

ORIGINATOR:

**GJL 6-1-07**

CHECKED:



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SHEET

**1** OF **1**

APPROVAL:

**ENGINEERING SPECIFICATIONS OR INSTRUCTIONS**

**ESN-0050**

REV: **A**

TITLE:

## **CAB DECK PAINT PROCEDURE**

### **CAB DECK PAINT PROCESS**

#### **Pretreatment and Surface Prep of Loose Parts Before Assembly**

- 1. All metal edges (except material thinner than 14 gauge and hemmed edges) will be deburred, and all scale and laser scale removed by a mechanical abrasion process (grinding, sanding, etc – chemical removal is not acceptable.)**
- 2. Clean and treat metal, minimum 4 stage process alkaline degrease, phosphate, and seal rinse.**
  - Step 1: EnChem SteelPrep 400**
  - Step 2: Soft water rinse (if automated washer is used)**
  - Step 3: EnChem SteelPrep 300**
  - Step 4 : Soft water rinse or EnChem UltraPrep 4000 (2% concentration)**
- 3. Application of DuPont Colar Epoxy primer per manufacturer's recommendations.**
  - DuPont P/N: 825P32760 and FGP32765 activator**
  - Exception: Stainless Steel AND Aluminum substrates.**
    - Step 1: MetaLok 235S/236S**
    - Step 2: 825P32760/FGP32765**

#### **Assemble Deck as indicated on drawing**

- 1. Exception – The mirror post is to have all surfaces primed and top coated before installation.**
- 2. CKD/SKD orders are to have the Hood Channel primed and top coated before installation.**

#### **Top Coat**

- 1. Sand with 320 grit. Any sand-through to be spot primed – if smaller than 3" diameter, use Nason 491-40, if larger use 825P32760.**
- 2. Top coat with DuPont Imron 5000 Single Stage top coat per manufacturer's recommended process.**