



Paint Specification

*Proprietary
Need-To-Know*

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PAINT SPECIFICATION SUN MICROSYSTEMS

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1. Purpose

This specification defines requirements for low-bake and high-bake water base finishes (paint) on metallic and non-metallic surfaces.

2. Scope

This specification includes process, achieved finish quality, and approved sources/material for domestic and international applications only.

3. Responsibility

The Sun Supplier Engineering Department has the responsibility for approval of all paint and sources, control of these materials and their application, and for developing and maintaining inspection procedures and records.

4. Applicable Documents

The following documents shall form a part of this specification.

4.1 American Society for Testing and Materials (ASTM).

- (a) B117 Salt Spray
- (b) D522 Elongation
- (c) D2247 Humidity
- (d) D2794 Impact Resistance
- (e) D3359 Adhesion
- (f) D3363 Film Hardness by Pencil Test

4.2 Federal Test method Standard No. 141 (FTMS 141)

- (a) 6081 Spotting Resistance
- (b) 6151 Accelerated Weathering
- (c) 6192 Abrasion Resistance

5. Physical Performance and Test Methods (Dry State).

5.1 Abrasion Resistance (FTMS 141; Method 6192)

- 5.1.1 The finish coating shall resist abrasion when tested with a Taber Abrasher, using CS-17 Calibrase Wheels and 1000 grams load with a maximum of 90 milligrams weight loss per 1000 cycles.

5.2 Corrosion Resistance (Salt Spray; ASTM B117)

- 5.2.1 The finish coating shall exhibit no degradation when tested for 96 hours.

5.3 Chemical Resistance (Spotting Resistance; FTMS 141 Method 6081)

- 5.3.1 The finish coating shall exhibit no degradation such as blistering, softening, or swelling when exposed to:

Water	Ethyl alcohol
Freon TF	Isopropanol
Hot Coffee	Industrial grade Enzyme
Cola beverage	Chlorine
Phosphate based cleaners	

5.3.2 The exposure time shall be 24 hours. Specular gloss shall not change more than 10%. Change in color shall not be in excess of specified tolerance for each individual color. (Ref. color spec)

5.4 Accelerated Weathering Resistance (FTMS 141 Method 6151)

5.4.1 The finish coating shall exhibit no degradation when exposed to accelerated weathering.

5.5 Adhesion (ASTM D3359 Method A)

5.5.1 The finish coating shall meet classification 3B when tested with the above standard.

5.6 Humidity Resistance (ASTM D2247)

5.6.1 The cured coating shall exhibit no appearance or physical degradation after continuous exposure for 96 hours (38°C at 100% humidity).

5.7 Heat Resistance

5.7.1 The cured coating shall exhibit no appearance of physical degradation after exposure to 65.5°C (150°F) for 1/2 hour.

5.8 Flexibility (ASTM D522)

5.8.1 A coated specimen shall pass the .25 inch conical mendrel test.

5.9 Impact Resistance, Extrusion (Reverse; ASTM D2794)

5.9.1 The applied coating shall exhibit no cracking when subjected to 20 in. lb. impact (extrusion).

5.10 Pencil Hardness Test (ASTM D3363)

5.10.1 The cured coating shall pass H on pencil hardness test.

6. Wet State Properties**6.1 Viscosity (ASTM D-2196-81)**

6.1.1 5500+/- 500 CPS #4 Spindle @ 20 rpm -77

6.2 Density in Weight per Gallon

6.2.1 9.75 lbs. +/- .10

6.3 Solids by Weight

6.3.1 46% +/- 1%

6.4 Solids by Volume

6.4.1 36% +/- 1%

6.5 Theoretical Hiding

6.5.1 575 Sq. Ft./Gallon @ 1.0 mils-no loss

6.6 Volatile Organic Compounds

6.6.1 2.2 Approximately lbs./gal.

7.0 VOC Rating

7.1 ALL paint supplied to this specification must be certified to contain less than 2.8 lbs. of solvent (minus water) per gallon of paint.

8.0 Sources/Approved Materials/Vendors

Color	Manufacturer	Sun P/N	Mfg. P/N
Sun Accent Grey	Sherwin&Williams	950-1307-xx	F83A1025
Sun Lt. Grey	Sherwin&Williams	950-1011-xx	F83A1022
Sun Med. Grey	Sherwin&Williams	950-1304-xx	F83A1023
Sun Charcoal Grey	Sherwin&Williams	950-1010-xx	F83A1024
Sun Lt. Purple	Sherwin&Williams	950-1305-xx	F83R1001
Sun Med. Purple	Sherwin&Williams	950-1306-xx	F83R1000
Sun Black	Sherwin&Williams	950-1308-xx	F73B630

8.1 High Bake Paint KEM AQUA 1700T

Color	Manufacturer	Sun P/N	Mfg. P/N
Sun Med. Purple	Sherwin&Williams	950-1306-xx	F83-R-1006
Sun Lt. Purple	Sherwin&Williams	950-1305-xx	F83-R-1005
Sun Accent Grey	Sherwin&Williams	950-1307-xx	F83-A-1100
Sun Light Grey	Sherwin&Williams	950-1011-xx	F83-A-1101
Sun Med. Grey	Sherwin&Williams	950-1304-xx	F83-A-1102
Sun Charcoal Grey	Sherwin&Williams	950-1010-xx	F83-A-1103
Sun Black	Sherwin&Williams	950-1308-xx	F83-B-570