



INTERNATIONAL MARKETING, INC. TECHNICAL BULLETIN

SUBJECT: Cold Weather Paint Bulletin

DATE: November 1, 2002

In order to keep the Wheel/Rim Refinishing System running smoothly through the winter, the following procedures will be necessary.

Storage area for the paint and paint production for wheels and rims should be maintained at ambient temperatures.

BEFORE REFINISHING

- Before the wheels are processed, store at 65 degrees F (19 degrees C) to 75 degrees F (24 degrees C) for 12 hours.
 - The temperature of the wheels before and during the refinishing process is critical for the proper application and cure of waterborne paint.

AFTER REFINISHING

- After the wheels are painted, store at 65 degrees F (19 degrees C) to 75 degrees F (24 degrees C) for 48 hours for complete curing to take place.
 - If the painted wheels are exposed to cold temperatures within 48 hours, it will inhibit the curing process.

STORAGE OF WATERBORNE (SHOWCASE PAINT)

- Waterborne compounds should be protected from freezing. Recommended storage temperature is 65 degrees F (19 degrees C) to 75 degrees F (24 degrees C).
- Before it is applied to the wheel, it is recommended that the waterborne paint be between 65 degrees F (19 degrees C) to 90 degrees F (35 degrees C).

WHEEL SURFACE TEMPERATURE

- Wheel surface temperature after shot blasting is critical so as to allow proper curing of waterborne paint.
- Wheel surface temperature should be 130 degrees F (55 degrees C) +/-10.

SHIPPING INFORMATION

- In below-freezing temperatures, all Showcase orders will be shipped via YELLOW Freight in heated trailers.
 - Please advise your customers that orders may take a little longer to be delivered due to the need of heated trailers. Rush orders will incur additional freight charges.

3M™ Freeze Watch™ Indicators 9805FW

The patented design of Freeze Watch indicators consists of a highly sensitive indicating liquid inside a specially designed ampule. When exposed to freezing temperatures, the ampule fractures, releasing a liquid. The liquid irreversibly stains a paper behind the ampule, providing a warning that product quality testing should be performed. Freeze Watch indicators are available at two temperature levels, -4°C (25°F) and 0°C (32°F), to accommodate differing product sensitivities. Placed directly on secondary shipper boxes of temperature-sensitive products during shipment and storage, the indicators provide a reliable measure of temperature exposure.



Upon delivery of the paint, if the “Freeze Indicator” is broken (showing a blackened blotter) but the pails are not frozen and/or broken from freezing, please follow the following directions (remember the paint has been exposed to freezing temperatures but may not necessarily be frozen):

1. Indicate “Broken Freeze Indicator” on the incoming Bill of Lading, making the freight carrier aware that the paint could possibly be frozen.
2. Call IMI (800-233-7086) to notify of the broken Freeze Indicator.
3. Place the paint in your warm storage area to bring the paint to (a warmer) room temperature (70-78 degrees) for 24 hours.
4. Take a pail from the load, make sure it is now room temperature (approximately 70-78 degrees) and prepare the paint for spraying – observe the paint for any inability to stay suspended or lumpiness
5. Spray out and observe the paint for separation, tip plugging, poor coverage or drying problems.
6. If these problems exist, call IMI with the production batch number to start the RMA process.

Questions regarding the above technical bulletin may be directed to:

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