧底漆	825P68121
面漆	TF620