

**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., 99XXXXX; these materials will show as APPROVED in the GM MATS-PC database), or it is applicable for materials that have not been approved by GM. Depending on the material qualification status, the X's 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.

9984120	GMW14700
9984123	GMW14729
EMS 9309574	GMW14829
GM6094M	GMW14872

GME L0004
GMW3001
GMW3059
GMW3286
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 impermissible.

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., cracks), 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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Table of Contents Worldwide Material Specification Engineering Gmw14671

1. Understanding the eBook Worldwide Material Specification Engineering Gmw14671
 - The Rise of Digital Reading Worldwide Material Specification Engineering Gmw14671
 - Advantages of eBooks Over Traditional Books
2. Identifying Worldwide Material Specification Engineering Gmw14671
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Worldwide Material Specification Engineering Gmw14671
 - User-Friendly Interface
4. Exploring eBook Recommendations from Worldwide Material Specification Engineering Gmw14671
 - Personalized Recommendations
 - Worldwide Material Specification Engineering Gmw14671 User Reviews and Ratings
 - Worldwide Material Specification Engineering Gmw14671 and Bestseller Lists
5. Accessing Worldwide Material Specification Engineering Gmw14671 Free and Paid eBooks

- Worldwide Material Specification Engineering Gmw14671 Public Domain eBooks
 - Worldwide Material Specification Engineering Gmw14671 eBook Subscription Services
 - Worldwide Material Specification Engineering Gmw14671 Budget-Friendly Options
6. Navigating Worldwide Material Specification Engineering Gmw14671 eBook Formats
 - ePub, PDF, MOBI, and More
 - Worldwide Material Specification Engineering Gmw14671 Compatibility with Devices
 - Worldwide Material Specification Engineering Gmw14671 Enhanced eBook Features
 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Worldwide Material Specification Engineering Gmw14671
 - Highlighting and Note-Taking Worldwide Material Specification Engineering Gmw14671
 - Interactive Elements Worldwide Material Specification Engineering Gmw14671
 8. Staying Engaged with Worldwide Material Specification Engineering Gmw14671
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Worldwide Material Specification Engineering Gmw14671
 9. Balancing eBooks and Physical Books Worldwide Material Specification Engineering Gmw14671
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Worldwide Material Specification Engineering Gmw14671
 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
 11. Cultivating a Reading Routine Worldwide Material Specification Engineering Gmw14671
 - Setting Reading Goals Worldwide Material Specification Engineering Gmw14671
 - Carving Out Dedicated Reading Time
 12. Sourcing Reliable Information of Worldwide Material Specification Engineering Gmw14671
 - Fact-Checking eBook Content of Worldwide Material Specification Engineering Gmw14671
 - Distinguishing Credible Sources
 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development

- Exploring Educational eBooks
14. Embracing eBook Trends
- Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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