

TMC SPECIFICATION

NO. s-521

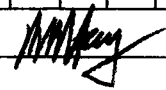
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SHEET 1

OF 2

TITLE:

Grey Textured Vinyl

GREY TEXTURED VINYL SPECIFICATION

TMC SPECIFICATION

NO. S-521

REV: 0

COMPILED:

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SHEET 2 OF 2

TITLE: Grey Textured Vinyl

PURPOSE:

The purpose of this specification is to outline the materials and method of applying Grey Vinyl Coritex.

MATERIALS REQUIRED:

#880 Hartite Metal Etch Primer	Hartin Corp.
#88 Hartite Reducer	Hartin Corp.
Grey Vinyl Coritex 63K-L10744	Duralac Corp.
H858 Reducer	Duralac Corp.
Grey Touch Up Lacquer NBW-31A	Duralac Corp.

SURFACE PREPARATION:

- 1) Clean surfaces of all oil, grease, and foreign matter by vapor degreasing using Trichlorethylene.
- 2) Wipe surfaces thoroughly with a clean rag - the wiper to wear white gloves to eliminate finger marks.
- 3) Apply one coat of Hartite Metal Etch Primer to all surfaces by spraying.
- 4) Bake: 10 minutes at 300 F.

METHOD OF APPLICATION:

- 1) Apply by spraying one uniform coat of Coritex to all surfaces.
- 2) Air dry for 10 minutes.
- 3) Reduce air pressure to 15 lbs in the tank and adjust spray gun fluid nozzle to desired pattern of texture.
- 4) Apply texture uniformly over outside surfaces and edges.
- 5) Air dry for 10 minutes and bake 45 minutes at 300 F.

OBSERVATIONAL STANDARD:

- 1) Munsell Notation: 3B4.53/0.35+, 17844
- 2) Size of the TMC approved panel should not be less than 12" x 12". This is necessary to insure proper comparison to finished parts meeting the texture pattern and gloss requirements.
- 3) No bubbling or cracking is permissible on the textured surfaces.

TOUCH UP:

- 1) May be applied by artist brush to very small areas only.

NOTE: Color Matches S115

