



2. Any equipment that discharges anything at all into the environment such as steam, mist, dust, odors, etc., must be approved by Plant and/or Corporate Safety Personnel.
3. The Supplier must provide MSDS information sufficient to obtain approval for use of any regulated substances as specified in the Safety, Health and Noise Specifications.

## **XI. Paint**

### **A. Paint Specifications (As required by Cummins Architectural Specifications)**

1. All machine tools must be painted with Cummins' standard equipment paint. Sherwin Williams CDG-96E is a two part epoxy enamel and was selected for durability and resistance to chemicals and cutting fluids.
2. A deviation from CDG-96E should only be considered in special applications such as high temperature equipment (e.g., heat treating furnaces), or mild manufacturing environments not subject to chemicals, cutting fluids, etc. (Note: CDG-96E has a dry heat resistance rating of 250°F).
3. Any deviation from the paint specification must follow the normal deviation and change process, including documentation by the Project Manager and approval by the Plant Technical Leader.
4. When a Project Manager deviates from the paint chemistry specification, the paint must exactly match the Cummins color specification and be compared to a certified color chip.
5. Before approving a color match with a different chemistry, the Project Manager should review the type of paint proposed and seek technical advice from the Corporate Paint Committee Chairman (contact Corporate Manufacturing Applications to identify the person who currently serves in this capacity).
6. Sherwin Williams is the sole approved supplier of Cummins equipment paint, and each Sherwin Williams dealer should have a complete paint schedule sheet. For machine tools, CDG-96E (for Cummins Diesel Gray) is the reference number.
7. Sherwin Williams number CDG-96E is the order number for Cummins Diesel Gray. Sherwin Williams number CDG-96 is a single-component industrial enamel for color matching non-machine surfaces, only.
8. In the event a Sherwin Williams dealer does not have the Cummins schedule sheet, the specifications shown on the following page may be used:

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Finish Top Coat: Cummins Diesel Gray CDG-96E  
Sherwin Williams Tile Clad II  
Epoxy - Sherwin Williams #B62-WZ101

Color Mix: B1 (black) 15/32 + 1/64 + 1/128  
N1 (raw umber) 17/32 + 1/64  
R2 (maroon) 3/32 + 1/64

Recoatable

Epoxy Primer: Epoxy - Sherwin Williams #B67-H5 (Part G) 630-4240  
Hardener - Sherwin Williams #B67-V5 (Part H) 630-4265

9. For distant suppliers, the Project Manager may find it more expedient to provide all needed paint. Note that paint may not be air freighted, and appropriate lead time should be planned in this event. CDG-96E can be applied directly over bare metal or other hard epoxy finishes without a primer.
10. Due to the strong adhesive characteristics of this paint, when covering an existing paint finish, the Sherwin Williams matched epoxy primer must be used to prevent paint lifting.
11. When the machine is already finished in an OEM color, a paint specialist must be consulted to determine if recoating is acceptable or if the finish must be stripped to bare metal.
12. For recoating, the specialist must prescribe the best preparation and application method. This information, and any cost charges to Cummins, must be submitted to the Project Manager for approval prior to performance.

#### B. Paint Color

1. The Supplier is responsible for proper paint color matching and should not rely solely on the paint supplier or mix formula. A paint chip must be made and compared to a certified color chip, available from the Project Manager.
2. The Supplier should procure a single batch of paint sufficient to paint all machines and components as a safeguard against small batch-to-batch mix variations.
3. If the Supplier has subcontracted machines or components (e.g., a systems integrator), the principle Supplier should procure one batch of paint and provide appropriate amounts to all subcontractors.
4. The Supplier must provide a machine tool which conforms to OSHA paint-coding requirements (See OSHA Standard 1910.144). Color-coding that normally would be visible must be approved by Project Manager as to area coded.

## XII. Ventilation and Containment

- A. For equipment that emits toxic or unpleasant vapors, odors, coolants, dust, gas fumes, machining fires, etc., as byproducts of the process, containment systems must be included in the quotation.

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When machine containment systems must be connected to existing factory ventilation, appropriate information must be provided with the quotation to allow Cummins Facility Engineers to ensure readiness of the plant systems.

- B. It is the responsibility of the Project Manager to ensure that any required construction or operating permits for air pollution sources or control devices are obtained prior to installation or operation of those sources or devices. The Supplier must provide whatever technical information or data necessary to support the accurate preparation of permit applications. The Supplier must provide estimated emission factors for all hazardous chemicals utilized in the operation or maintenance of the equipment, in compliance with the manufacturer's recommendation.
- C. All containment shields, guards and access doors must be supplied with guard hinges that are not easily removable.

### **XIII. Foundation and Pit Recommendations**

- A. The Supplier must indicate the dimension from the bottom of the machine base to an identifiable point on the piece part and indicate the direction of index or transfer of the part on the front and side elevation drawings.
- B. Machine mounting should utilize vibration absorbing materials or components.
- C. The Supplier will submit, by the date specified by the Project Manager, certified drawings for all foundation and pit requirements. The drawings must include all dimensional locators for the pit and equipment and structural details, if required.
- D. The Supplier must provide minimum foundation requirements and machine weights.

### **XIV. Documentation**

- A. All documentation, must be written in English. All foreign words must have an English translation supplied, preferably in the vicinity of the original text.
- B. All equipment supplied must be accompanied by three (3) copies of maintenance and service documentation. This documentation must include the following, in formats acceptable to the purchasing plant's systems:
  - 1. All pneumatic diagrams and layouts.
  - 2. All electrical and electronic diagrams and layouts.
  - 3. All lubrication diagrams and layouts.
  - 4. All hydraulic diagrams and layouts.
  - 5. All coolant diagrams and layouts.

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