



Standard Specification for Performance of Enameling System, Baking, Metal Joiner Work and Furniture¹

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1. Scope

1.1 This specification covers the performance of a baking primer and enamel on metal for use on fabricated metal products, including marine furniture and joiner work.

1.2 The values stated in inch-pound units are to be regarded as standard. The metric (SI) units, given in parentheses, are for information only.

1.3 Painting facilities shall comply with all applicable Federal and State regulations regarding emissions and waste disposal.

1.4 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 ASTM Standards:²

A1008/A1008M Specification for Steel, Sheet, Cold-Rolled, Carbon, Structural, High-Strength Low-Alloy, High-Strength Low-Alloy with Improved Formability, Solution Hardened, and Bake Hardenable

A653/A653M Specification for Steel Sheet, Zinc-Coated (Galvanized) or Zinc-Iron Alloy-Coated (Galvannealed) by the Hot-Dip Process

B117 Practice for Operating Salt Spray (Fog) Apparatus

B209 Specification for Aluminum and Aluminum-Alloy Sheet and Plate

D522 Test Methods for Mandrel Bend Test of Attached Organic Coatings

D1186 Test Methods for Nondestructive Measurement of Dry Film Thickness of Nonmagnetic Coatings Applied to

a Ferrous Base (Withdrawn 2006)³

D1400 Test Method for Nondestructive Measurement of Dry Film Thickness of Nonconductive Coatings Applied to a Nonferrous Metal Base (Withdrawn 2006)³

D3359 Test Methods for Measuring Adhesion by Tape Test

D3363 Test Method for Film Hardness by Pencil Test

2.2 *American Institute of Steel Construction Manual*:⁴

AISC Wire and Sheet Metal Gages Equivalent Thickness in Decimals of an Inch, U.S. Standard Gauge (USSG) for Uncoated Hot and Cold Rolled Sheets and Galvanized Sheet Gage (GSG) for Hot-Dipped Zinc Coated Sheets

2.3 *Code of Federal Regulations*:⁵

40 CFR 60 Subpart EE—Standard of Performance for Surface Coating of Metal Furniture

3. Terminology

3.1 Definitions of Terms Specific to This Standard:

3.1.1 *air dry touch-up enamel*—an air drying enamel that matches the factory applied enamel in color and gloss and is compatible with it.

3.1.2 *baking finish*—an enamel that requires baking at temperatures above 150°F (65°C) for the development of desired properties.

3.1.3 *blister*—an enclosed raised spot on the paint surface caused by moisture or solvent trapped under the surface.

3.1.4 *cleaning*—the first phase of the metal pretreatment prior to painting.

3.1.5 *cure*—to condense or polymerize a material by heating, resulting in the full development of desired properties.

3.1.6 *degreasing*—to remove grease from a surface using chemical solvent, steam or other method. See *cleaning*.

3.1.7 *dry film thickness (DFT)*—the actual thickness of the cured paint system. It is measured in mils or thousandths of an inch, that is, 0.001 in. (25.4 μm).

¹ This specification is under the jurisdiction of ASTM Committee F25 on Ships and Marine Technology and is the direct responsibility of Subcommittee F25.01 on Structures.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

³ The last approved version of this historical standard is referenced on www.astm.org.

⁴ Available from American Institute of Steel Construction (AISC), One E. Wacker Dr., Suite 700, Chicago, IL 60601-2001, <http://www.aisc.org>.

⁵ Available from U.S. Government Printing Office Superintendent of Documents, 732 N. Capitol St., NW, Mail Stop: SDE, Washington, DC 20401, <http://www.access.gpo.gov>.