

PRODUCTS FOR BONDING, SEALING, ANTI-CHIPPING, ANTIABRASION, ANTICORROSION, TEMPORARY PROTECTION FUNCTIONS – LABORATORY STOVING CYCLES

Page 1/3

NO USE RESTRICTION*This is a translation, the French original shall be used in all cases of litigation**Date of translation : 12/12/2002***CONTENTS**

1. OBJECT	1
2. EXPRESSION ON DOCUMENTS	1
3. IDENTIFICATION AND DEFINITION	2
4. RECORDS AND REFERENCE DOCUMENTS	3
4.1. RECORDS	3
4.2. REFERENCE DOCUMENTS	3
4.3. EQUIVALENT TO :	3
4.4. CONFORMS TO :	3
4.5. KEY WORDS	3

1. OBJECT

This norme defines the types of stoving cycles in low bake, high bake, under stoving and over stoving to be used in laboratory for product design.

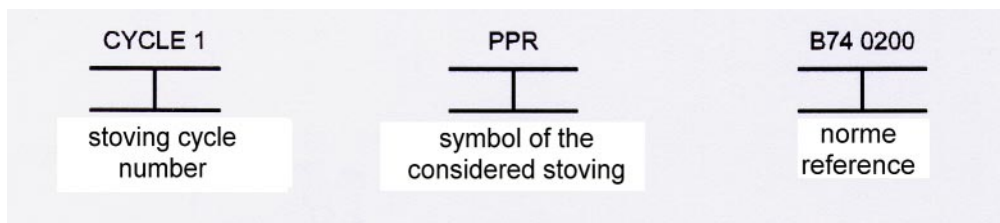
It applies to products used for bonding, sealing, anti-chipping, anti-abrasion, anti-corrosion and temporary protection functions whether this be in manufacture or in retouch.

This document must be accompanied by méthode d'essai D55 1171 which defines the calibration of laboratory ovens.

2. EXPRESSION ON DOCUMENTS

The cycle is defined on the document by the cycle type identification number, the symbol of the considered stoving and by the reference of this norme.

Example :



3. IDENTIFICATION AND DEFINITION

The table below gives the conventional reference shown as one figured number for the various types of stoving cycles as well as the times, temperatures and symbols of the considered stoving. Values in brackets represent the stoving time allocation; the first corresponding to the rise to temperature, the second to the duration at constant temperature

CYCLE REFERENCES		CYCLE 1		CYCLE 2		CYCLE 3		CYCLE 4	
Characteristics		Low bake		High bake		Under stoving		Over stoving	
		min	°C	min	°C	min	°C	min	°C
CONSIDERED STOVINGS	Products deposited before recoverable primer paint (PPR)	25 (10 + 15)	170	60 (10 + 50)	200	25 (10 + 15)	160	60 (10 + 50)	220
	Pregelling simulation (PRE)	12 (7 + 5)	140	12 (7 + 5)	160	-	-	-	-
	Products deposited before low temperature intermediate paint (140°C) (PIB)	30 (10 + 20)	140	60 (10 + 50)	160	-	-	-	-
	Products deposited before high temperature intermediate paint (170°C) (PIH)	17 (10 + 7)	160	60 (10 + 50)	180	-	-	-	-
	Products deposited before finish painting (PF)	25 (10 + 15)	130	60 (10 + 50)	160	25 (10 + 15)	125	15 (10 + 5)	190
	Retouch (RET)	25 (10 + 15)	130	25 (10 + 15)	150	25 (10 + 15)	110	-	-

Note : A dash means that there is no cycle.

4. RECORDS AND REFERENCE DOCUMENTS

4.1. RECORDS

4.1.1. CREATION

- OR : 01/01/1985 – CREATION OF THE NORME.

4.1.2. SUBJECT OF THE MODIFICATION

- B : 25/02/1997 – INTRODUCED INTO IDEM (*French only*).
- C : 05/12/1997 – LONG TITLE ADJUSTED TO 132 CHARACTERS FOR GEODE.

4.2 REFERENCE DOCUMENTS

4.2.1. PSA DOCUMENTS

4.2.1.1 Normes

D55 1171.

4.2.1.2. Others

4.2.2. EXTERNAL DOCUMENTS

4.3. EQUIVALENT TO :

4.4. CONFORMS TO :

4.5. KEY-WORDS