	<b>WORK INSTRUCTION</b>  <b>Painting Process</b>	
REVISION: 01	PROCEDURE NO.: WI-8.2.4.21	DATE EFFECTIVE: 06/09/14

Once parts have been brought to the paint booth area, the following steps must be taken:

1. A respirator mask must be worn by worker at all times.
2. Must verify expiration date of paint prior to usage. If it is ok to use, it must be prepared according to lot size by using the ratio of 1:1 (1 part paint and 1 part lacquer thinner).
3. Mixture must be stirred well and poured onto canister through a strainer.
4. Paint gun should be clean before it is assembled to the canister.
5. Parts/surfaces to be painted must be clean and free of dust or oil.
6. Parts/surfaces that are not to be painted must be covered with masking tape or by the use of special template for that part if available.
7. For proper spraying the paint gun has to be adjusted.
8. The air pressure should be adjusted to be between 60 and 90 psi.
9. Exhaust system must be turned on at this point.
10. A small area of the part is to be painted to test/check the color consistency and thickness of the paint.
11. There are no special settings needed for moisture or paint density needed for this painting operation.
12. A very light coat of paint is to be applied to the parts.
13. Imperfections on the painted finish, such as paint running or scratches on surface from handling are acceptable. Paint is only there to give a uniform appearance to the parts and is purely a cosmetic detail.



**WORK INSTRUCTION**

**Painting Process**

REVISION: 01

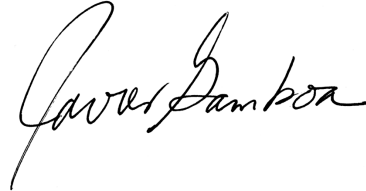
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**REVISION HISTORY**

REVISION LEVEL	DATE OF REVISION	SECTIONS	DESCRIPTION OF CHANGE
00	05/22/09	All	Initial release
01	06/09/14	Step 2	Added verification of expiration date comment

**AUTHORIZATION**

POSITION	HELD BY	AUTHORIZATION SIGNATURE OR INITIALS
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